ENGR. STARTED		10-27-41
ENGR. COMPLETED		10-22-41
ENG. ISS'	DATE	REVISED
L10	9	10-31-41
L10	449	7-2-42
L10	1003	9-12-42
L10	1350	10-2-42
L10	1055	11-10-42
L10	1852	11-17-42

2.998 DIA.
3.008
2.62
2.559
2.565
3.22
2.25
1.562
.250
.18
2.375
.75
1.50
2.62°
1.19°
1.94°
1.69
1.53
.97
1.88°
1.75
2.69°
.10
.50
2.00
.187
30°
30°
.41
.25
.69
.02
.38°
.88
1.69°
.56°
.12°
.38
1.531
.38°
1.312
2.875
5.25
CAST DRILL SPOT IN CENTER OF BOSS
5/16 DRILL - 1.00 DEEP .06 x 45° CHAMFER TAP 3/8 - 16 N.C. 2 THD. .75 DEEP - 4 HOLES P.D. (.3394 - .3369)
FRONT FACE
DRILL "F" (.257 - .263) .75 DEEP - CHAMFER .06 x 45° TAP 5/16 - 18 - N.C. 2 .56 DEEP P.D. (.2764 - .2805) - 4 HOLES
DRILL (.1959 - .2013) THRU 1/4 - 20 - N.C. 4 - THD. P.D. (.2175 - .2190) - 2 HOLES
5/16 DRILL .06 x 45° CHAMFER TAP 3/8 - 16 - THD. 8 HOLES THRU. P.D. (.3344 - .3389) - N.C. - 2 - FOR 3 HOLES MARKED "X" P.D. (.5344 - .5359) - N.C. - 4 - FOR 5 OTHER HOLES
5/16 DRILL THRU 3/8 AM. STANDARD TAPER PIPE TAP .06 DEEPER THAN STANDARD
.19
2.75
.44
.56
1.12
.19
.88
.88°
1.03
5.00
1.38
1.25
1.25
60°
VIEW Z-Z
Z
1.00
Z
2.937
5.156
.38
2.406
.75°
1.906
.31°
.31°
1.69°
AA
AA
4.12
.88
.25
.25
.38°
2.437
.25
.31
1.562
.31
1.562
4.374
4.376
4.62
1.312
3.125
3.125
1.312
4.997
5.003
1/4 DRILL - THRU FRONT BEARING
R
R
1.687
5/16 DRILL - .81 DEEP .06 x 45° CHAMFER TAP 3/8 - 16 N.C. - 4 THD. - .62 DEEP P.D. (.3344 - .3359)
1/4 DRILL
.41
45°
SEE SH. #2
SECTION AA-AA
.12°
SECTION V-V
38
SECTION H-H
SECTION S-S
.56
1.50
.62
2.375
1.125
.62
1.875
.812
5.06
30°
W
2.50
1.375
56°
13/32 DRILL - 2 HOLES
56°
62°
.12
.50
.19°
.44°
V
94°
V
4.50
.25
.94
1.00
.25
S
S
1.50°
.19
2.31°
.10
.40°
H
H
2.44°
.50
7.00
4.687
.687
W
5.12
.53°
SECTION - W - W
.35°
1.69°
.38°
1.31
.25°
1.00°
.62°
.25
.56
27°
.44
.38
.56°
.38
.31
.44
.50°
.09
.12
.14
1.624
1.626
.020
.005
4.374
4.376
ALL CAP SLOTS
.020
.005
27°
.37°
.44
1/4 DRILL - 2.00 DEEP 1/8 DRILL - THRU - REAR BEARING
.31
6.9365
6.9385
6.9365
6.9385
BEAM .3745" - .3750" - 2 HOLES
ALL DRILL TO BE .12 EXCEPT WHERE SPECIFIED

CYLINDER BLOCK

CAST IRON GRADE "A"
BRINELL 179 MIN TAKEN ON CYLINDER BORES
BRINELL 220 MAX TAKEN ON OIL PAN FLANGE

SHEET No. 6 OF 6 SHEETS

GPW 6015

(W) A-630632

DES. BY	SCALE	DRAWN BY	CK.	O.K.	GPW 6015
	FULL				