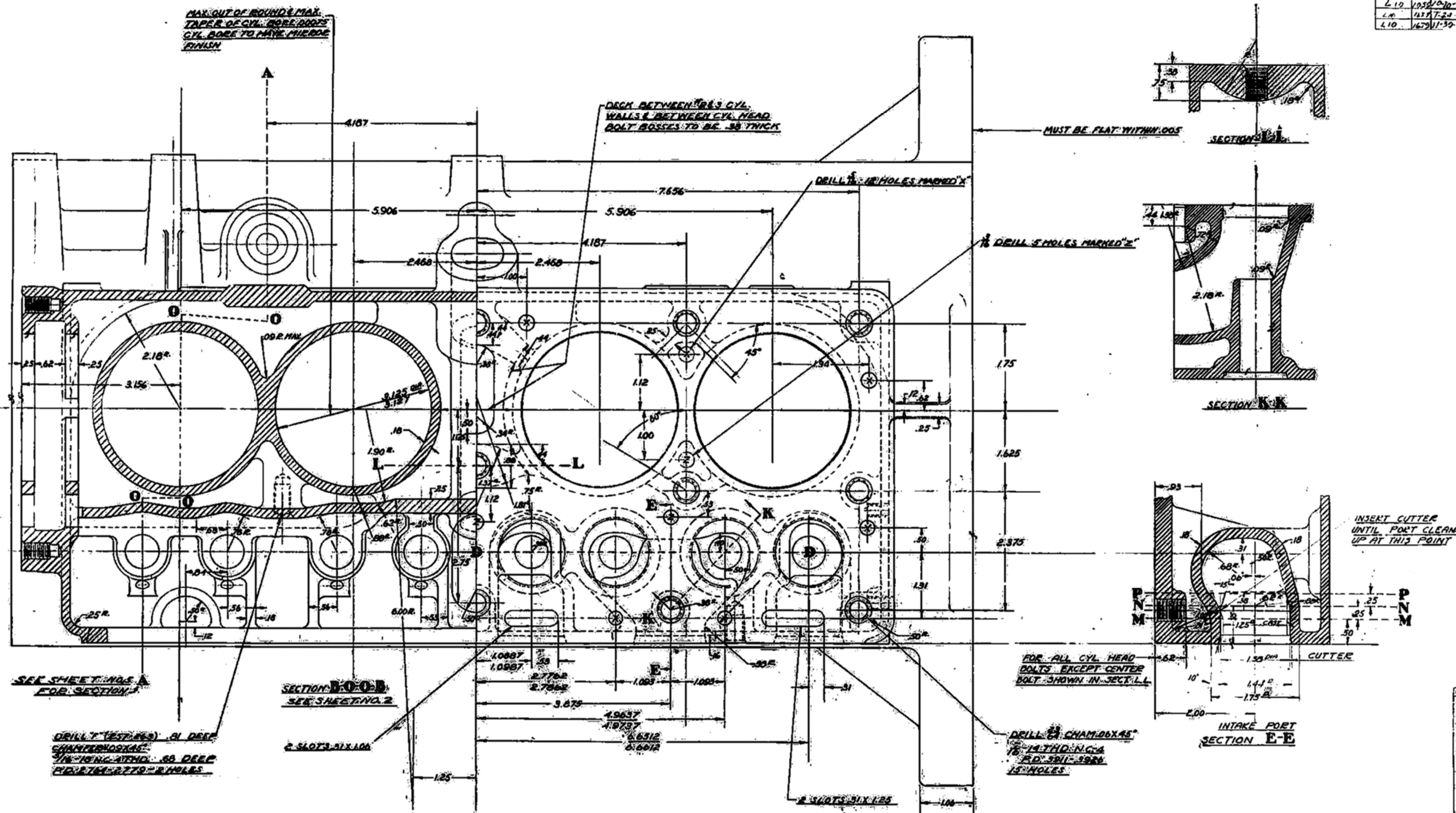


REV.	DATE	BY	CHK.
L.D.	10-31-41		
L.10	11-2-42		
L.10	10-10-43		
L.A.	11-7-44		
L.10	11-30-44		



SEE SHEET NO. 1 FOR SECTION A-A

SECTION B-B SEE SHEET NO. 2

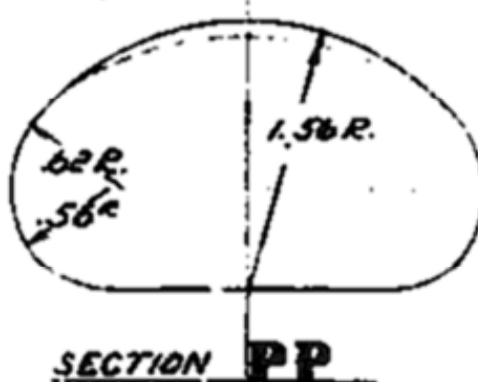
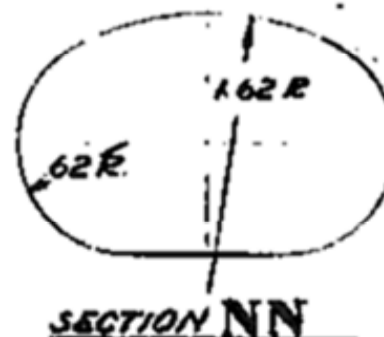
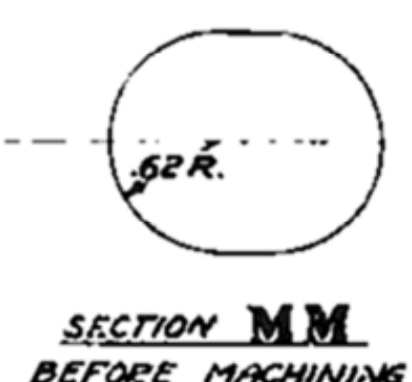
DRILL (TESTED) .01 DEEP CHAMFER .00045" IN 10" LONG AT HD. .60 DEEP REPT. TO .2770" R HOLES

2 SLOTS SIX 1.00

FOR ALL CYL. HEAD BOLTS EXCEPT CENTER BOLT SHOWN IN SECT. L-L

DRILL CHAMFER .00045" IN 10" LONG AT HD. .60 DEEP REPT. TO .2770" R HOLES

INSERT CUTTER UNTIL PORT CLEAN UP AT THIS POINT



CYLINDER BLOCK
GRADE A CAST IRON
SPINELL 170 MIN. TAKEN ON CYLINDER BORES
SPINELL .003 MAX. TAKEN ON OIL PAN FLANGE
SHEET 5 OF 6 SHEETS

GPW-6015

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

(11) 638632

DESIGN	SCALE	DRAWN BY	CHK. BY	DATE

GPW-6015