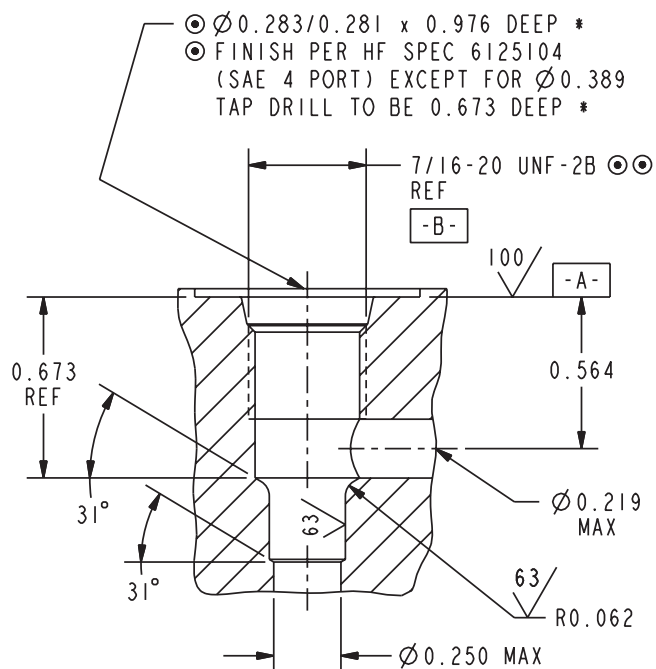


Series 04 Cartridge Cavities

VC04-2



NOTES:

- FEATURES (EXCEPT FOR PILOT DRILL, CROSS DRILL AND SAE 4 PORT) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.

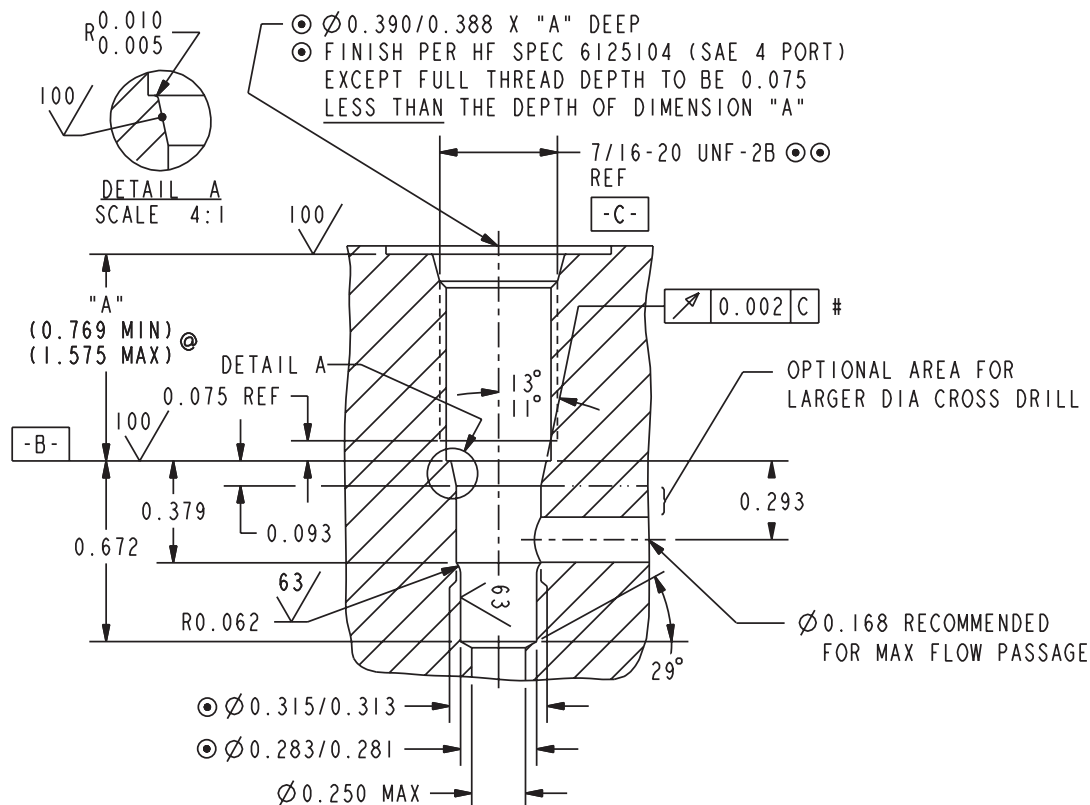
◎ -	<table><tr><td></td><td>0.001</td><td>A</td></tr><tr><td></td><td>0.002</td><td>B</td></tr></table>		0.001	A		0.002	B	◎ ◎ -	<table><tr><td></td><td>0.001</td><td>A</td></tr><tr><td></td><td>0.0009</td><td>(PITCH DIA)</td></tr></table>		0.001	A		0.0009	(PITCH DIA)
	0.001	A													
	0.002	B													
	0.001	A													
	0.0009	(PITCH DIA)													

* - DEPTHS ARE FROM DATUM -A- .

- UNSPECIFIED TOLERANCES ARE ± 0.005 .

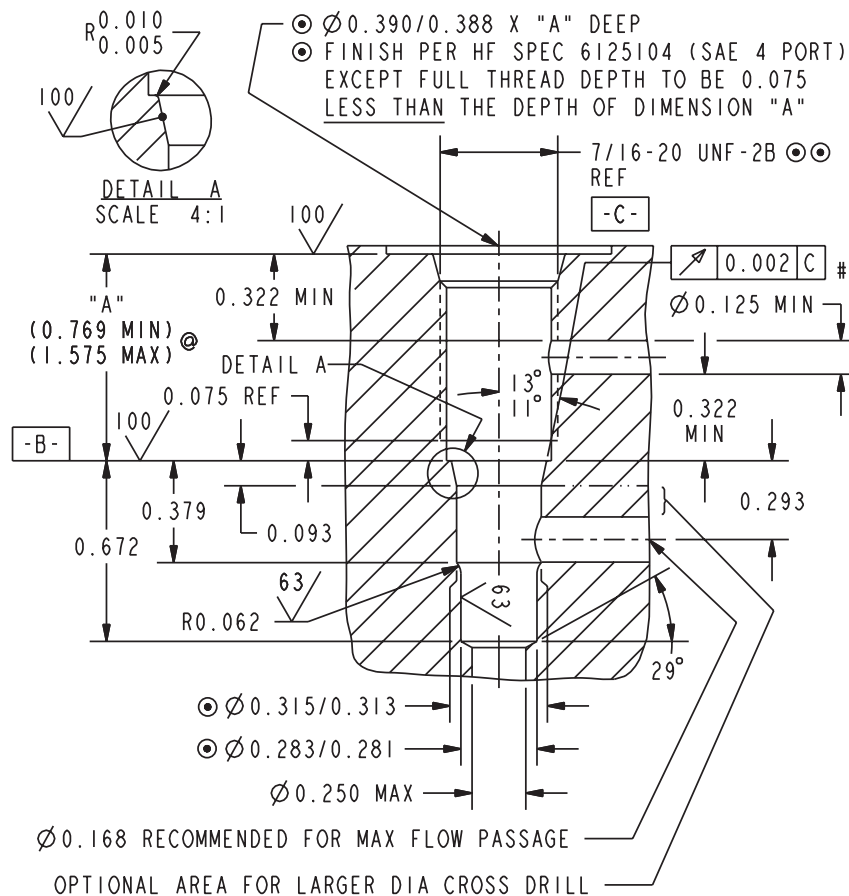
- UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.

VC04-B2



Series 04 Cartridge Cavities

VC04-B3



NOTES:

- THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL, CROSS DRILLS AND SAE 4 PORT) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.

④ -

	0.001	B
↗	0.002	C



	0.001	B
	0.0009	(PITCH DIA)

- UNSPECIFIED TOLERANCES ARE ± 0.005 .
- UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.
- @ - WITH HF FORM TOOLS AND USING 0.020/0.010 SPOTFACE DEPTH.
- # - THIS SURFACE IS A VALVE SEAT, IT MUST BE FREE OF NICKS AND TOOL MARKS.