

DATE LISTED	10-27-42
DATE COMPLETED	10-27-42
ENG. DESIGNED	LIO 9 1031-92
ENG. CHECKED	LYO 3454-33-42
DATE	11-1-43

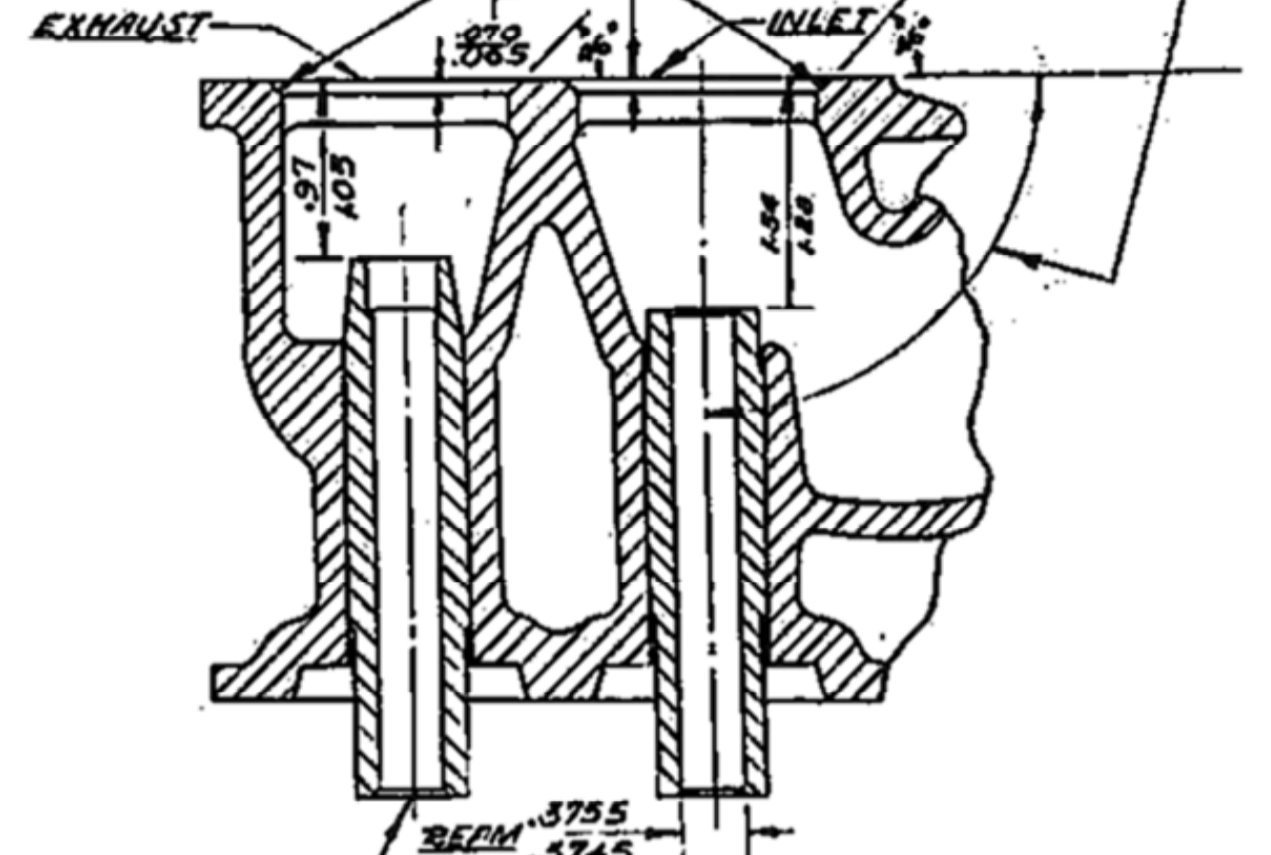
$\frac{5}{16}$ DRILL CHAMFER $0.6 \times 45^\circ$
 $\frac{1}{8}$ 16 USE THRD .56 DEEP
 FD. 3399-3359
 7 HOLES

VALVE SEATS TO BE CONCENTRIC WITH GUIDE HOLE TO TOTAL INDICATOR READING OF .002 VALVE SEATS MUST BE SMOOTH AND FREE FROM CHATTER MARKS

GUIDE HOLES TO BE SQUARE WITH TOP SURFACE WITHIN .001 PER INCH OF GUIDE LENGTH

SEE SHEET NO. 3 FOR SECTION B

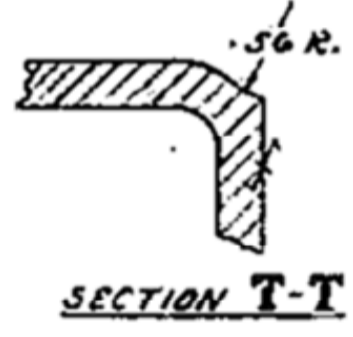
SECTION D-D SEE SHEET NO. 3



SECTION THRU VALVES

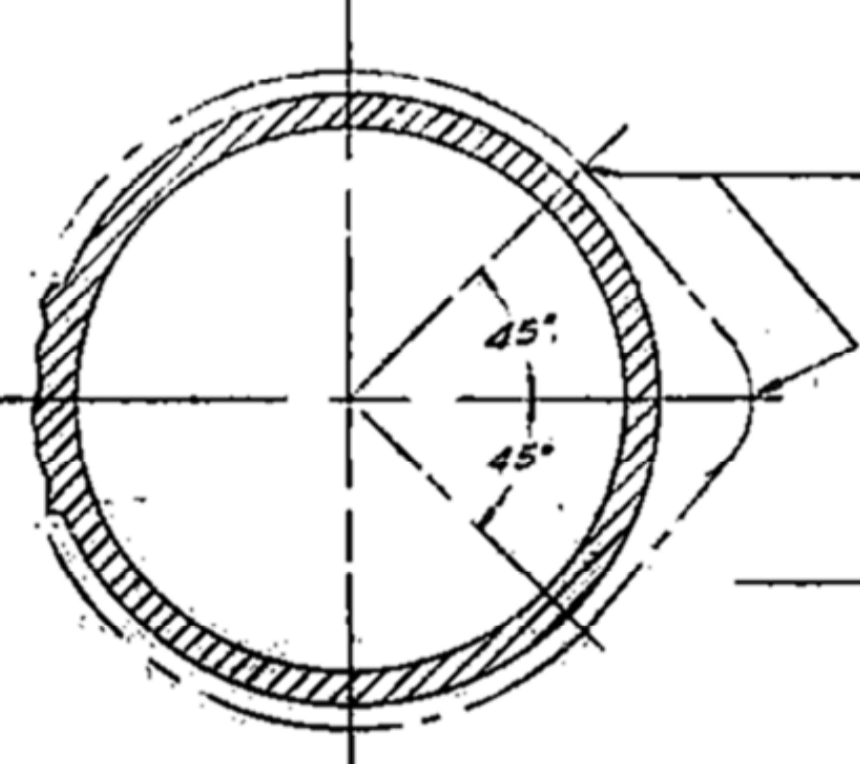
VALVE GUIDE HOLE TO BE HELD WITHIN TOLERANCES SPECIFIED AND MUST NOT BE BELLMOUTHED OR BARRELED

DRILL F (237-263) .625 DEEP
 CHAMFER .06 X 45°
 TAP $\frac{1}{8}$ 16 THD INC. .50 DEEP
 FD. 2764-2779
 2 HOLES

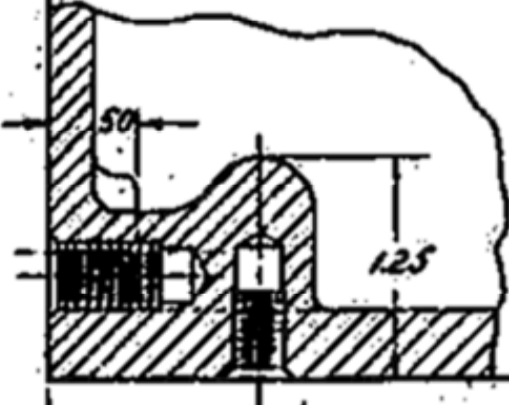


SECTION T-T

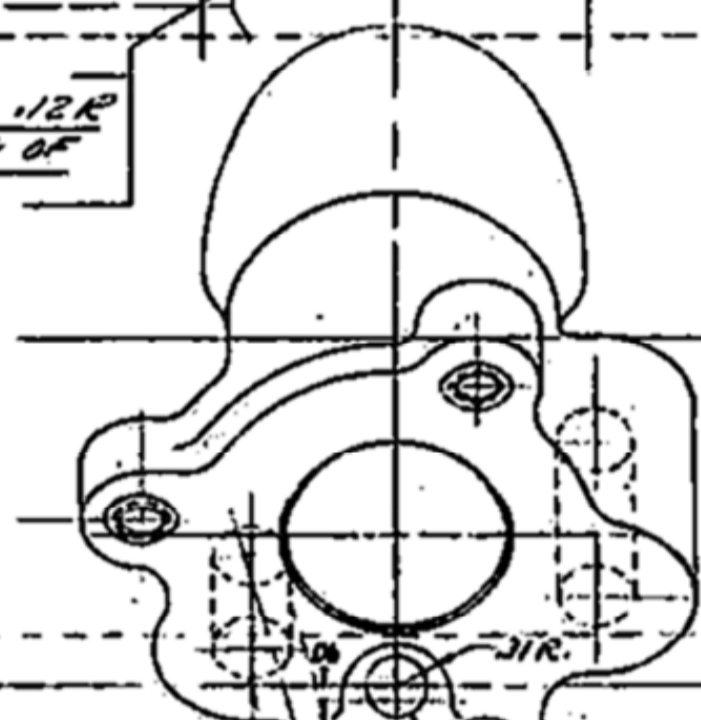
.50 R BLENDS TO .12 R AT 45° EACH SIDE OF CENTER



SECTION E1-E1



SECTION R-R SEE SHEET NO. 4

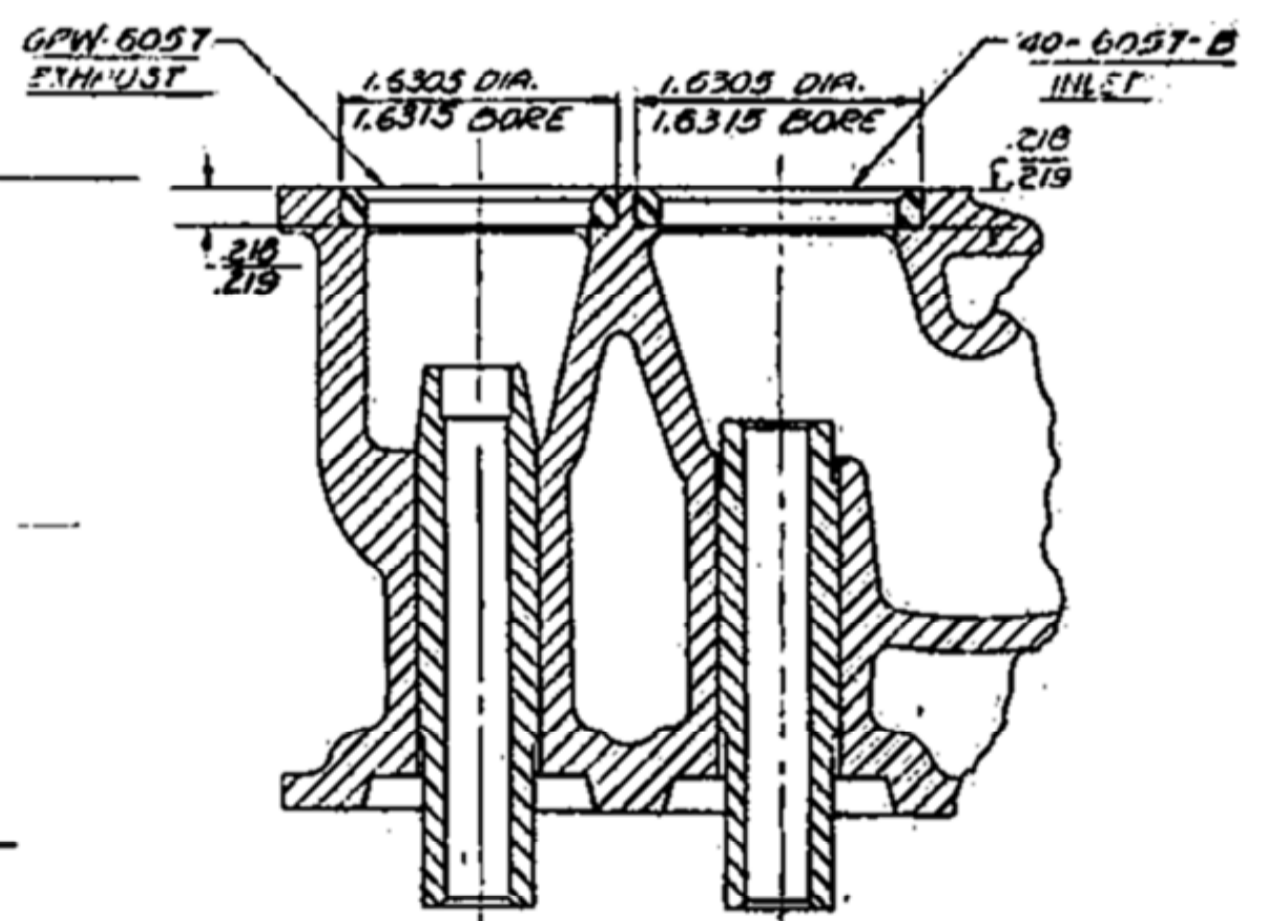


CRANK SHAFT

$\frac{11}{32}$ DRILL - .456 DEEP

$\frac{11}{32}$ DRILL - .200 DEEP
 DRILL $\frac{1}{8}$ THRU
 TAP $\frac{1}{8}$ ALL STANDARD
 TAPER PIPE TAP
 2 INTERMEDIATE BEARINGS

$\frac{11}{32}$ DRILL - .394 DEEP
 TAP $\frac{1}{8}$ ALL STANDARD TAPER
 PIPE TAP
 FRONT & REAR BEARINGS



VIEW SHOWING VALVE SEAT INSERTS TO BE USED AS EQUIPPED TO CALIBRE CYLINDER BLOCKS WITH SAND HOLES ON VALVE SEAT MACHINING TO DIMENSIONS SHOWN IN SECTION VIEW AT TOP OF THIS DRAWING

CYLINDER BLOCK

GRADE "A" CAST IRON
 BRINELL 170 MIN TAKEN ON CYLINDER BORES
 BRINELL 220 MAX TAKEN ON OIL PAN FLANGE

GPW-6015

ALLOWABLE VARIATION OF DIMENSIONS CONTROLLING FINISHED SURFACE IS .002 UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS IN INCHES

SHEET NO. 2 OF 6 SHEETS

SECTION	SCALE	QUANTITY	DATE	BY
FULL	1/2" = 1"	1	10-27-42	LIO

(11) 638632

GPW-6015