**Series 08 Cartridge Cavities**

**VC08-2**
- 1.188 SPOTFACE x 0.031 DEEP #
- 0.502/0.500 x 1.156 DEEP •
- 0.690/0.686 x 0.750 DEEP •
- 3/4-16 UNF-2B x 0.500 DEEP •

**VC08-3**
- 1.188 SPOTFACE x 0.031 DEEP #
- 0.564/0.562 x 1.703 DEEP •
- 0.627/0.625 x 1.270 DEEP •
- 0.690/0.686 x 0.718 DEEP •
- 3/4-16 UNF-2B x 0.500 DEEP •

**NOTE:**
- CAVITY VARIATION "A"**
- PILOT DRILL Ø 0.469 MIN. REQUIRED TO MIN. DEPTH OF 1.32 FROM SPOTFACE

**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 ±3°.

**FEATURES OF VARIATION "A" ARE ONLY REQUIRED IF NOTED ON A SPECIFIC PRODUCT CATALOG PAGE.**
**Series 08 Cartridge Cavities**

![Diagram of HVC08-2 Cartridge Cavity]

**NOTES:**

- 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].
- FEATURES OF VARIATION ‘A’ ARE ONLY REQUIRED IF NOTED ON A SPECIFIC PRODUCT CATALOG PAGE.
**Series 08 Cartridge Cavities**

**HVC08-3**

**NOTES:**

- " 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].
- "Features of variation 'A' are only required if noted on a specific product catalog page.

**Valve Housing Detail**

Scale: 1:1
VC08-PCV

1.188 Dia. Spotface x .031 Deep #
① .5005/.5020 Dia. x 2.19 Deep *
② .686/.690 Dia. x .750 Deep *
③ 3/4-16UNF-2B x .500 Deep *

Max. Piston Travel

Dimensions are typical of other end.

VC08-DCV

1.188 Dia. Spotface x .031 Deep #
① .5005/.5020 Dia. Thru
② .686/.690 Dia. x .750 Deep *
③ 3/4-16UNF-2B x .500 Deep *

Notes:
① 1. These Diameters to be Concentric within .002 T.I.R. and Perpendicular to Spotface within .001 T.I.R.
② 2. Depths are from Spotface.
③ 3. Unspecified Tolerances are .005.
④ 4. Unless Otherwise Specified on Machining Drawing
⑤ 5. All Dimensions shown in inches unless otherwise noted.

Cavity features (except for pilot drill and cross drills) can be machined simultaneously using HydraForce form tools. Consult factory.
**Series 08 Cartridge Cavities**

**VC08-4**

- Ø1.188 Spotface x 0.031 Deep
- Ø0.502/0.500 x 2.210 Deep
- Ø0.564/0.562 x 1.830 Deep
- Ø0.627/0.625 x 1.270 Deep
- Ø0.690/0.686 x 0.718 Deep
- 3/4-16 UNF-2B x 0.500 Deep

**VC08-5**

- Ø1.188 Spotface x 0.031 Deep
- Ø0.439/0.437 x 2.770 Deep
- Ø0.502/0.500 x 2.390 Deep
- Ø0.564/0.562 x 1.830 Deep
- Ø0.627/0.625 x 1.270 Deep
- Ø0.690/0.686 x 0.718 Deep
- 3/4-16 UNF-2B x 0.500 Deep

**NOTES:**
- THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL AND CROSS DRILLS) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.
- Ø - 0.001 A
- Ø - 0.001 A
- Ø - 0.002 B
- Ø - 0.0009 (PITCH DIA)
- " DEPTHS ARE FROM DATUM A.
- # UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ±0.005.
- UNSPECIFIED ANGULAR DIMENSIONS ±3°.