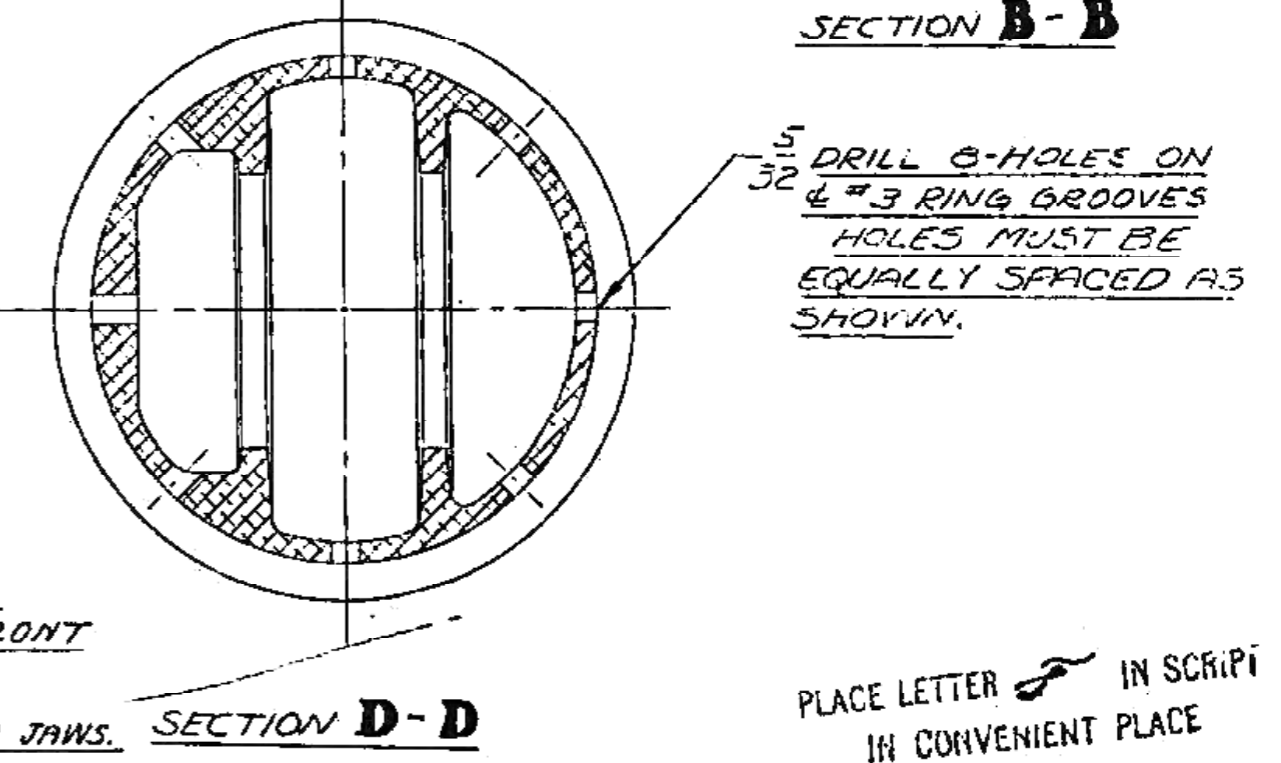
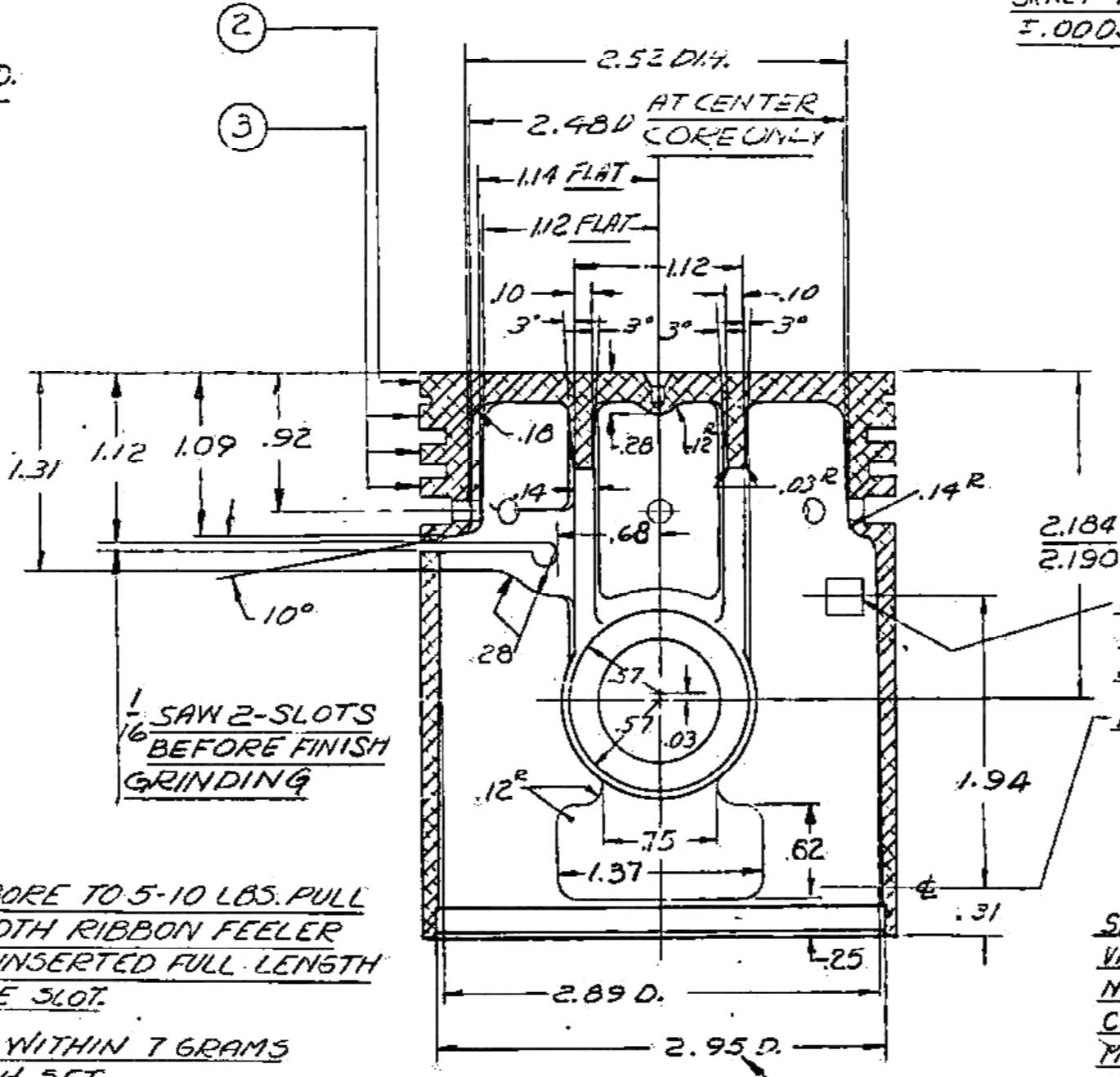
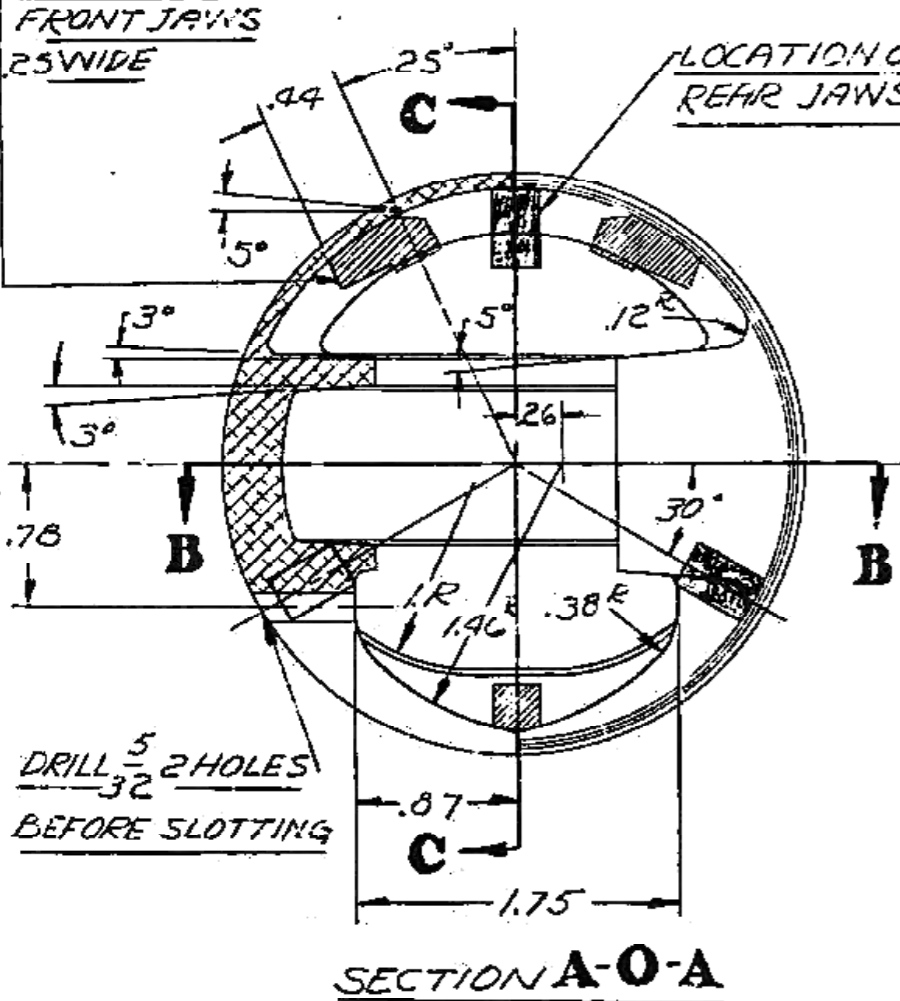
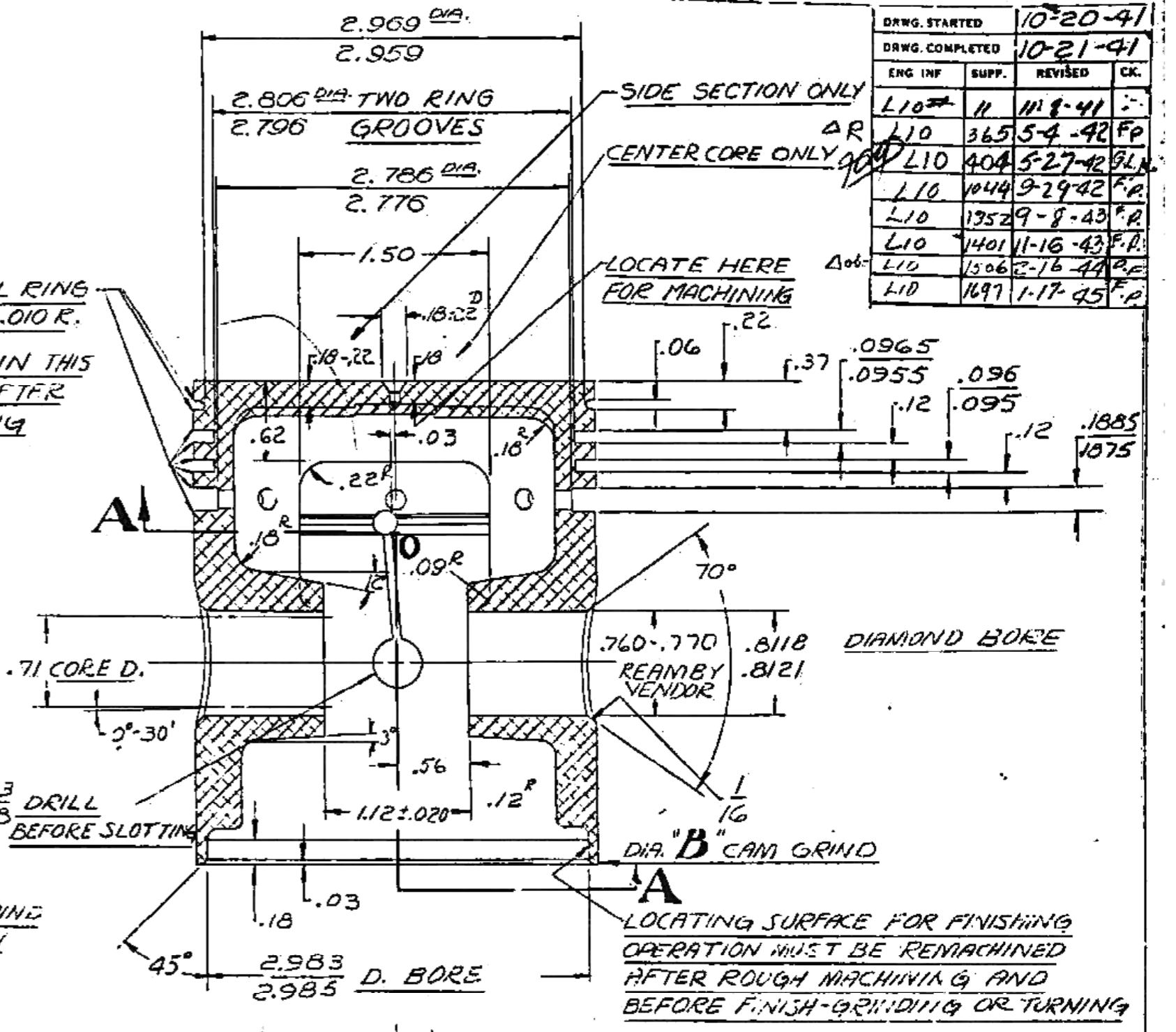
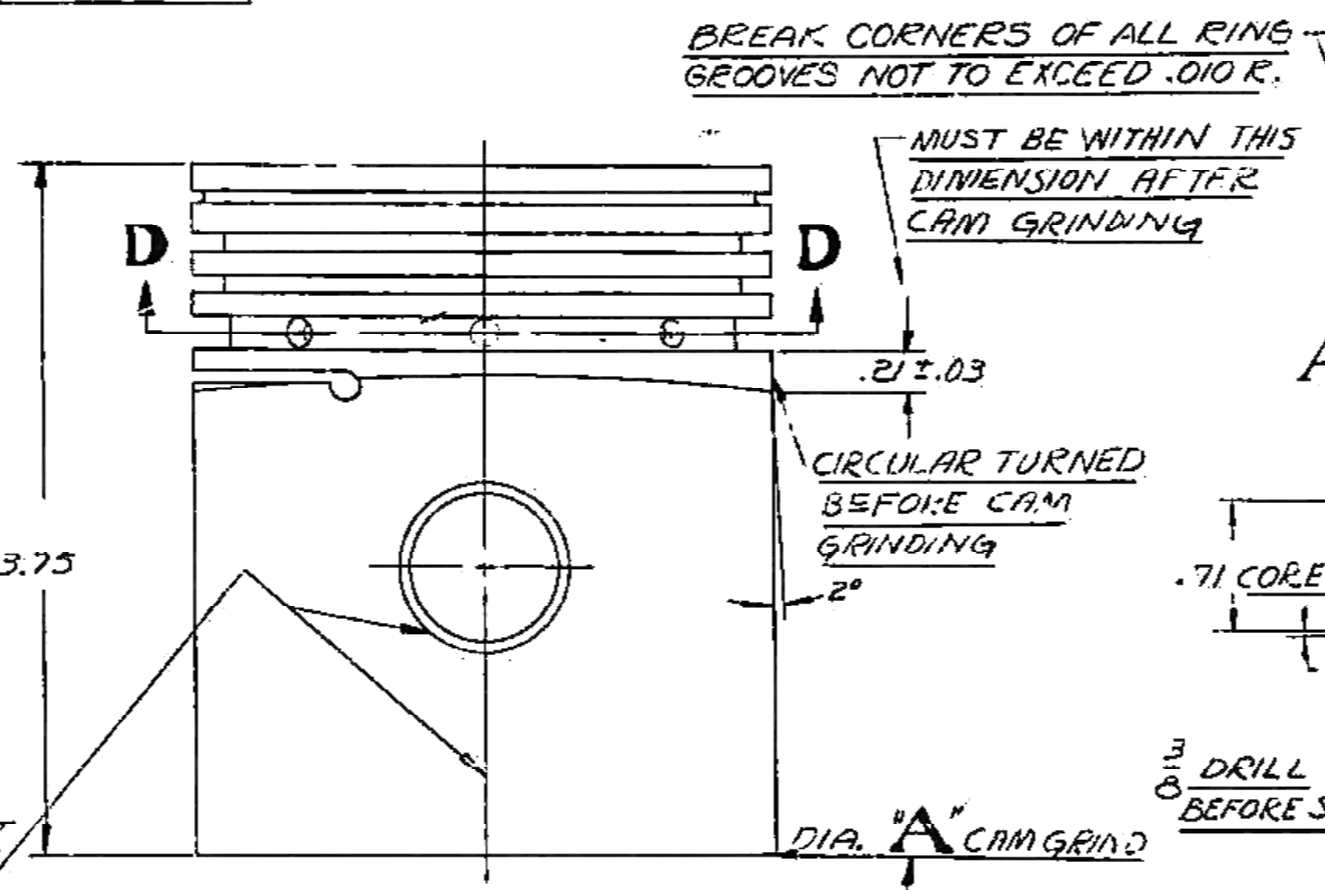
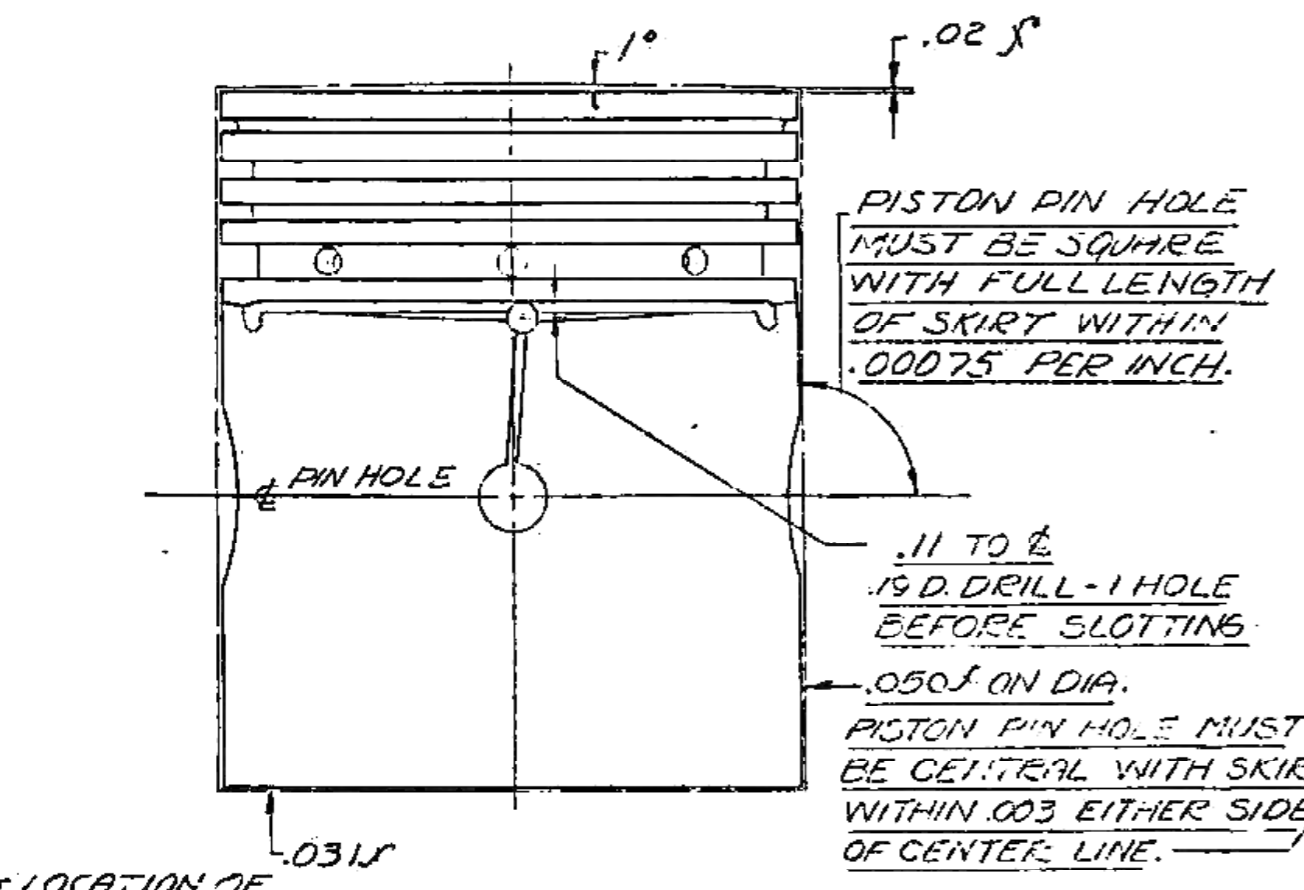


PART NO.	SIZE	A	B	(2)	(3)
GPW-6110-A	STANDARD	3.1225-3.1250	3.1125-3.1145	3.088-3.085	3.111-3.108
GPW-6110-B	.010 OVERSIZE	3.1325-3.1350	3.1225-3.1245	3.098-3.095	3.121-3.118
GPW-6110-C	.020 OVERSIZE	3.1425-3.1450	3.1325-3.1345	3.108-3.105	3.131-3.128
GPW-6110-D	.030 OVERSIZE	3.1525-3.1550	3.1425-3.1445	3.118-3.115	3.141-3.138
GPW-6110-F	.040 OVERSIZE	3.1625-3.1650	3.1525-3.1545	3.128-3.125	3.151-3.148

DRWG. STARTED	10-20-41		
DRWG. COMPLETED	10-21-41		
ENG. INF.	SUPP.	REVISED	CK.
L10	11	11-8-41	
L10	365	5-4-42	FP
L10	1044	9-29-42	FP
L10	1352	9-8-43	FP
L10	1401	11-16-43	FP
L10	1506	2-16-44	FP
L10	1691	1-17-45	FP



- NOTE:
 FINISH MACHINE WEIGHT 373-377 GR.
- GPW-6110-F
 - GPW-6110-D
 - GPW-6110-C
 - GPW-6110-B
 - GPW-6110-A

FIT PISTON IN CYL. BORE TO 5-10 LBS. PULL USING A .75 MIN. WIDTH RIBBON FEELER GAUGE .003 THICK INSERTED FULL LENGTH OF PISTON OPPOSITE SLOT.
 SELECT PISTONS TO WITHIN 7 GRAMS VARIATION IN EACH SET.
 FIT PISTON PIN IN PISTON WHEN DRY TO A LIGHT PUSH FIT AT ROOM TEMP. (APPROX. 70°F) SO THAT THE PIN WILL NOT FALL THRU BY ITS OWN WEIGHT
 ALL SMALL UNMARKED RADII TO BE .06

VANASIL ANALYSIS

SILICON	21-23
VANADIUM	0.10-0.11
NICKEL	2.00-2.25
COPPER	1.00-1.10
MAGNESIUM	0.75-1.25
IRON	0.50 MAX.
ZINC	0.02 MAX.
OTHER IMPUR.	0.025 MAX.
ALUMINIUM	BALANCE
HT. TR. TO B.H.N.	100-130

ALLOY-X-113-152 ANALYSIS

SILICON	5.00-6.00
COPPER	6.00-8.00
IRON	1.50 MAX.
MAGNESIUM	1.5-3.5
TITANIUM	.20 MAX.
BALANCE	ALUMINIUM
IMPURITIES	1.50 MAX.

ALLOY-10-EX SAE. 321 ANALYSIS

SILICON	11.00-13.00
COPPER	.6-1.00
NICKEL	2.25-2.75
IRON	1.25 MAX.
MAGNESIUM	.9-1.2
BALANCE	ALUMINIUM
IMPURITIES	1.50 MAX.

PISTON

TIN PLATE ALL OVER BY IMMERSION PROCESS P-24

ALLOWABLE VARIATION ON DIMENSIONS CONTROLLING FINISHED SURFACES IS $\frac{1}{16}$ UNLESS OTHERWISE SPECIFIED. ALL DIMENSIONS IN INCHES.

(W) 636954

DESIGN	SCALE	DRAWN BY	CR.	O.K.	FORD MOTOR CO.	GPW 6110-A
	FULL	V. ROYALE			DEARBORN, MICH.	