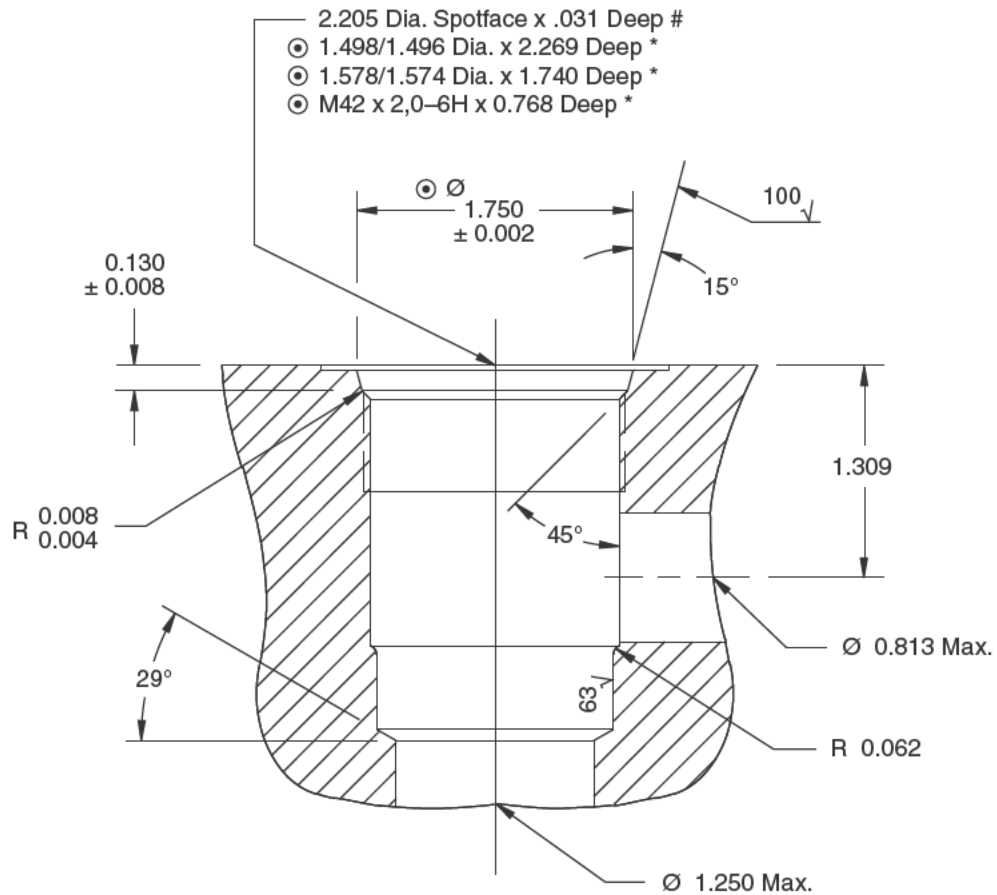


Series 42 Cartridge Cavities

VC42-M2



The above features (except for pilot drill & cross drills) can be machined simultaneously with a form tool.

⊙ — These diameters to be concentric within 0.002 T.I.R. and perpendicular to spotface within 0.001 T.I.R.

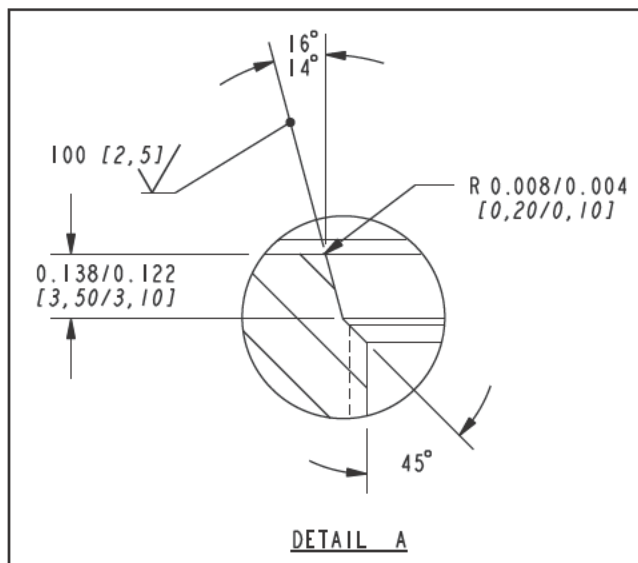
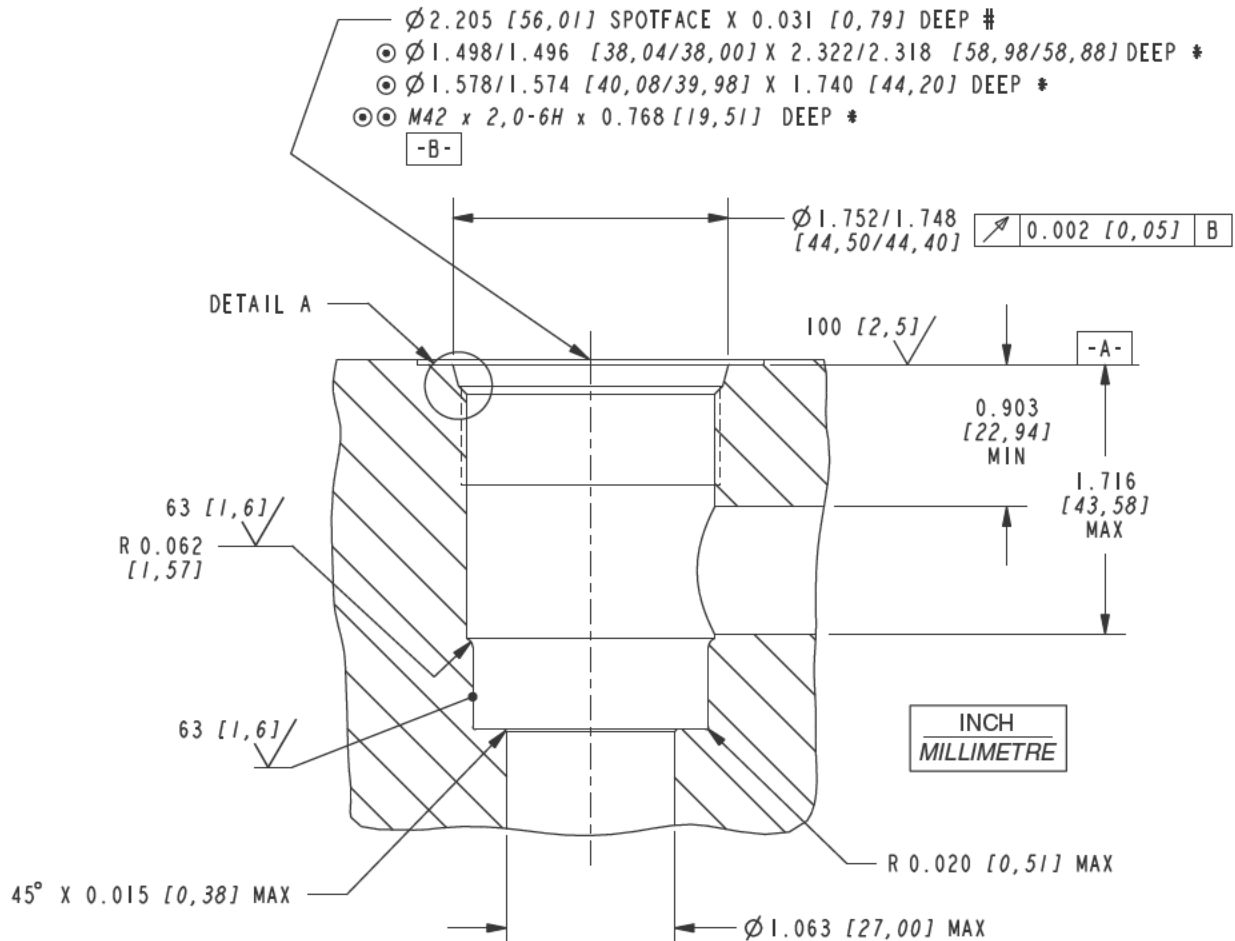
* — Depths are from spotface.

— Unless otherwise specified on machining drawing

Unspecified tolerances are ±0.005.

Series 42 Cartridge Cavities

HVC42-M2

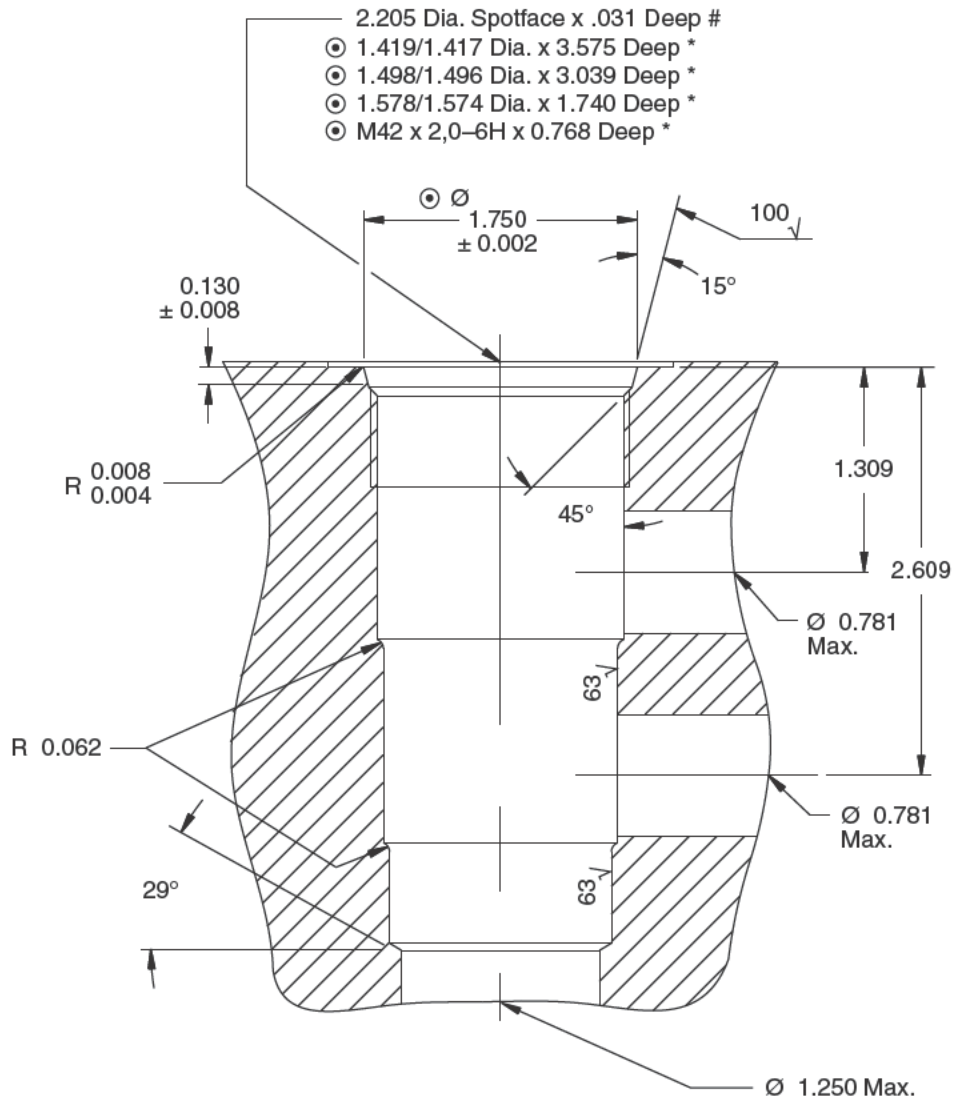


- $\odot$ - $\sqrt{0.001}$ [0,025] A
 $\sqrt{0.002}$ [0,05] B
 $\odot \odot$ - $\sqrt{0.001}$ [0,025] A
 $\bigcirc 0.0009$ [0,023] (PITCH DIA)

- * - DEPTHS ARE FROM DATUM -A-
 ‡ - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING
 - UNSPECIFIED TOLERANCES ARE ± 0.005 [0,13]
 - UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$
 - SURFACE FINISH SPECIFICATIONS ARE IN MICROINCHES [MICROMETERS]

Series 42 Cartridge Cavities

VC42-M3



The above features (except for pilot drill & cross drills) can be machined simultaneously with a form tool.

⊙ — These diameters to be concentric within 0.002 T.I.R. and perpendicular to spotface within 0.001 T.I.R.

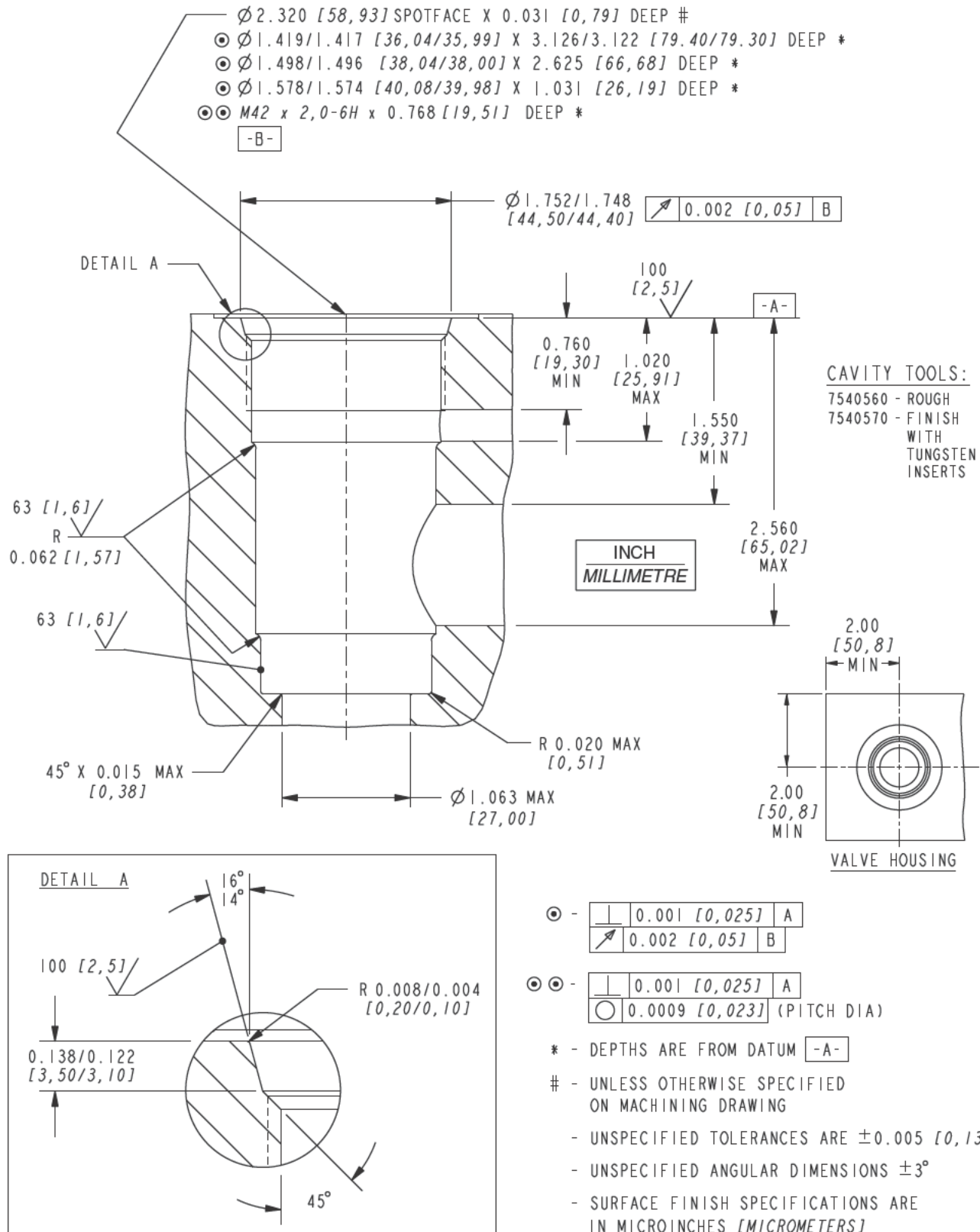
* — Depths are from spotface.

— Unless otherwise specified on machining drawing

Unspecified tolerances are ±0.005.

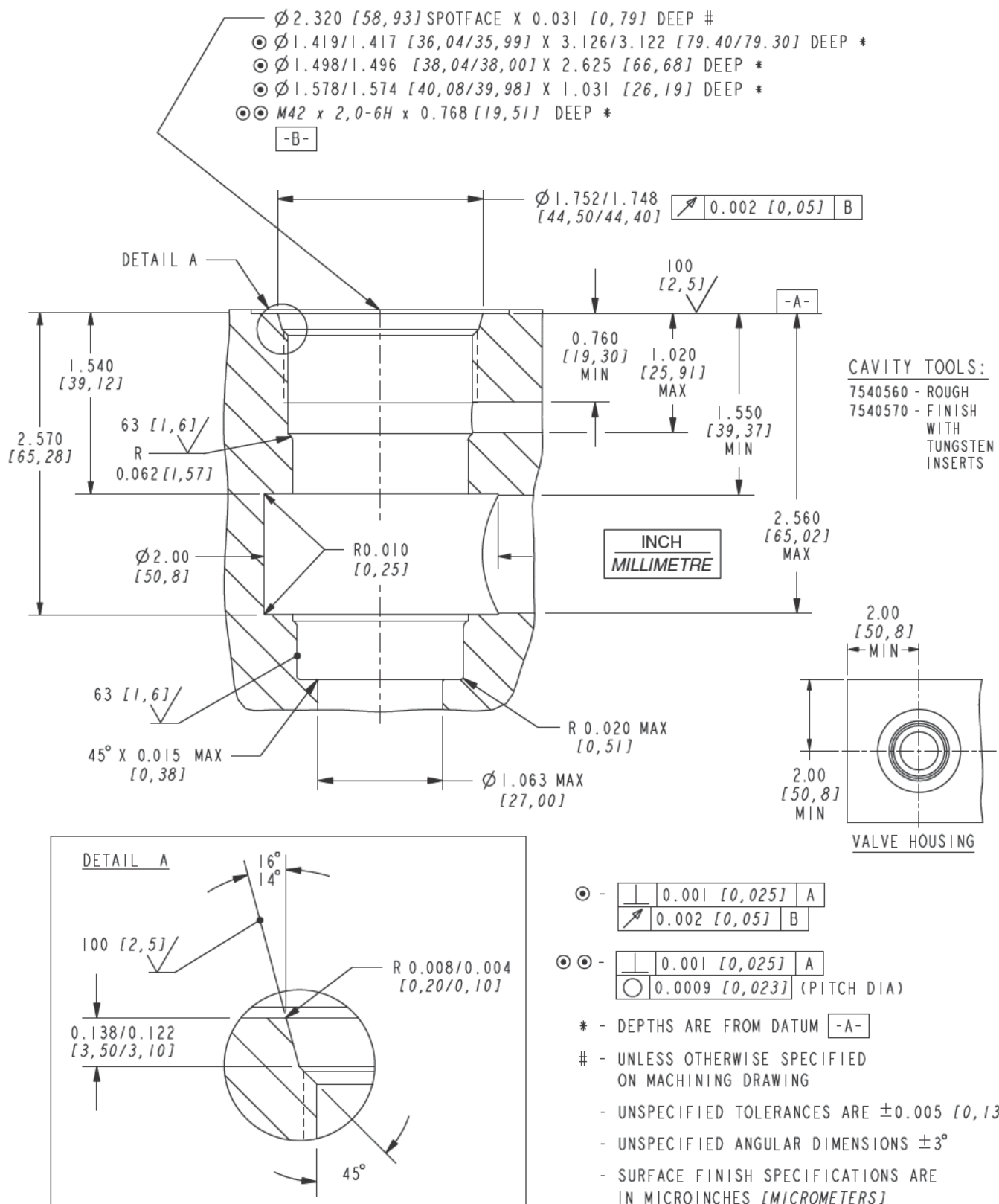
Series 42 Cartridge Cavities

HVC42-S3



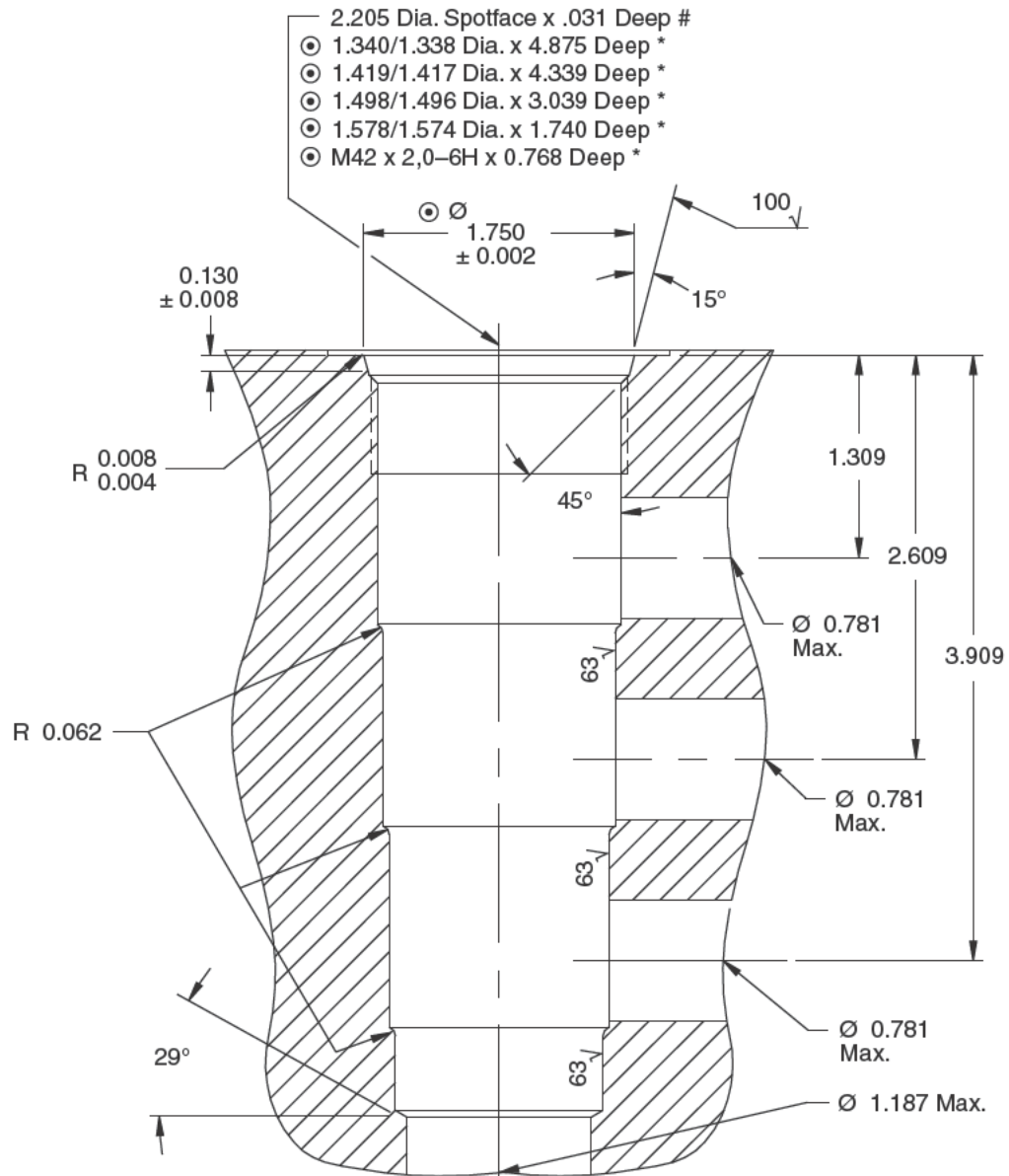
Series 42 Cartridge Cavities

HVC42-S3A



Series 42 Cartridge Cavities

VC42-M4



The above features (except for pilot drill & cross drills) can be machined simultaneously with a form tool.

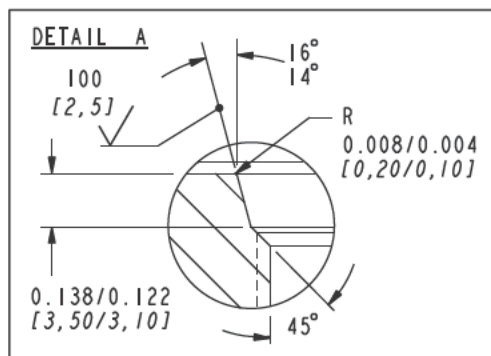
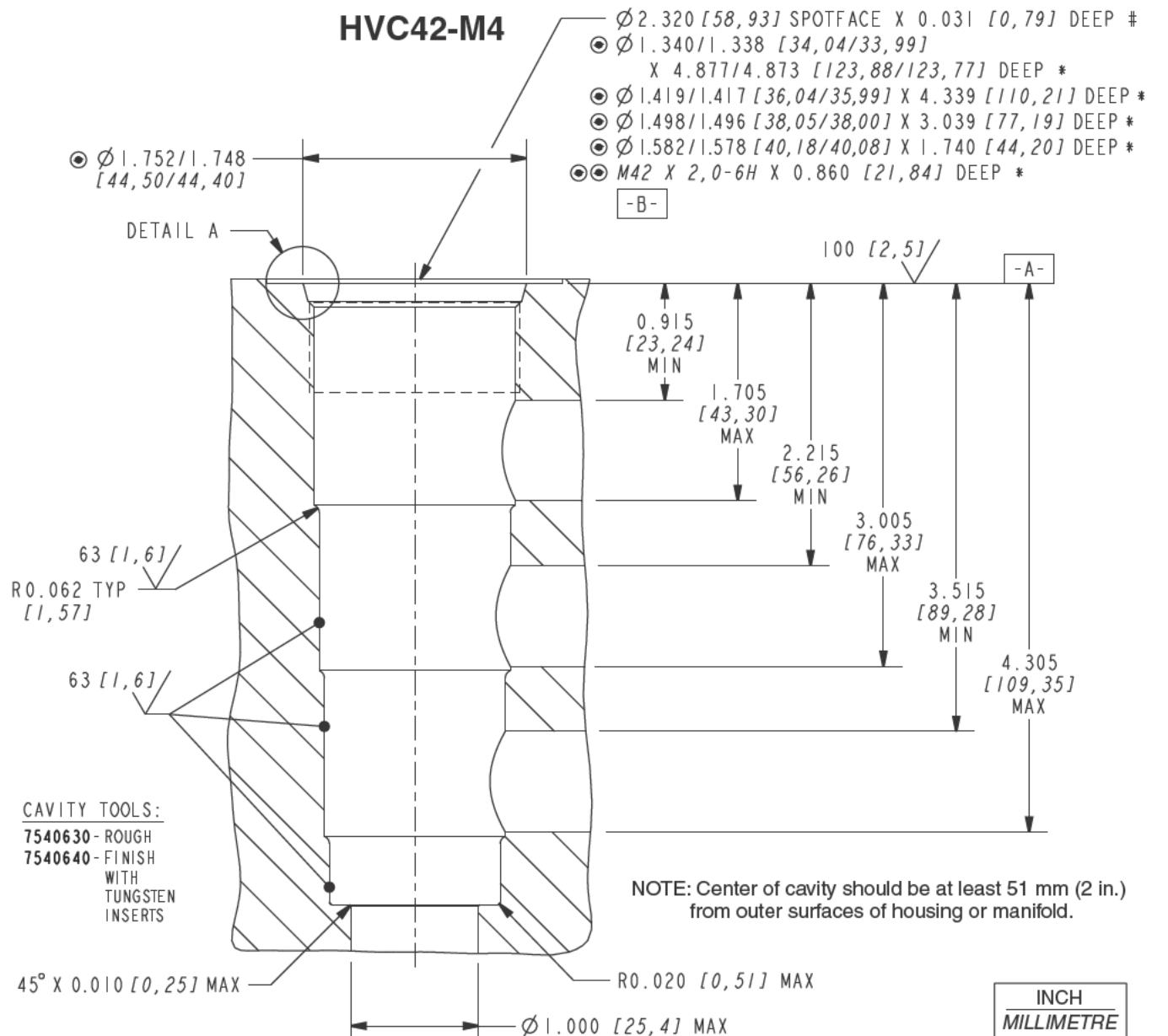
◎ — These diameters to be concentric within 0.002 T.I.R. and perpendicular to spotface within 0.001 T.I.R.

* — Depths are from spotface.

— Unless otherwise specified on machining drawing

Unspecified tolerances are ±0.005.

Series 42 Cartridge Cavities

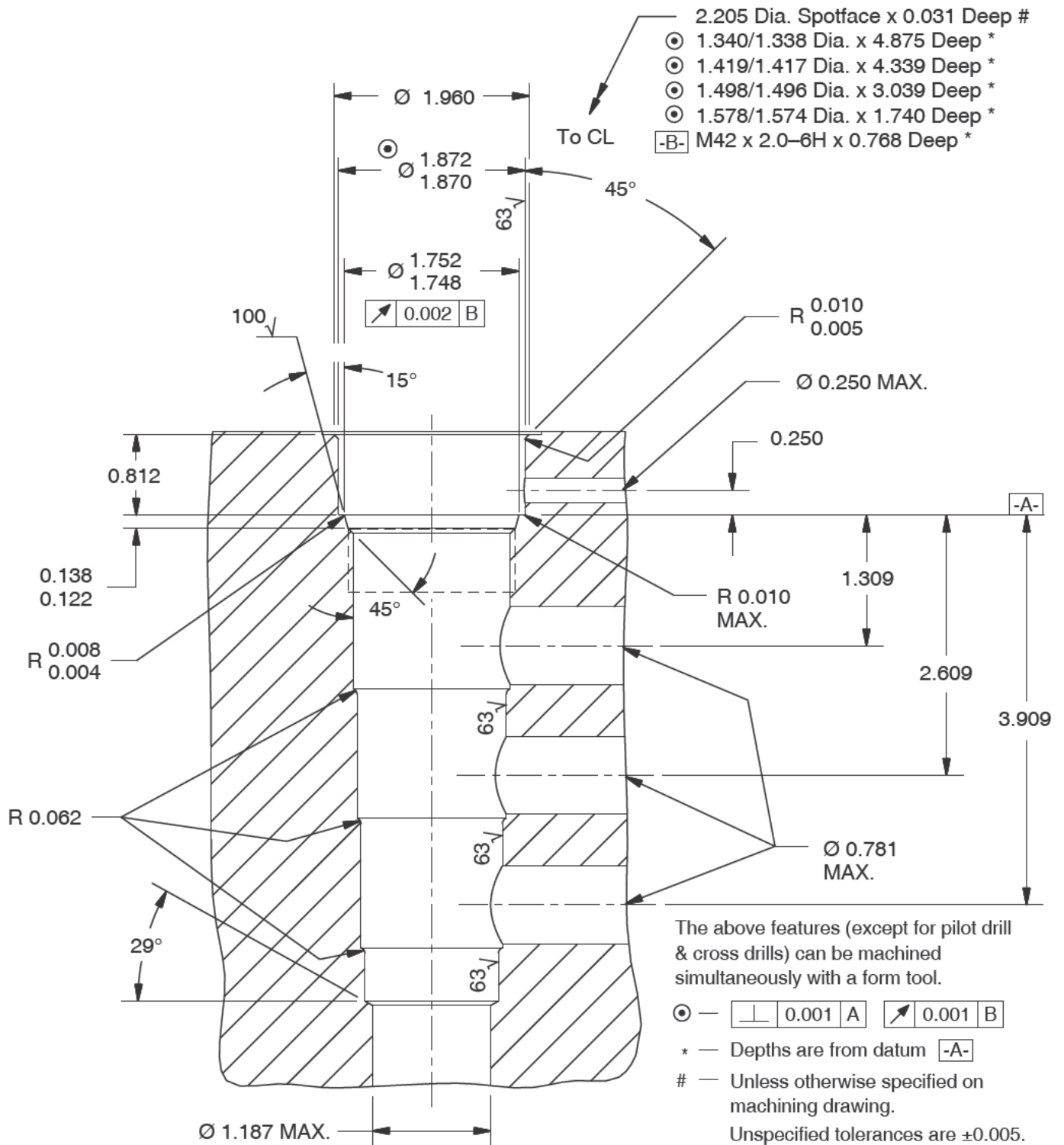


⊙ -		0.001 [0,025]	A
		0.002 [0,05]	B
⊙ ⊙ -		0.001 [0,025]	A
		0.0009 [0,023]	(PITCH DIA)

- * - DEPTHS ARE FROM DATUM -A-
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING
 - UNSPECIFIED TOLERANCES ARE ± 0.005 [0,13]
 - UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$
 - SURFACE FINISH SPECIFICATIONS ARE IN MICROINCHES [MICROMETERS]
- ** - CAVITY VARIATION 'A': PILOT DRILL $\varnothing 0.922$ [23,42] REQUIRED TO MINIMUM DEPTH OF 6.290 [159,77] FROM DATUM A ONLY IF NOTED ON SPECIFIC PRODUCT CATALOG PAGE.

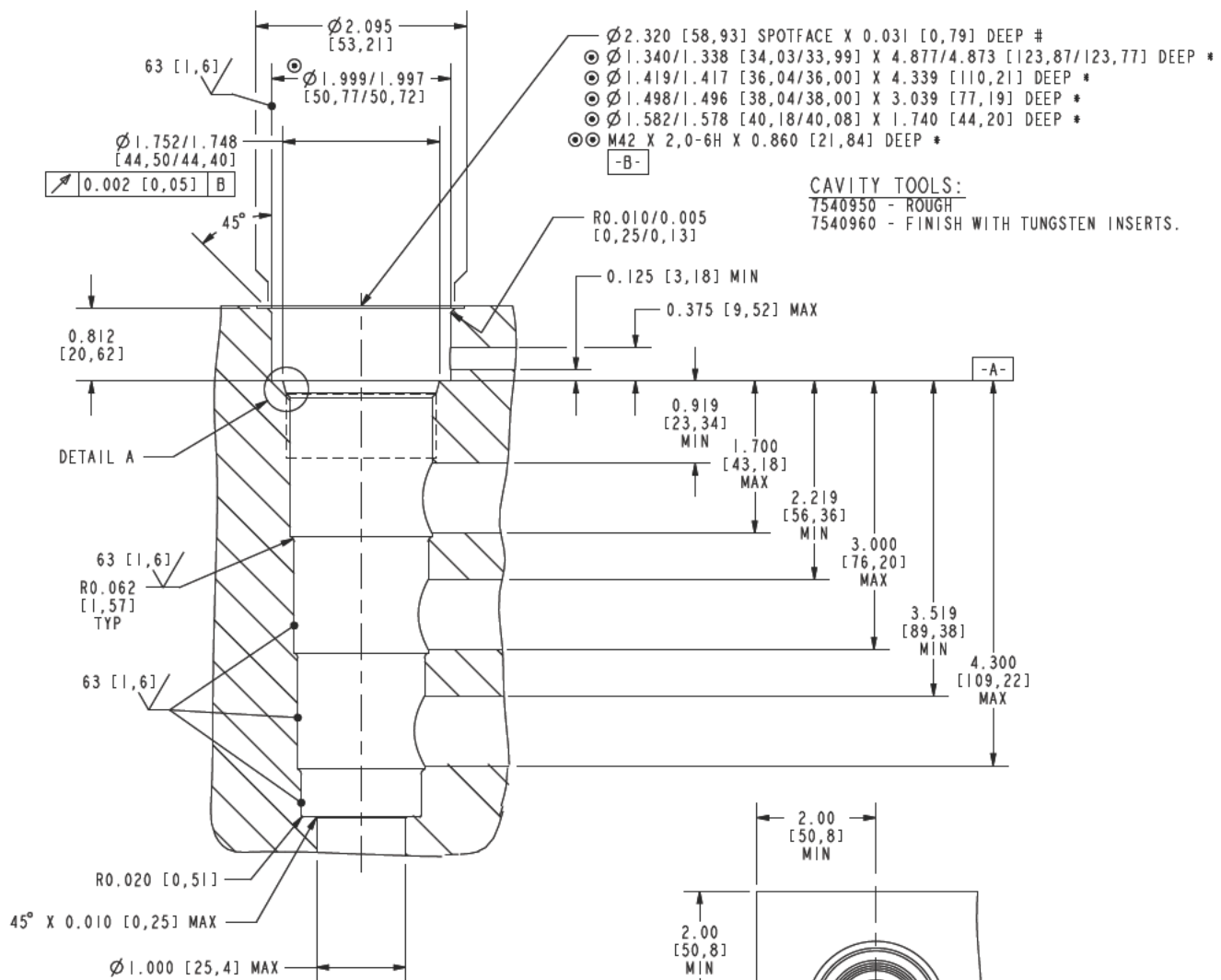
Series 42 Cartridge Cavities

VC42-S5

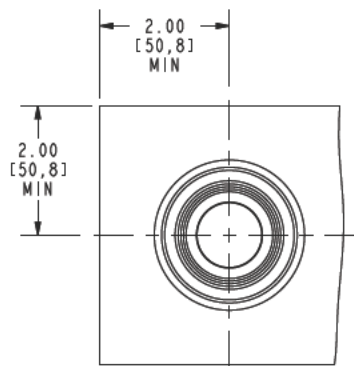
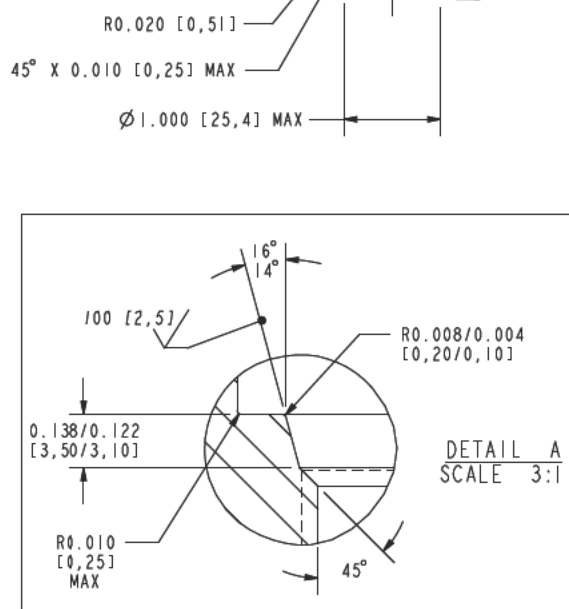


Series 42 Cartridge Cavities

HVC42-S5



CAVITY TOOLS:
7540950 - ROUGH
7540960 - FINISH WITH TUNGSTEN INSERTS.

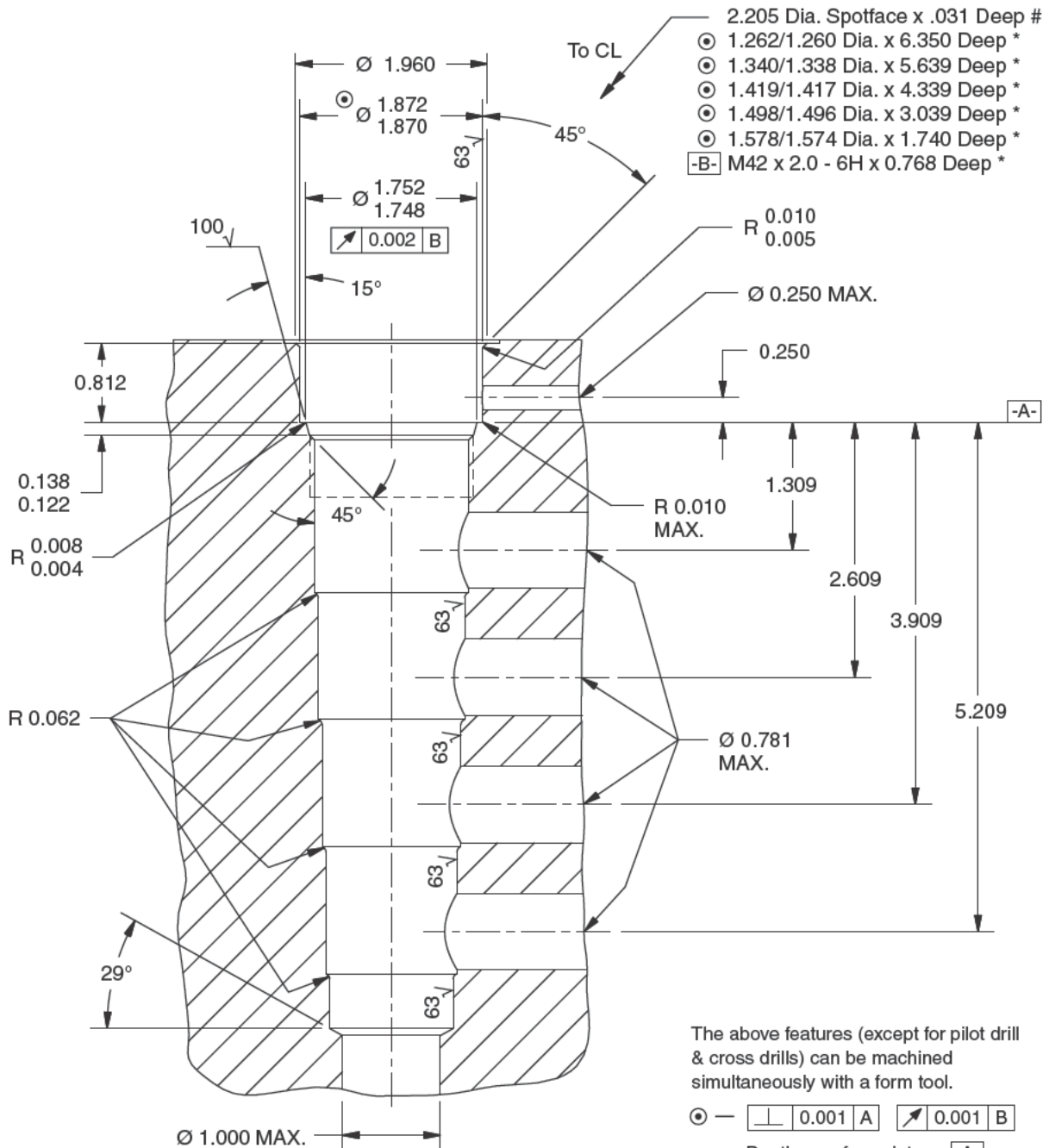


NOTES:

- * - DEPTHS ARE FROM DATUM -A-.
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ± 0.005 [0,13].
- UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.
- SURFACE FINISH SPECIFICATIONS ARE IN MICROINCHES [MICROMETERS].

Series 42 Cartridge Cavities

VC42-S6



The above features (except for pilot drill & cross drills) can be machined simultaneously with a form tool.

⊙ — $\sqrt{0.001}$ A $\sqrt{0.001}$ B

* — Depths are from datum -A-

— Unless otherwise specified on machining drawing.

Unspecified tolerances are ± 0.005 .

