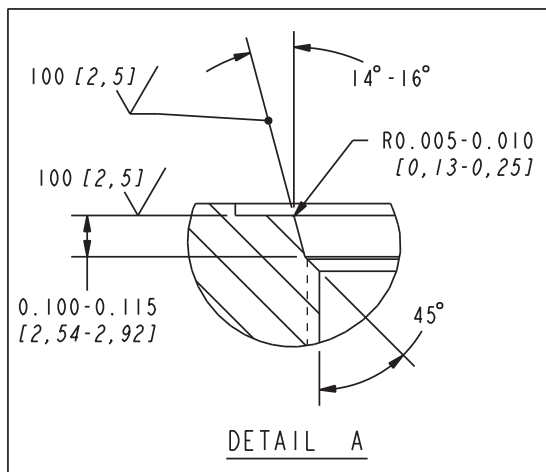
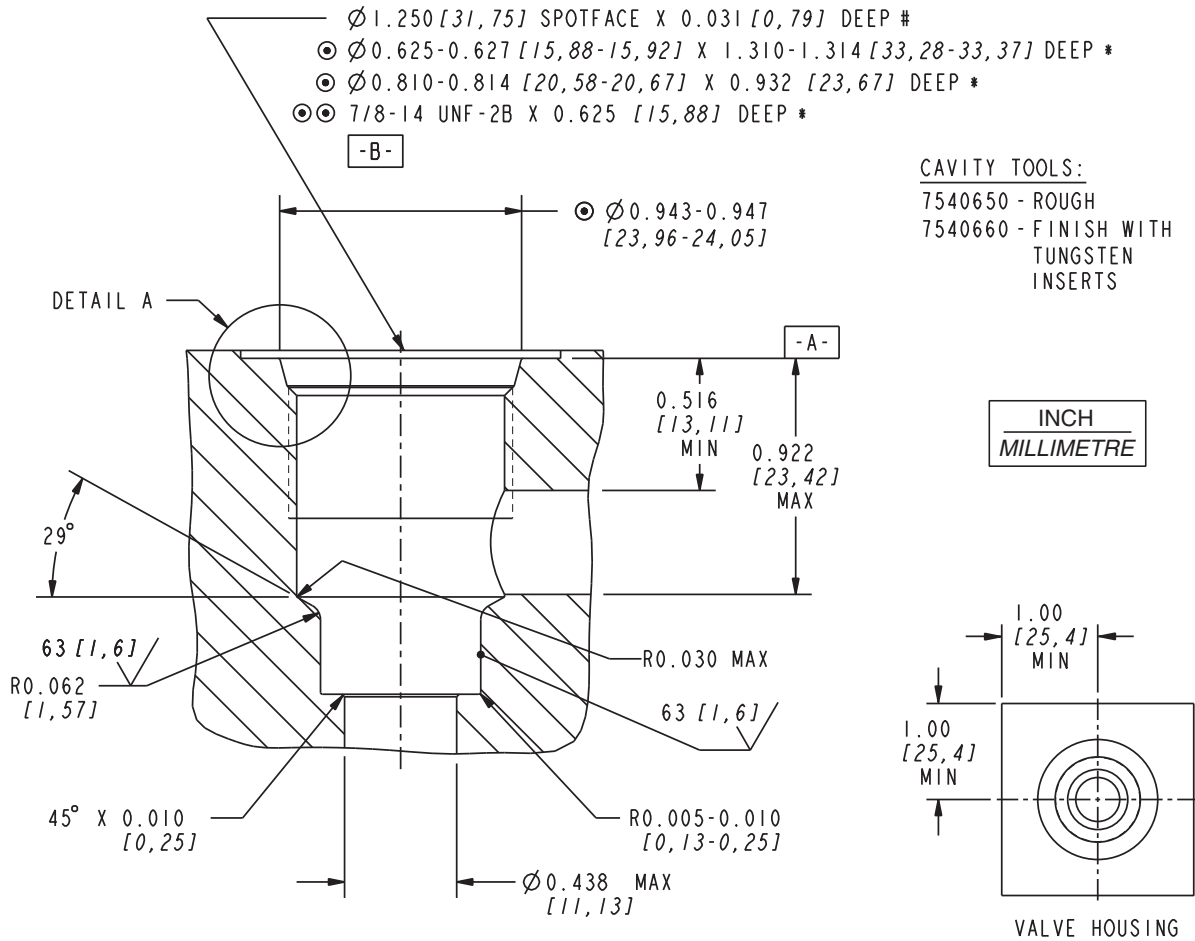


Series 10 Cartridge Cavities

HVC10-2



NOTES:

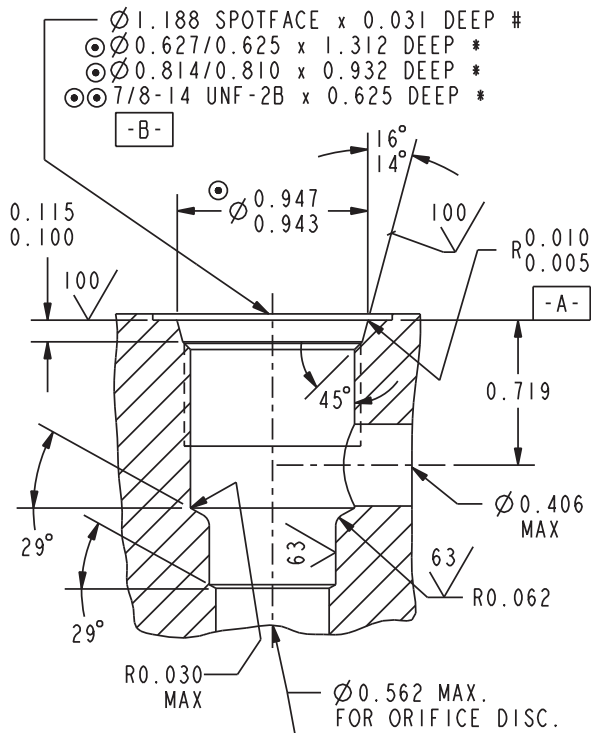
- \odot -

	0.001 [0,025]	A
↗	0.002 [0,05]	B
- $\odot \odot$ -

	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].

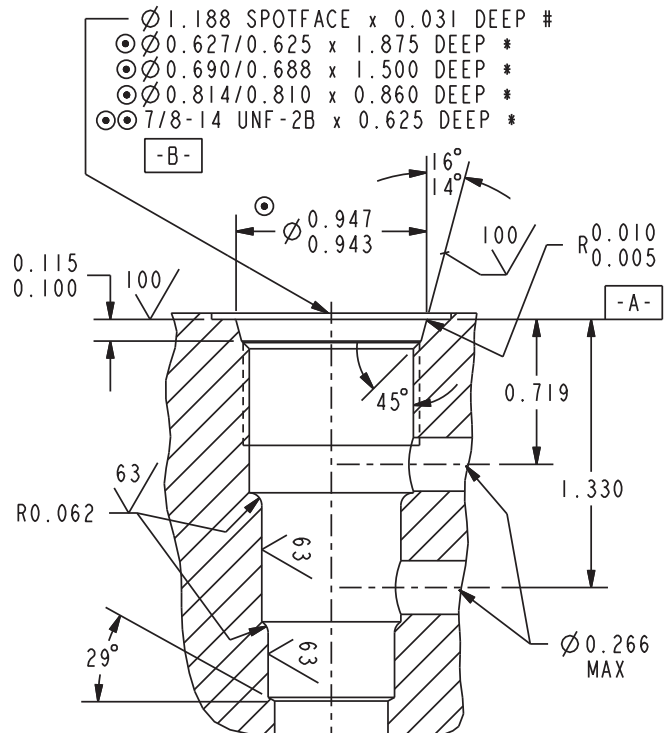
Series 10 Cartridge Cavities

VC10-2



NOTE:
 CAVITY VARIATION 'A'***
 PILOT DRILL $\varnothing 0.562$ MIN.
 REQUIRED TO MIN. DEPTH
 OF 1.50 FROM SPOTFACE

VC10-3



NOTE:
 CAVITY VARIATION 'A'***
 PILOT DRILL $\varnothing 0.562$ MIN.
 REQUIRED TO MIN. DEPTH
 OF 2.06 FROM SPOTFACE

NOTE:
 CAVITY VARIATION 'B'***
 PILOT DRILL $\varnothing 0.600$ MIN.
 0.615 MAX. REQUIRED
 TO MIN. DEPTH OF 2.63
 FROM SPOTFACE

NOTES:

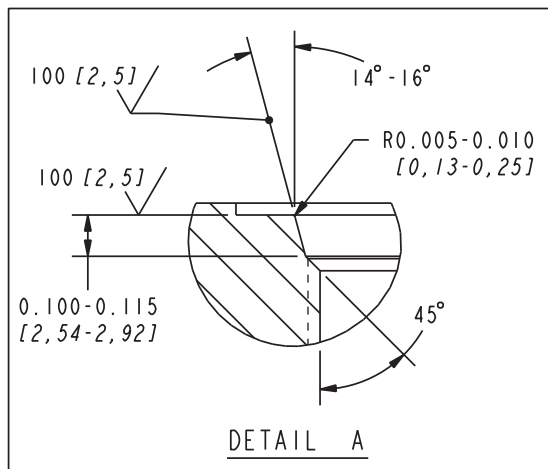
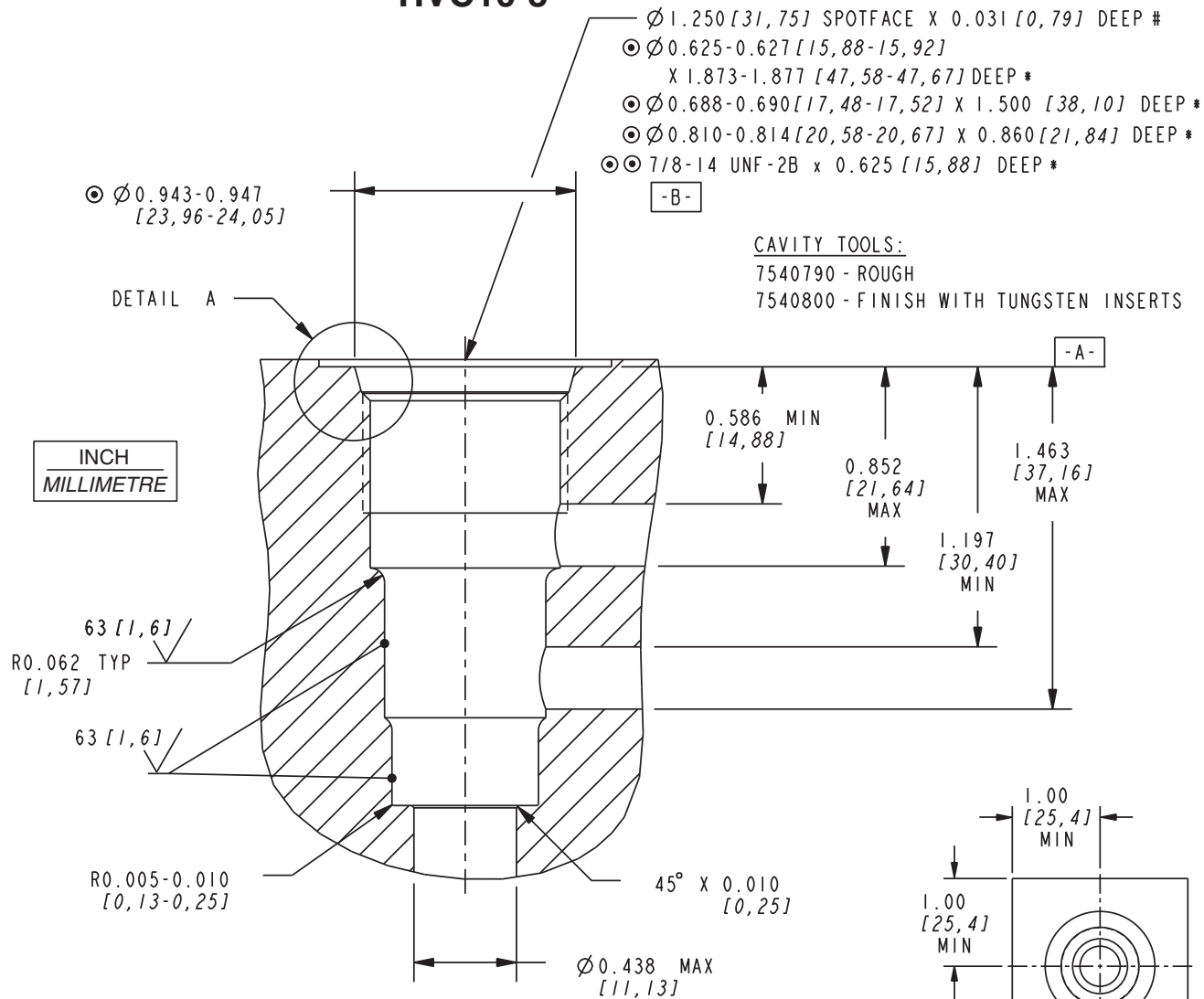
- THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL AND CROSS DRILLS) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.

\odot -	0.001	A	$\odot \odot$ -	0.001	A
		0.002		B	

- * - DEPTHS ARE FROM DATUM -A- .
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ± 0.005 .
- UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.
- ** - FEATURES OF VARIATIONS ARE ONLY REQUIRED IF NOTED ON A SPECIFIC PRODUCT CATALOG PAGE.

Series 10 Cartridge Cavities

HVC10-3



NOTES:

- \odot -

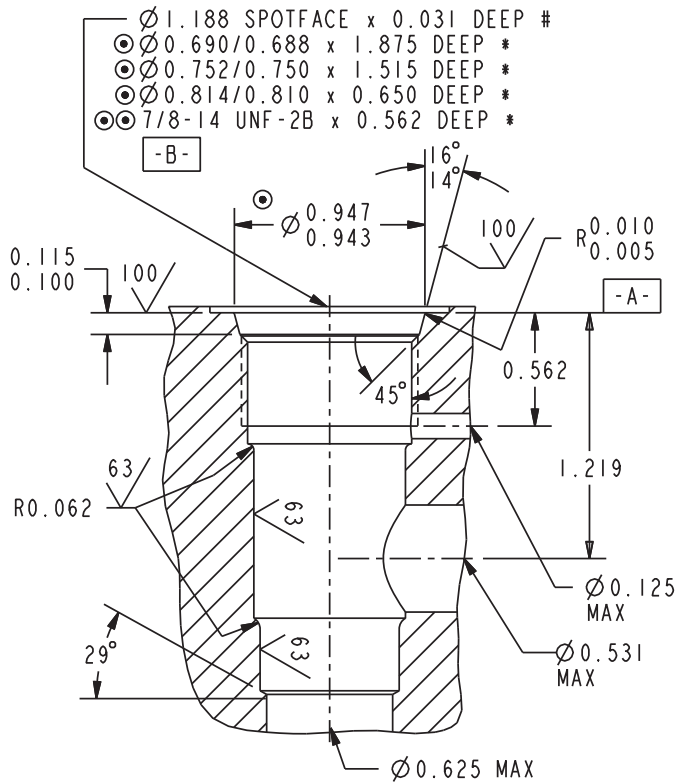
	0.001 [0,025]	A	
↗	0.002 [0,05]	B	
- $\odot \odot$ -

	0.001 [0,025]	A	
○	0.0009 [0,023]	(PITCH DIA)	

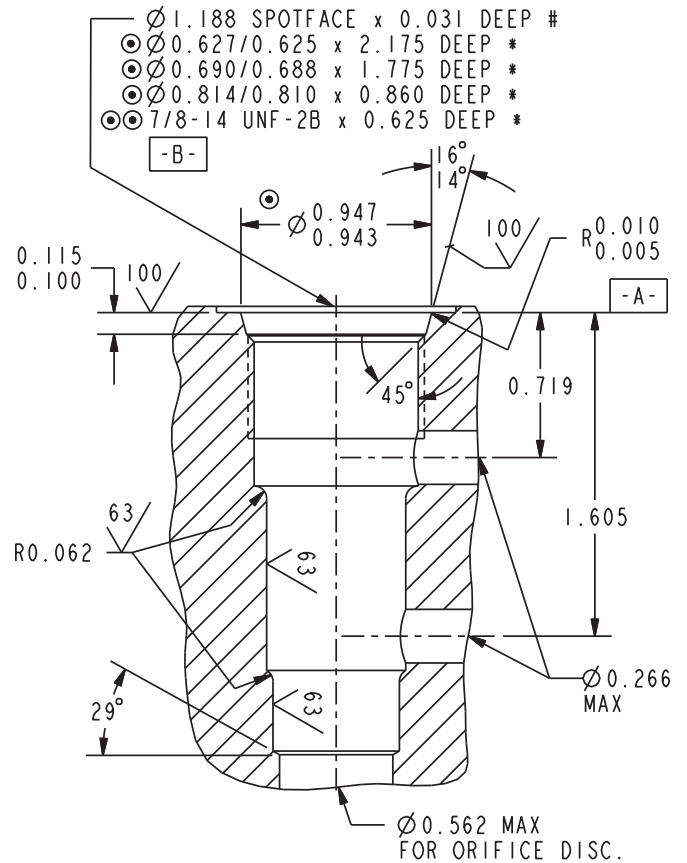
- * - DEPTHS ARE FROM DATUM -A-.
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ± 0.005 [0,13].
- UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.
- SURFACE FINISH SPECIFICATIONS ARE IN MICROINCHES [MICROMETERS].

Series 10 Cartridge Cavities

VC10-S3



VC10-L3



NOTES:

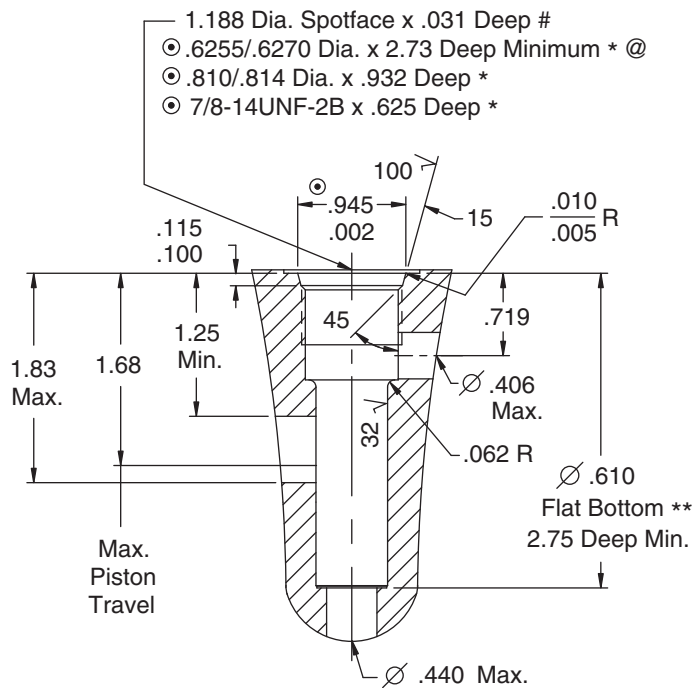
- THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL AND CROSS DRILLS) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.

\odot -	0.001	A	$\odot \odot$ -	0.001	A
	0.002	B		0.0009	(PITCH DIA)

- * - DEPTHS ARE FROM DATUM **-A-**.
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ± 0.005 .
- UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.

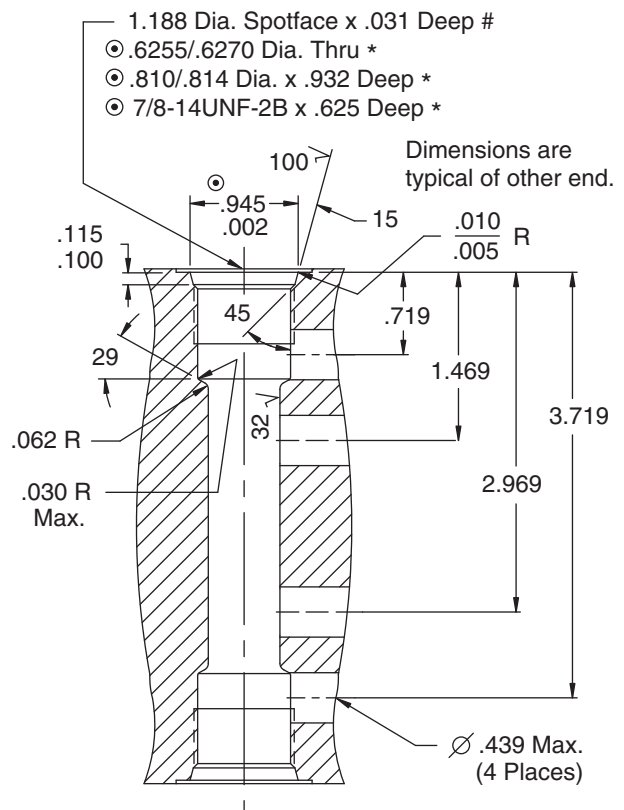
Series 10 Cartridge Cavities

VC10-PCV



** Flat Bottom Dia. is used as the PCV Piston stop.
 Alternate stop can be up to .025 inch deeper.

VC10-DCV



These 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.

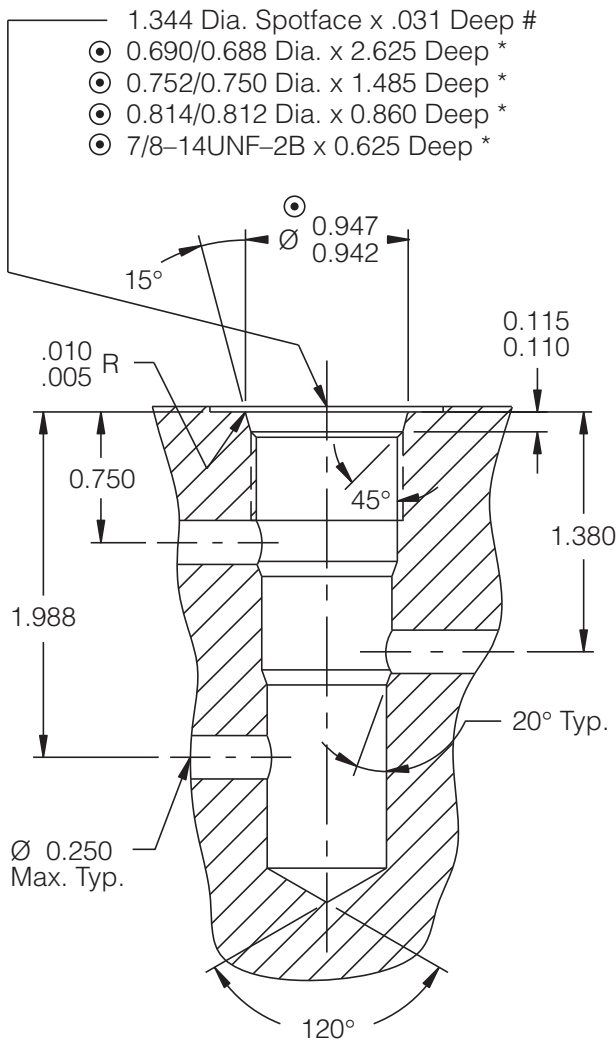
* — Depths are from spotface.

— Unless otherwise specified on machining drawing
 Unspecified tolerances are ± 0.005 .

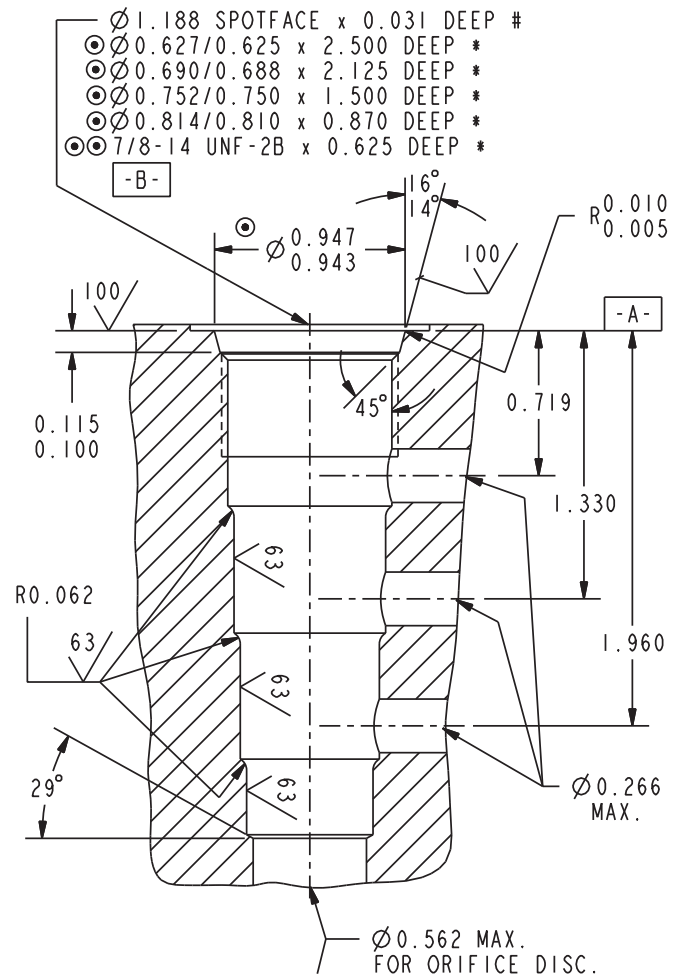
@ — Flat bottom diameter is used as PCV piston stop.
 If alternate stop or if 0.626 diameter is deeper than min. shown above, then the piston stop must be within 0.025" max. of the depth of the 0.626 diameter.

Series 10 Cartridge Cavities

VC98-3



VC10-4



NOTE:
CAVITY VARIATION 'A' **
PILOT DRILL ∅ 0.562 MIN.
REQUIRED TO MIN. DEPTH
OF 2.69 FROM SPOTFACE

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

All machined cavity surfaces $46\sqrt{\quad}$ maximum.

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

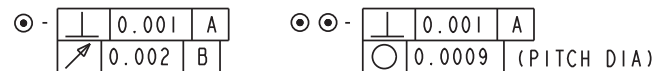
* — Depths are from spotface.

— Unless otherwise specified on machining drawing.

Unspecified tolerances are ± 0.005 .

NOTES:

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



* - DEPTHS ARE FROM DATUM -A- .

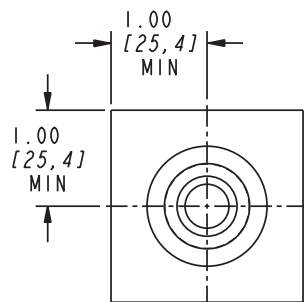
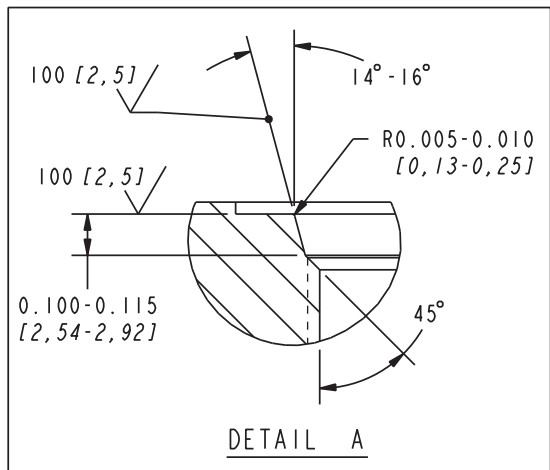
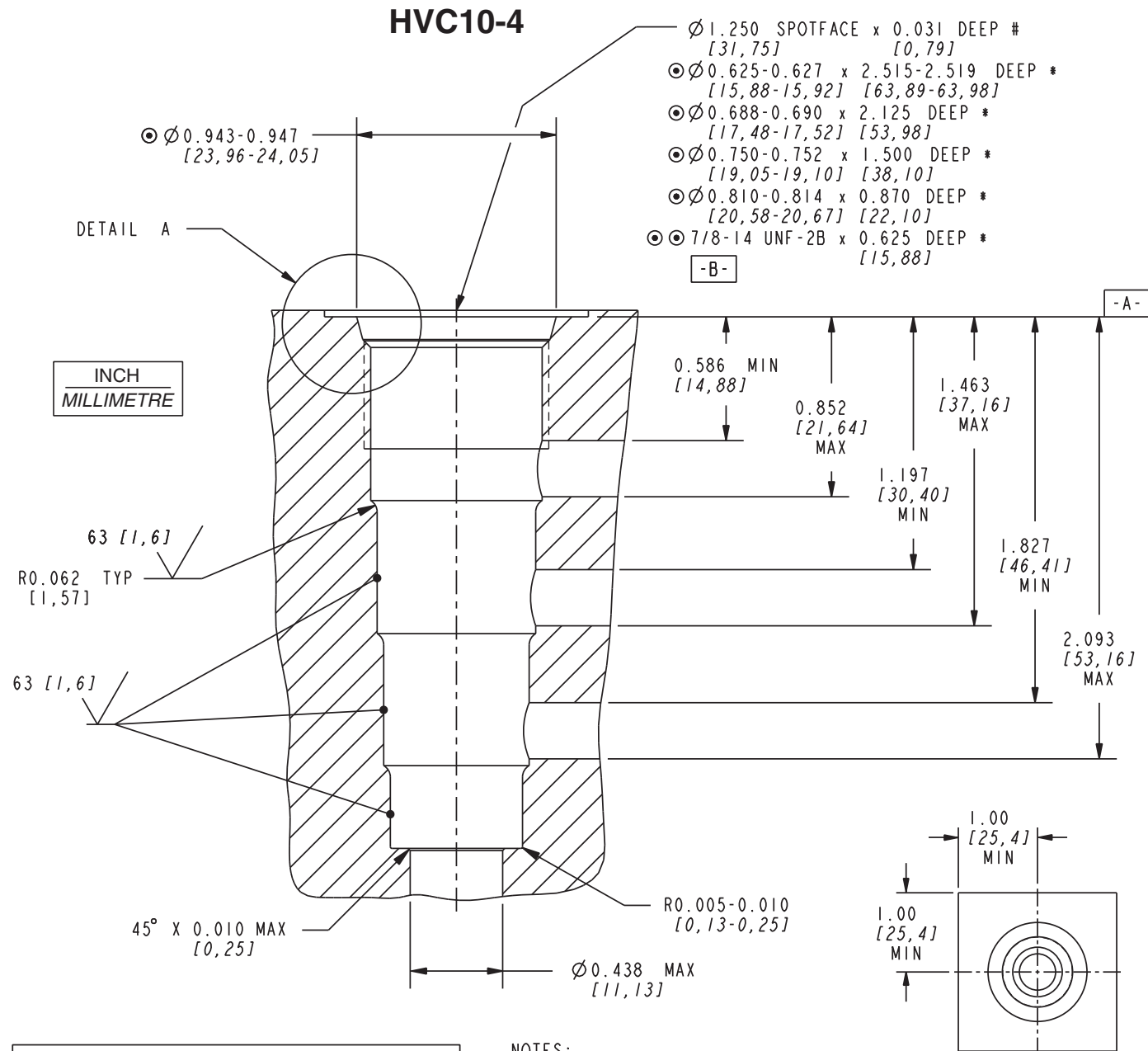
- UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.

- UNSPECIFIED TOLERANCES ARE ± 0.005 .

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

** - FEATURES OF VARIATION 'A' ARE ONLY REQUIRED IF NOTED ON A SPECIFIC PRODUCT CATALOG PAGE.

Series 10 Cartridge Cavities



NOTES:

- ⊙ -

	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].

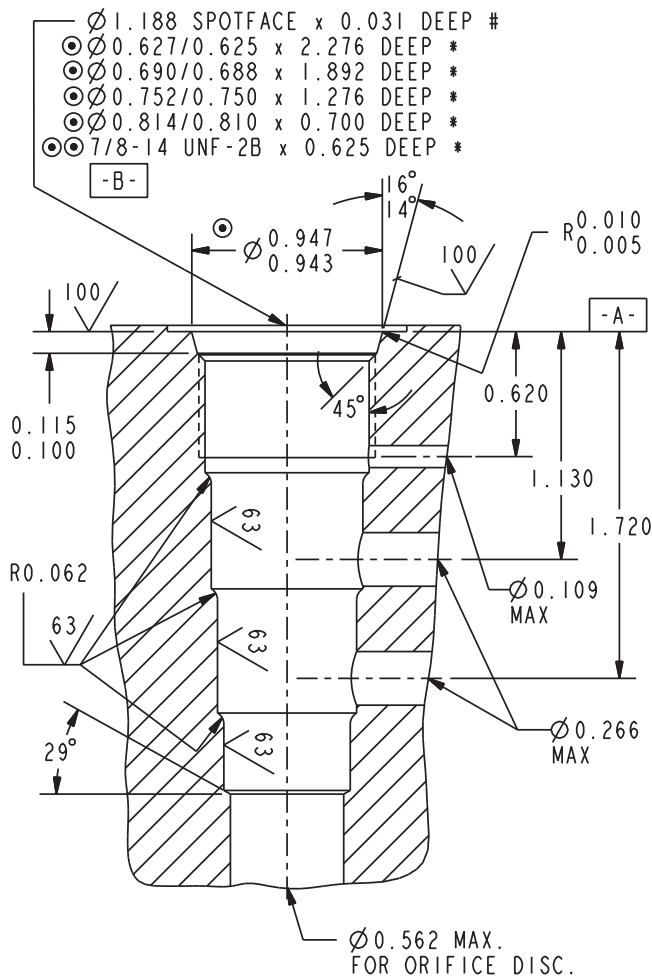
VALVE HOUSING

CAVITY TOOLS:

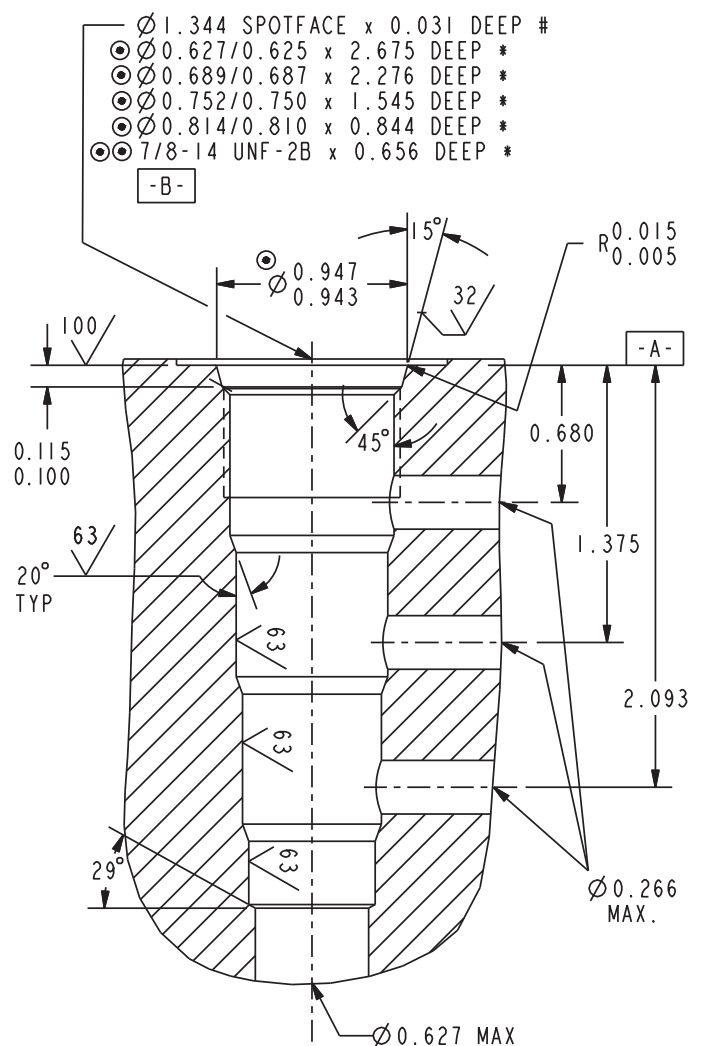
- 7540810 - ROUGH
- 7540820 - FINISH
- WITH TUNGSTEN INSERTS

Series 10 Cartridge Cavities

VC10-S4



VC10-L4



NOTES:

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

\odot - <table border="1"> <tr><td>0.001</td><td>A</td></tr> <tr><td>\varnothing 0.002</td><td>B</td></tr> </table>	0.001	A	\varnothing 0.002	B	$\odot \odot$ - <table border="1"> <tr><td>0.001</td><td>A</td></tr> <tr><td>\odot 0.0009</td><td>(PITCH DIA)</td></tr> </table>	0.001	A	\odot 0.0009	(PITCH DIA)
	0.001	A							
\varnothing 0.002	B								
0.001	A								
\odot 0.0009	(PITCH DIA)								

* - DEPTHS ARE FROM DATUM -A- .

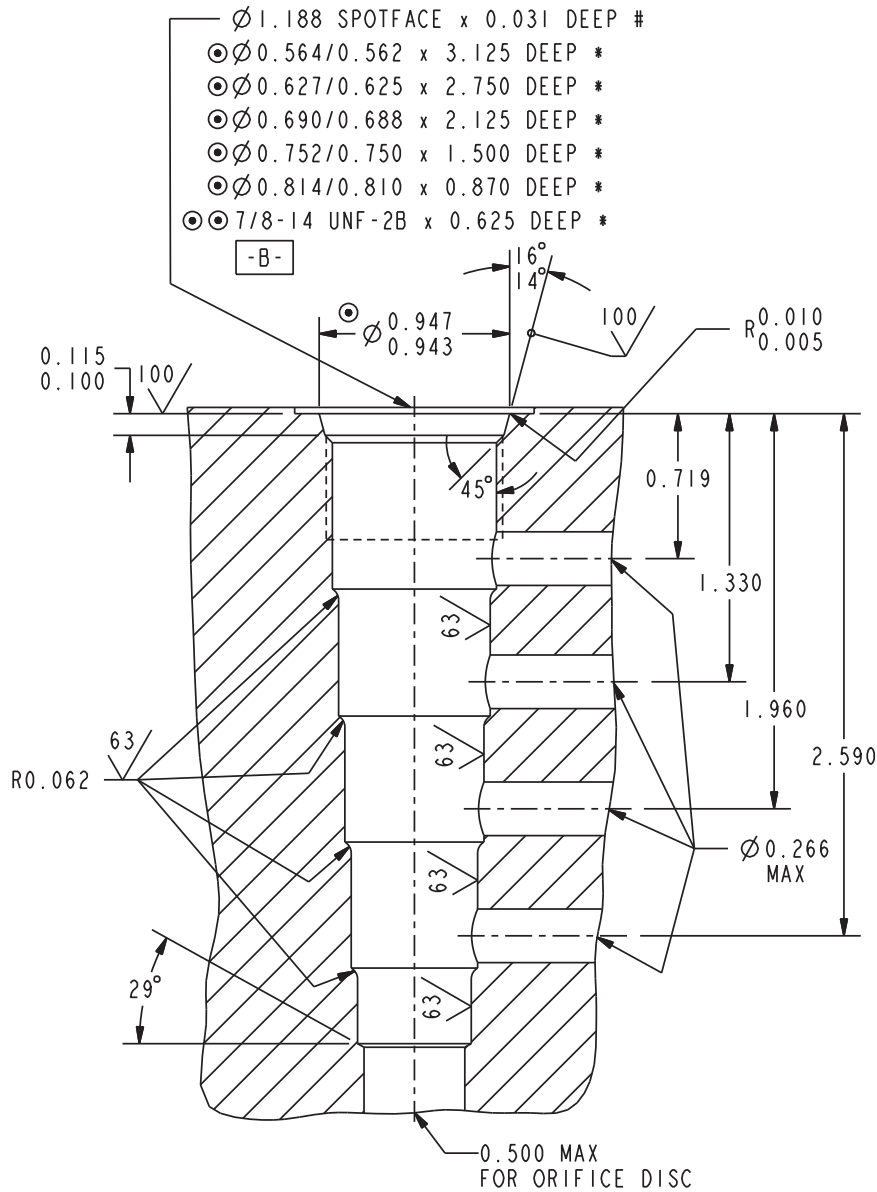
- UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.

- UNSPECIFIED TOLERANCES ARE ± 0.005 .

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

Series 10 Cartridge Cavities

VC10-5



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

\odot -

\perp	0.001	A
∇	0.002	B

 $\odot \odot$ -

\perp	0.001	A
\bigcirc	0.0009	(PITCH DIA)

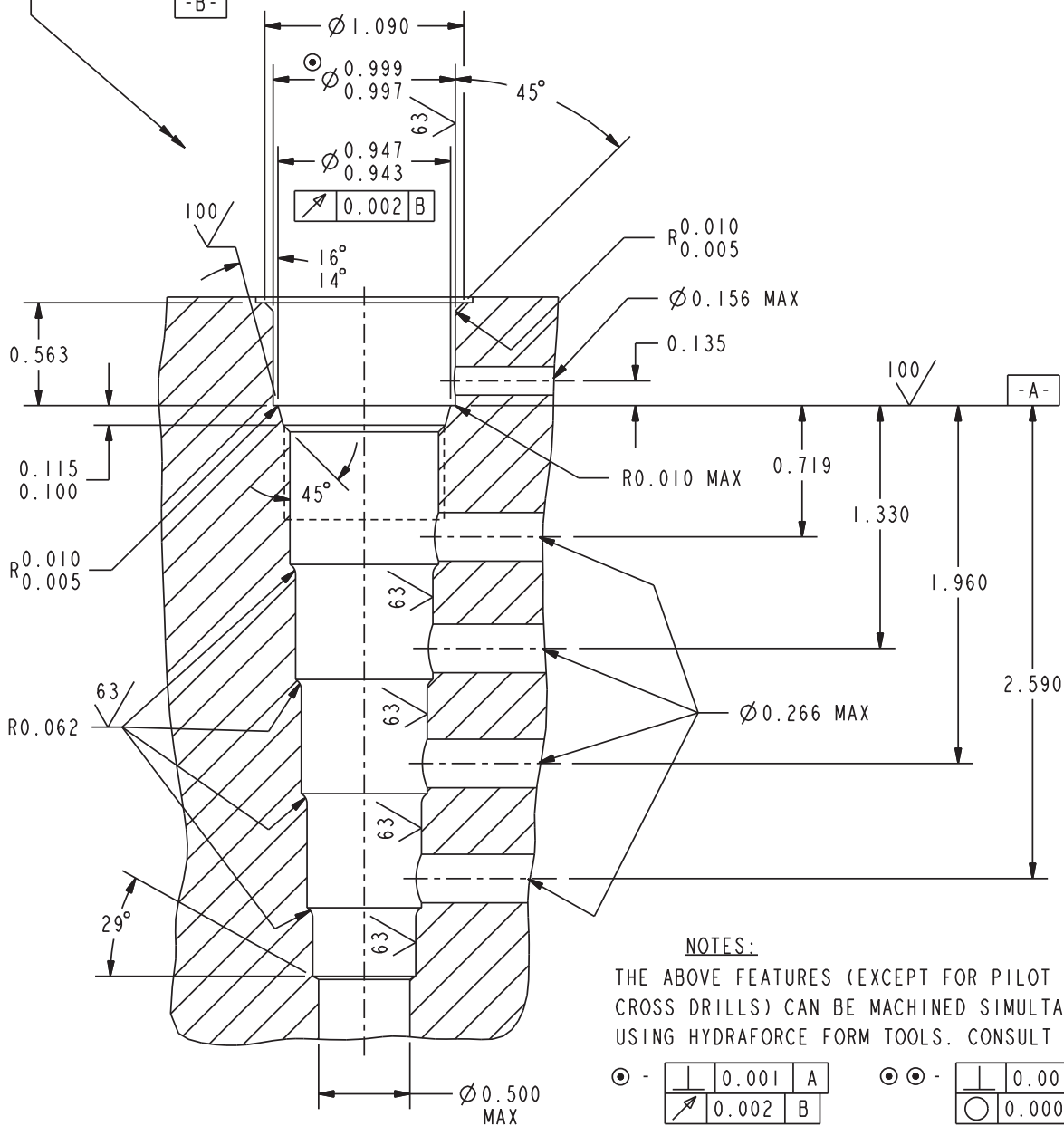
- * - DEPTHS ARE FROM DATUM -A- .
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ± 0.005 .
- UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.

Series 10 Cartridge Cavities

VC10-S6

- ∅ 1.188 SPOTFACE x 0.031 DEEP #
- ⊙ ∅ 0.564/0.562 x 3.125 DEEP *
- ⊙ ∅ 0.627/0.625 x 2.750 DEEP *
- ⊙ ∅ 0.690/0.688 x 2.125 DEEP *
- ⊙ ∅ 0.752/0.750 x 1.500 DEEP *
- ⊙ ∅ 0.814/0.810 x 0.870 DEEP *
- ⊙⊙ 7/8-14 UNF-2B x 0.625 DEEP *

-B-



NOTES:

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

- ⊙ -

⊥	0.001	A
↗	0.002	B
- ⊙⊙ -

⊥	0.001	A
○	0.0009	(PITCH DIA)

- * - DEPTHS ARE FROM DATUM -A- .
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ±0.005.
- UNSPECIFIED ANGULAR DIMENSIONS ±3°.