BEGIN. STARTED		10-13-41
BEGIN. COMPLETED		10-20-41
LINE NO.	QUAN.	REVISED
L10	9	10-31-41
L10	59	12-20-41
L10	99	1-13-42
L10	345	4-29-42
L10	979	7-2-42
L10	1464	7-8-42

MUST BE CONCENTRIC WITH VALVE STEM GUIDE BORE WITHIN ½ INDICATOR READING

BREAK CORNER .010-.025

7.125

2.880 / 2.870

1.812

1.312 / 1.275 / 1.283

.34 .25 .06 .38 .087 / .090 .44 .76 .08R .75 .31 1.R .31 R .18R .656R 1.12 .125 .12

1.250 / 1.233 ACME

1.220 / 1.200

.32° .18 .75 R .81R ⅞ DRILL .38 .50R

3.38 2.38 2.18 .31R .655 D. .656 .25 R .10 .12R DIA. .31 1.50 1.312 3.50 6.562 3.50 13.572 / 13.562 15.812

½ DRILL-8 HOLES .48° .50R 45° .68R .81 1.31 / 1.10

3.22 BURNISH .185 OFFSET .625 / .626R .50R .68R .12R .25 .25R .25 R .20° .60° 1.62 1.44R 1.62R 4.7998 / 4.8048 CHAM. .60 X .74 DIA. .3R 1.0 3.75 1.81 .50 .88 2.247 / 2.252 40°

1.250 D / 1.252 .38 .12R 2.44R 45° 2.18 .68 .12R 5.44 5.12 7.22 .18 3.38R 1.68R 2.62R .25 .46 2.81R .12R .45° .25 .31 .98

SECTION XX

4.88 .25 R 4.88

2.25 .50R 1.38

SECTION A-0000-A
SEE SHEET NO.3

SECTION YY

1.250 / 1.252 3/16 DRILL .03125° CHAMFER

1.62 3.24 45° .68R .50R .75 1.50 .12R .38

SECTION J-J

3.253 / 3.255 1.06R .30° 8.0 1.12 1.0 .68 .97R 1.25R 1.343 / 1.347 .40° 1.093 .39R .25° 1.437 1.426 .97R 1.437 1.50 1.00R .58R 1.18 1.182 .25R .38R 1.12 .39R .12 .56R .25R 1.13° 19°-7' .50 .38R .56R

7/16 DRILL-1.38 DEEP

7/16-DRILL .81 DEEP

DRILL "F" (257) .62 DEEP CHAM. .06X45° TAP ⅝-18 N.C.-4 .50 DEEP P.D. .2764-.2779 - 3 HOLES.

SECTION UU

NUST PRESS FIRMLY IN PLACE

GPW-6022

.12 MAX. WALL

VIEW SHOWING OIL PUMP BODY PILOT BUSHING FOR SALVAGE CYL. BLOCKS

SEE SHEET NO.1 FOR SECTION F

⅝ DRILL THRU.

1 3/32 DRILL-2.25 DEEP 1.062 - 1.064 REAM 1.68 DEEP

.82R .50R .38R .31 1.22 .88R .39R 7.18 .25 .25R 1 DIA. .203

DRILL 1 3/32 - ⅞ DEEP CHAMFER .06 X 45° TAP 1-20 THD. N.C.-2. .50 DEEP P.D. .2175-.2211

THIS THICKNESS OF RIBS EACH SIDE OF CENTER OF BLOCK ONLY

.32 12.250 / 12.235

MUST BE FLAT AND SMOOTH

VERT. TO CYL. BLOCK

.10 1.0 .38R .62 1.62 5.0 .56 .35° 3.72 .56

¼ DRILL .94 DEEP CENTER BEARING

11/32 DRILL-2.44 DEEP TAP ⅛ AM STD. TAPER PIPE THD.

3.56 1.88 1.09 1.25

11/32 DRILL-4.62 DEEP TAP ⅛ AM STD. TAPER PIPE THD.

2.50 3.12 2.50 DRILL-2.50 DEEP

SECTION CC
SEE SHEET NO.2

F

ALL RADII TO BE .12 EXCEPT WHERE SPECIFIED

CYLINDER BLOCK

CAST IRON GRADE "A"

BRINELL 179 MIN. TAKEN ON CYLINDER BORES.
BRINELL 228 MAX. TAKEN ON OIL PAN FLANGE.

SHEET NO.5 OF 6 SHEET

DESIGN	SCALE	DRAWN BY	CHK.	DO NO.	GPW-6015
	FULL	R. FISCHER			

GPW-6015

ALLOWABLE VARIATION ON DIMENSIONS CONTROLLING FINISHED SURFACES ± .010 UNLESS OTHERWISE SPECIFIED. ALL DIMENSIONS IN INCHES.