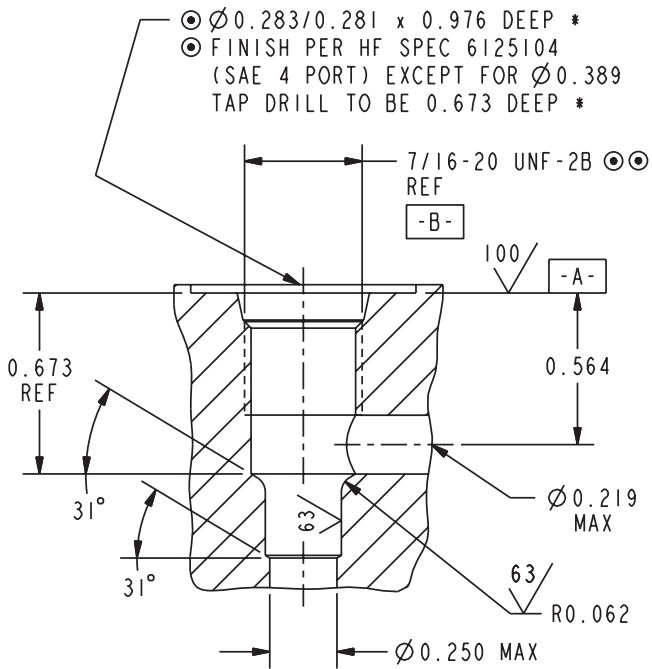


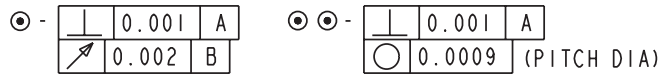
Series 04 Cartridge Cavities

VC04-2



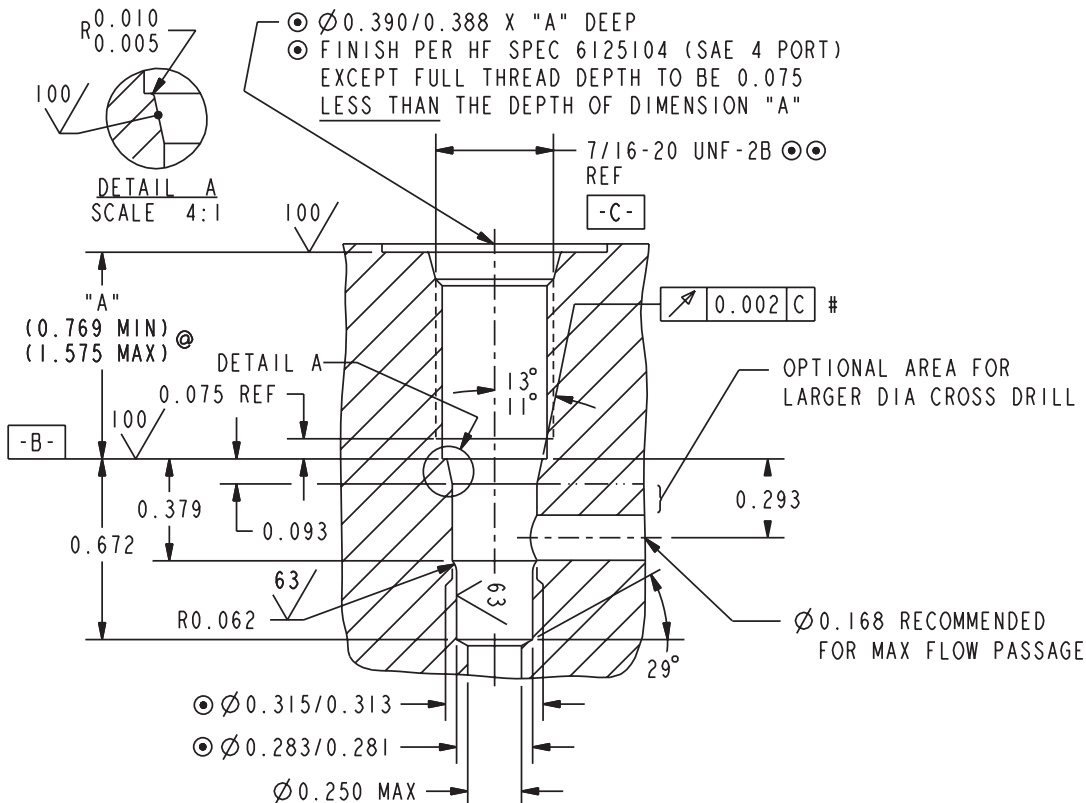
NOTES:

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



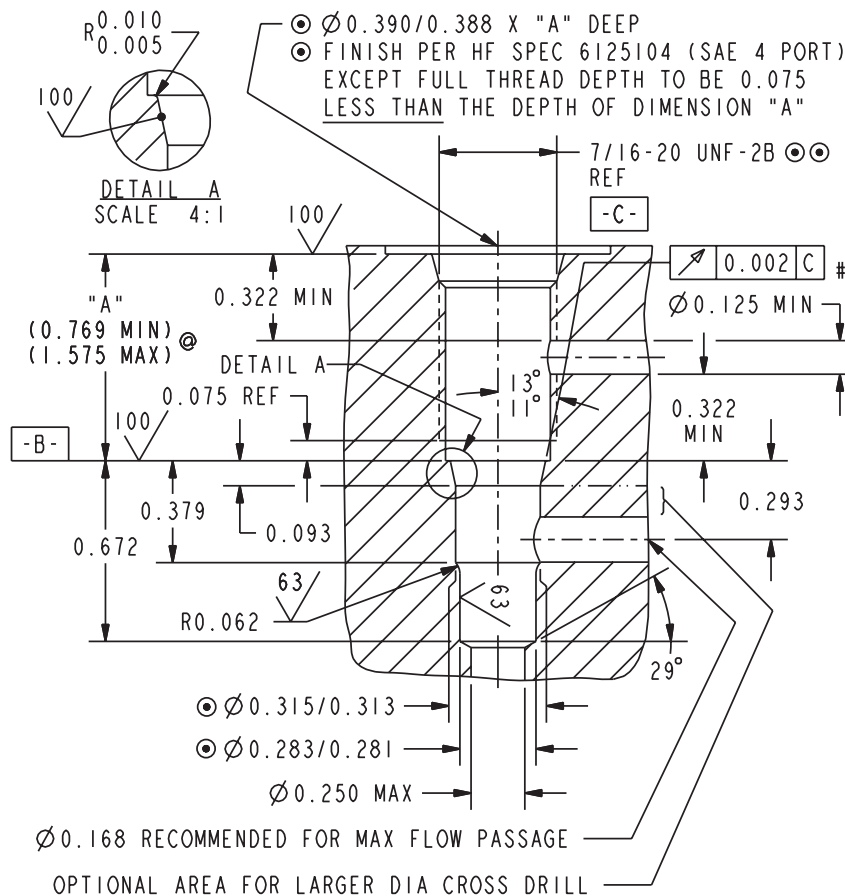
- * - DEPTHS ARE FROM DATUM -A- .
- UNSPECIFIED TOLERANCES ARE ± 0.005 .
- UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.

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.



- UNSPECIFIED TOLERANCES ARE ± 0.005 .

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

\odot - 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.