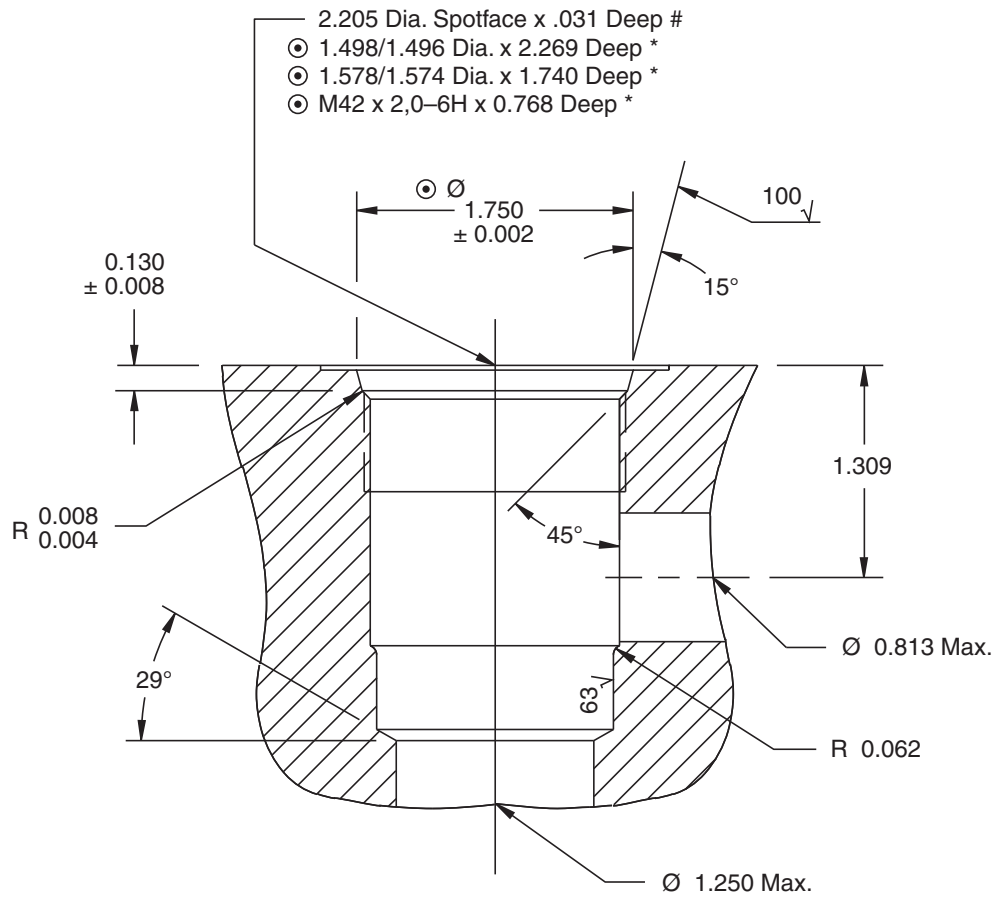


Series 42 Cartridge Cavities

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.

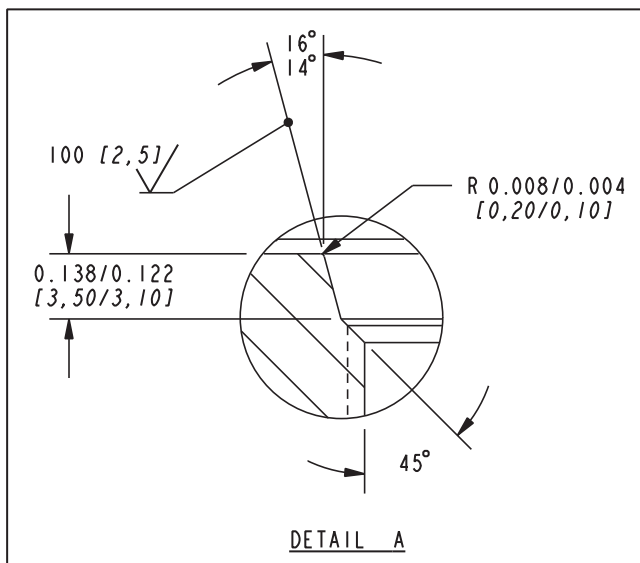
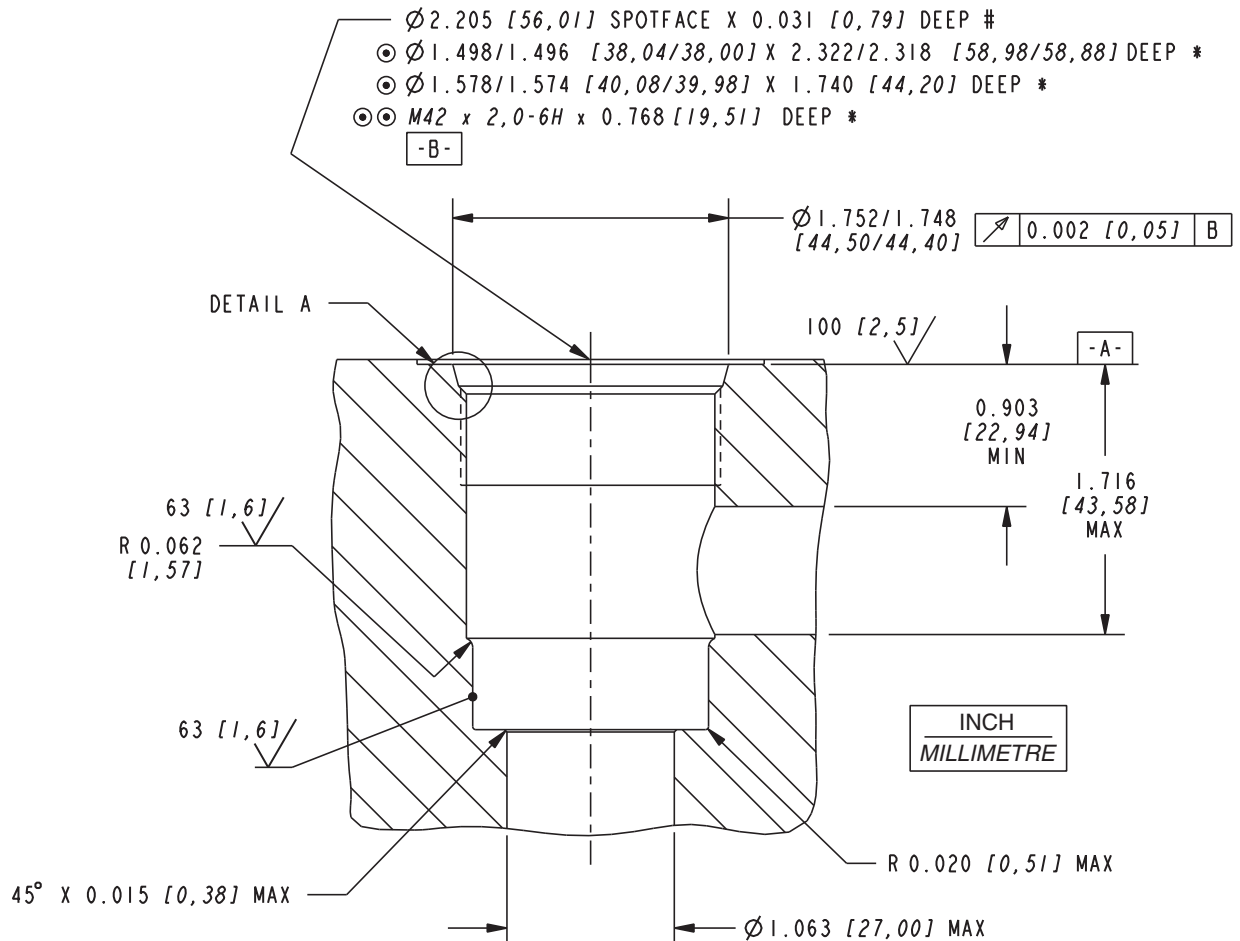
* — Depths are from spotface.

— Unless otherwise specified on machining drawing

Unspecified tolerances are ±0.005.

Series 42 Cartridge Cavities

HVC42-M2



- \odot -

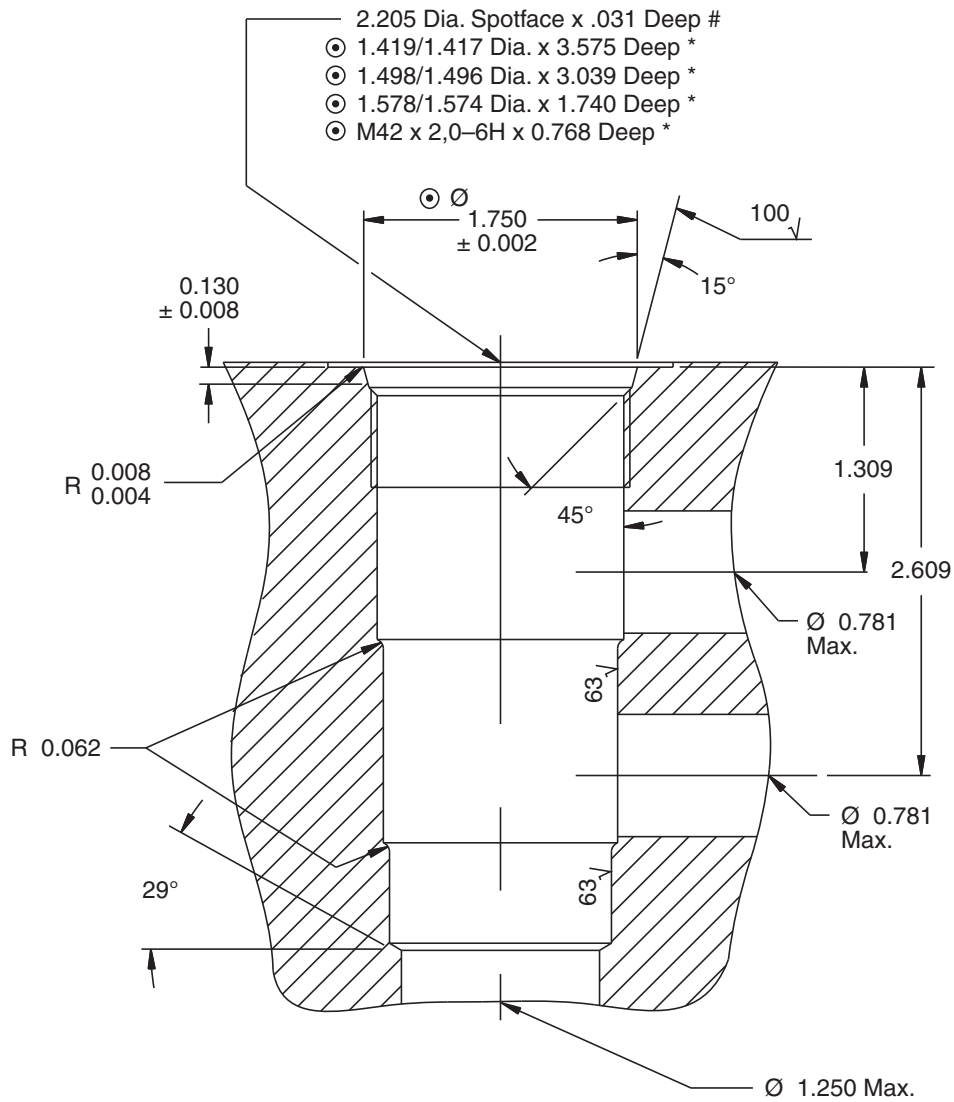
		0.001 [0,025]	A		
		0.002 [0,05]	B		
- $\odot \odot$ -

		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 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

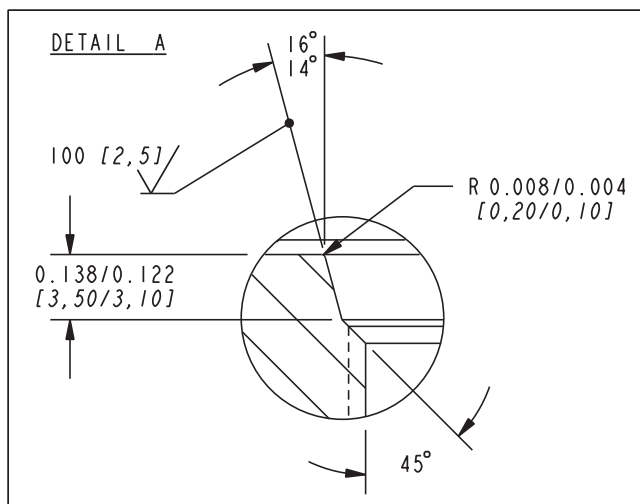
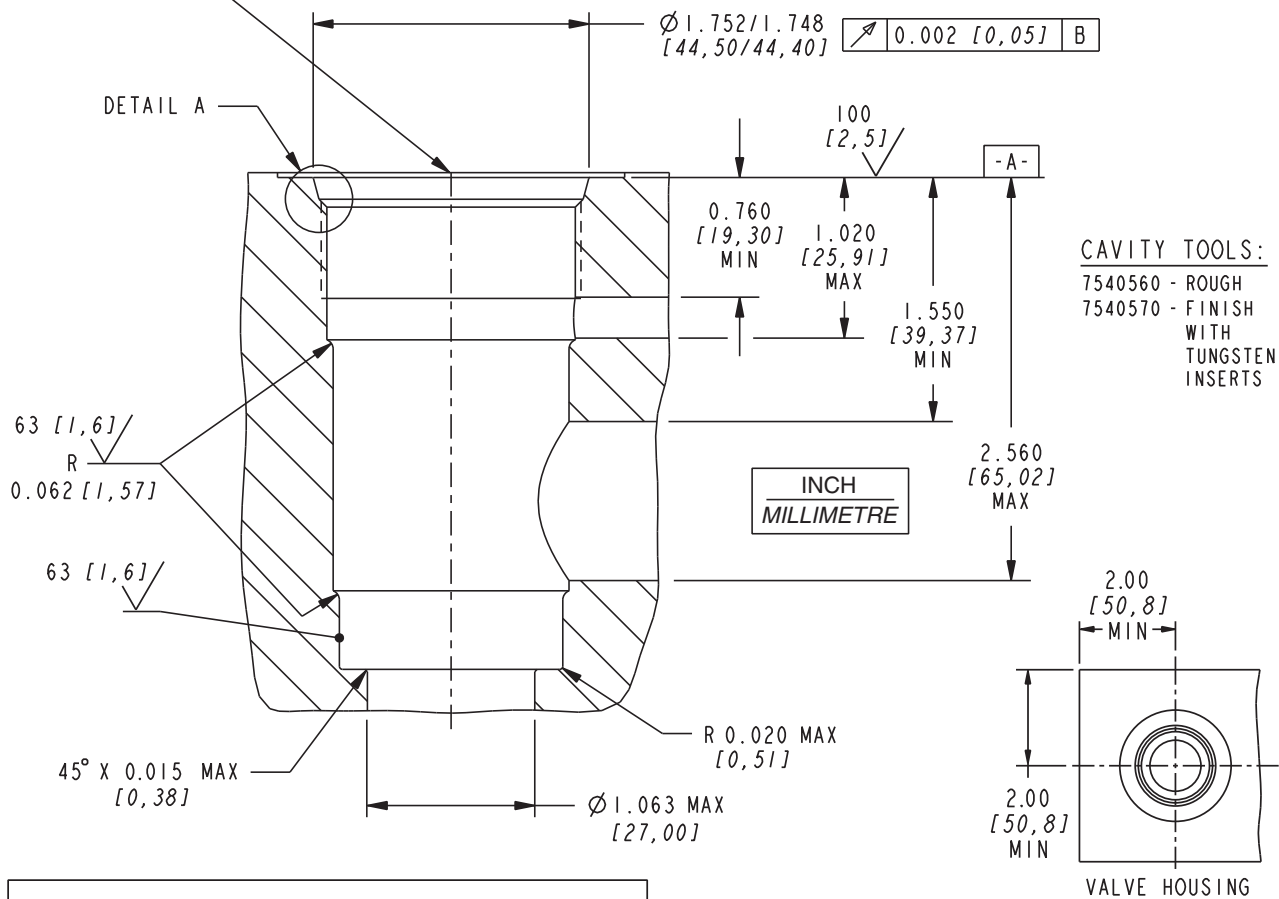
Unspecified tolerances are ±0.005.

Series 42 Cartridge Cavities

HVC42-S3

- Ø 2.320 [58,93] SPOTFACE X 0.031 [0,79] DEEP #
- ⊙ Ø 1.419/1.417 [36,04/35,99] X 3.126/3.122 [79,40/79,30] DEEP *
- ⊙ Ø 1.498/1.496 [38,04/38,00] X 2.625 [66,68] DEEP *
- ⊙ Ø 1.578/1.574 [40,08/39,98] X 1.031 [26,19] DEEP *
- ⊙⊙ M42 x 2,0-6H x 0.768 [19,51] DEEP *

-B-



⊙ -		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

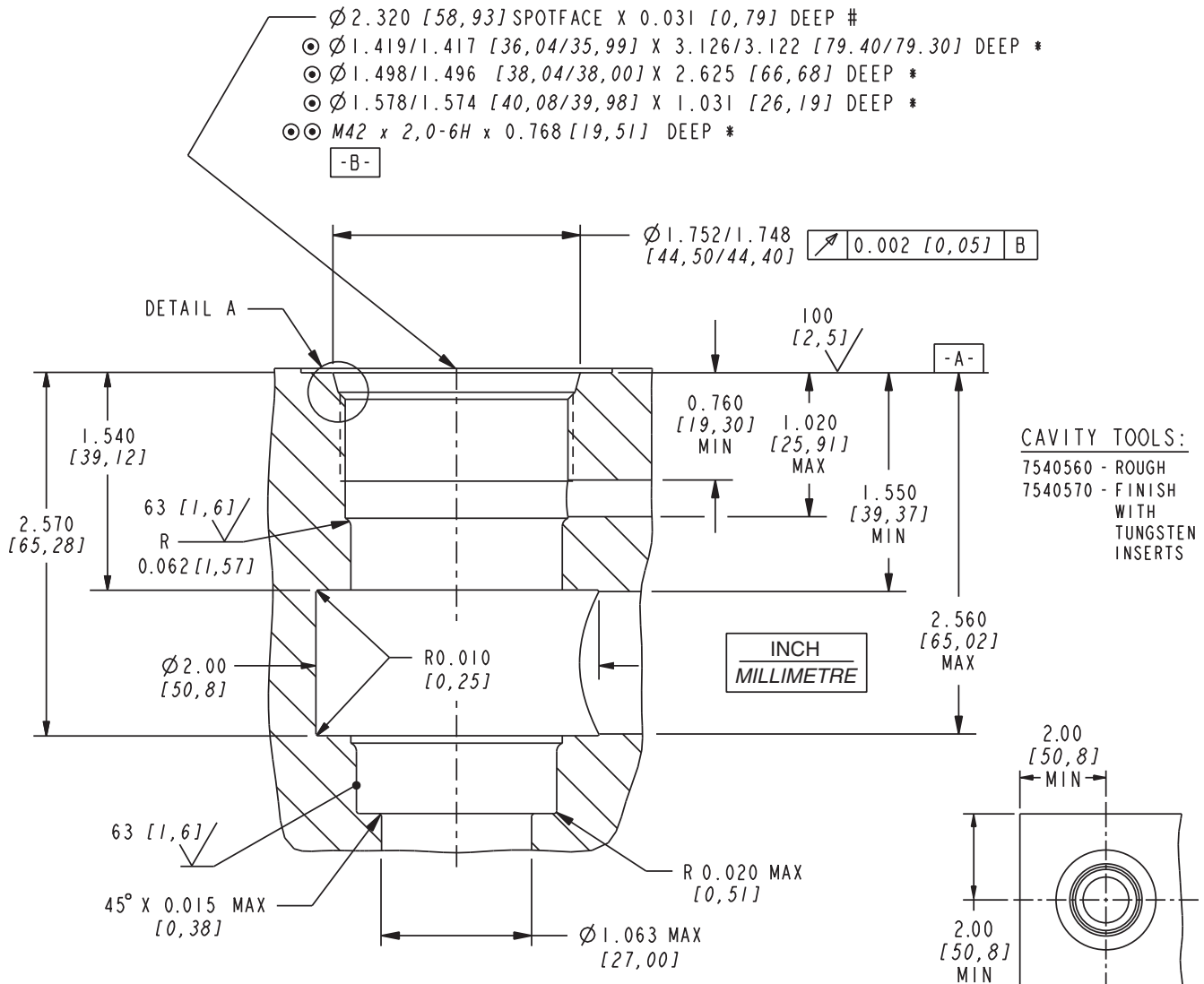
- UNSPECIFIED TOLERANCES ARE ±0.005 [0,13]

- UNSPECIFIED ANGULAR DIMENSIONS ±3°

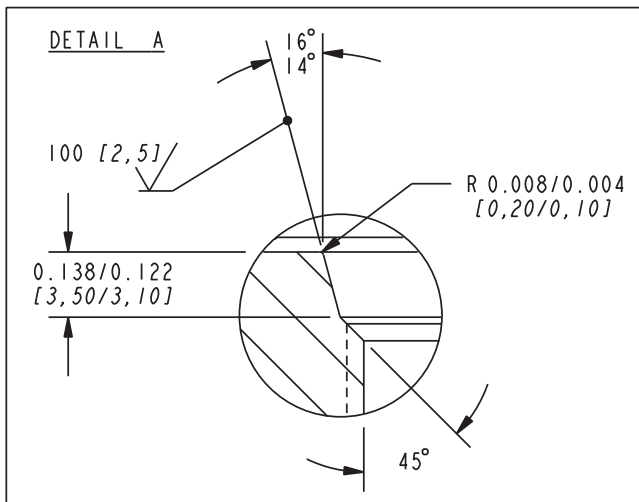
- SURFACE FINISH SPECIFICATIONS ARE IN MICROINCHES [MICROMETERS]

Series 42 Cartridge Cavities

HVC42-S3A



CAVITY TOOLS:
 7540560 - ROUGH
 7540570 - FINISH
 WITH
 TUNGSTEN
 INSERTS



- \odot -

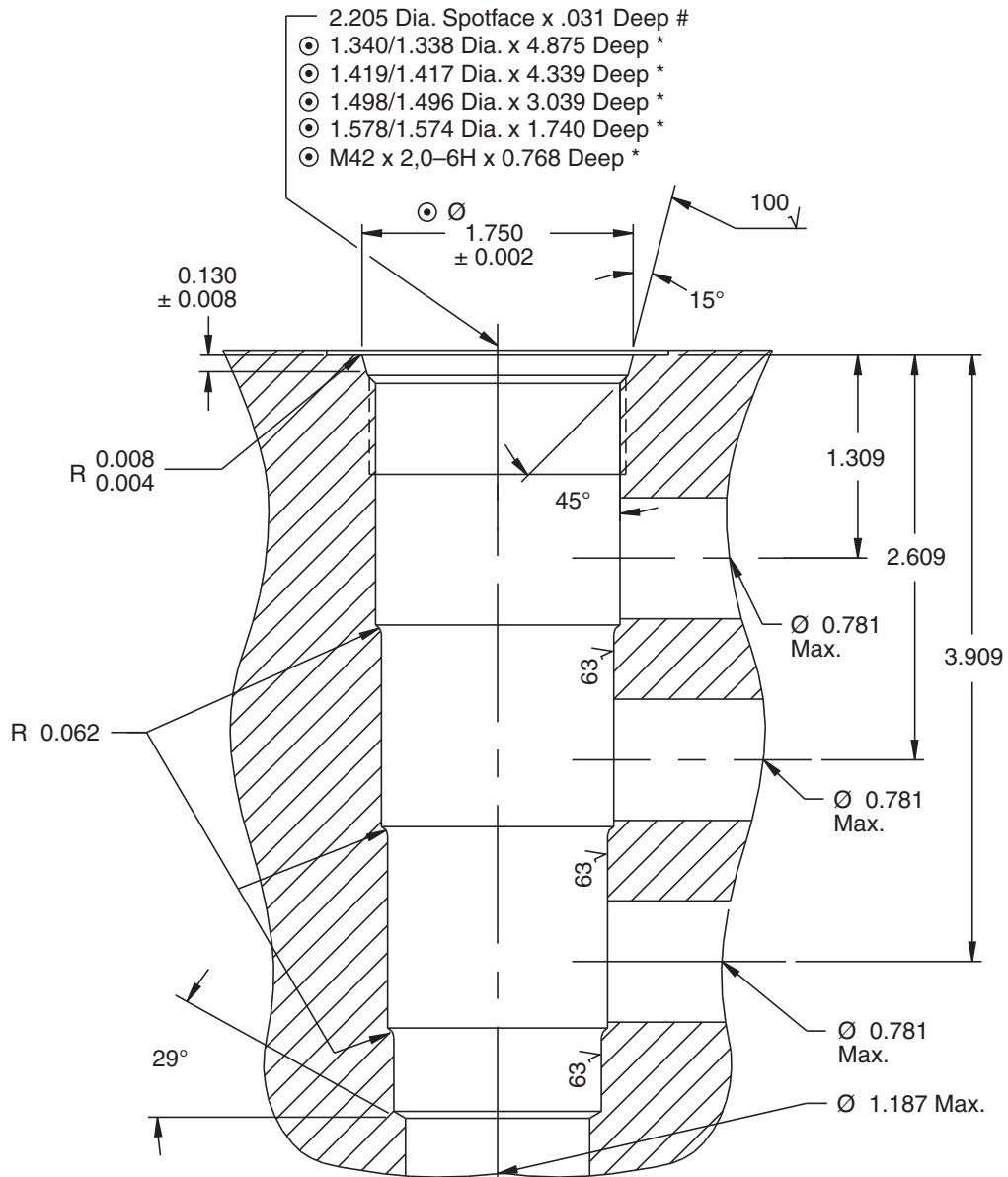
	0.001 [0,025]	A
	0.002 [0,05]	B
- $\odot \odot$ -

	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 42 Cartridge Cavities

VC42-M4



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

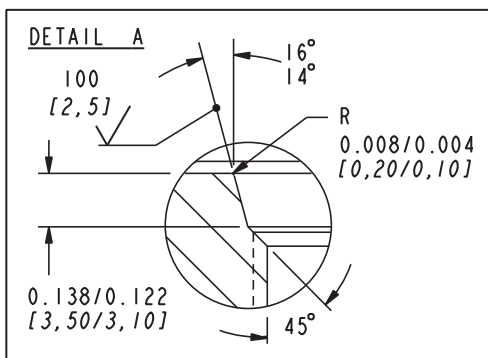
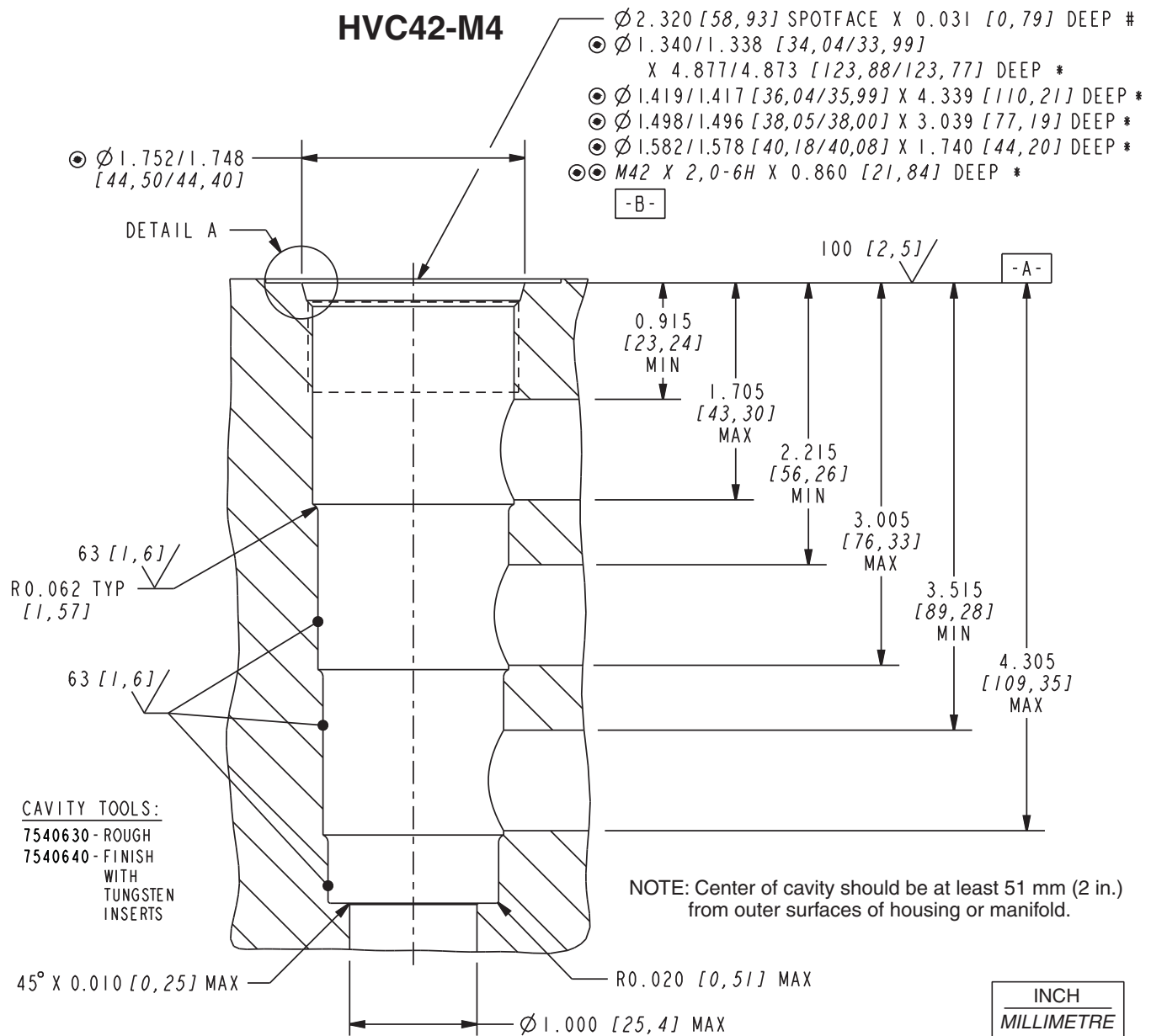
⊙ — These diameters to be concentric within 0.002 T.I.R. and perpendicular to spotface within 0.001 T.I.R.

* — Depths are from spotface.

— Unless otherwise specified on machining drawing

Unspecified tolerances are ±0.005.

Series 42 Cartridge Cavities

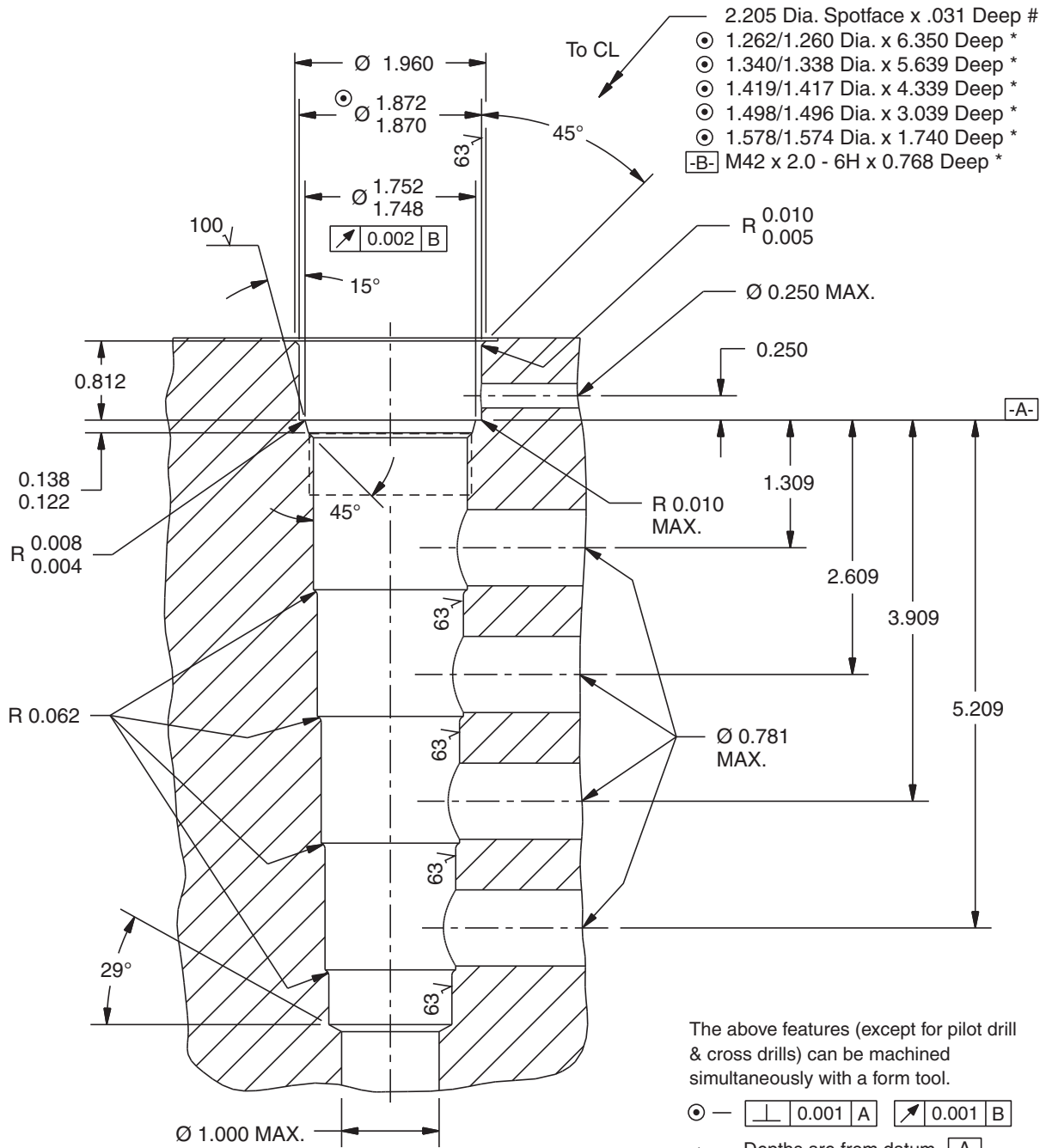


\odot	\perp	0.001 [0,025]	A	$\odot \odot$	\perp	0.001 [0,025]	A
	∇	0.002 [0,05]	B		\circ	0.0009 [0,023]	(PITCH DIA)

- * - DEPTHS ARE FROM DATUM -A-
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING
- UNSPECIFIED TOLERANCES ARE $\pm 0.005 [0,13]$
- 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-S6



- 2.205 Dia. Spotface x .031 Deep #
- ⊙ 1.262/1.260 Dia. x 6.350 Deep *
- ⊙ 1.340/1.338 Dia. x 5.639 Deep *
- ⊙ 1.419/1.417 Dia. x 4.339 Deep *
- ⊙ 1.498/1.496 Dia. x 3.039 Deep *
- ⊙ 1.578/1.574 Dia. x 1.740 Deep *
- [-B-] M42 x 2.0 - 6H x 0.768 Deep *

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

⊙ — \perp 0.001 A \nearrow 0.001 B

* — Depths are from datum [-A-]

— Unless otherwise specified on machining drawing.

Unspecified tolerances are ± 0.005 .

