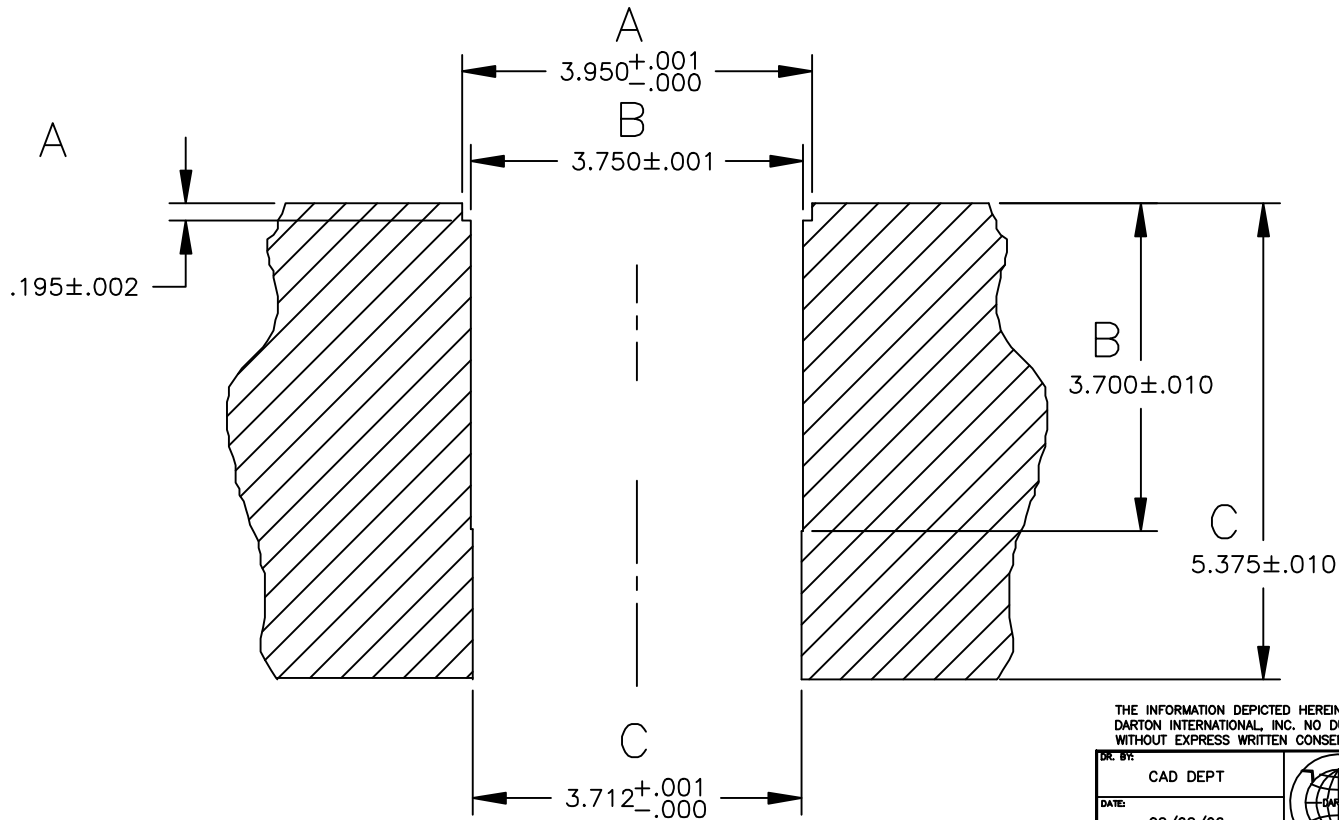


NOTE:

1. PRIOR TO BORING FOR SLEEVE INSTALLATION
BORE EXISTING SLEEVE TO FINISH BORE DIMENSION $\pm .010$
STOPPING AT MAIN BEARING WEB.
2. .000 GAP AT FLATS, DO NOT USE OEM HEAD GASKET
3. APPLY LOCTITE #518 OR #620 TO BLOCK BORE AT C DIMENSION
4. MACHINE DIAMETER B TO BE NET AND A & C
AT .001 CLEARANCE OF SLEEVE
5. MACHINE BLOCK AT BORE CENTER OF 97mm/3.819

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
A	ADDED NOTES 4 & 5	04/08/09	



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DR. BY:	CAD DEPT		Darton International, Inc.	
DATE:	02/02/06		Carlsbad, CA USA	
CHK'D BY:			(800) 713-2786 (760) 603-9895	
MATERIAL:			FAX (760) 603-9629	
HARDNESS:			WWW.DARTON-INTERNATIONAL.COM	
TITLE		BLOCK SPECIFICATION-		
SIZE		NISSAN SR20 86/90mm DRY		
SCALE		300-035	SF DF	REV A
SCALE		NONE	SHEET 1 OF 1	

NOTE:


LOCTITE #518

- TEMP. RANGE: -65 TO 300 DEG. F
- SPECIFIC GRAVITY; 1.13
- CHARACTERISTICS: RIGID, THIXOTROPIC, GENERAL PURPOSE
- COLOR: RED
- FULL CURE: 4 HR.
- FLASH POINT: 212 DEG. F
- BEGINS TO HARDEN: 30 MIN.
- APPLICATION: METAL THREADS, STEEL AND BRASS, FITTINGS, PIPES, VALVES, GAUGES, REFRIGERANT SYSTEMS, STEM
- TYPE: ANAEROBIC
- SUBSTRATES: METAL
- ITEM: GASKET SEALANT
- VISCOSITY: PASTE
- COUNTRY OF ORIGIN: UNITED STATES (SUBJECT TO CHANGE)

LOCTITE #620

- REQUIRES: SECONDARY HEAT CURE AT 356 DEG. F. TO GENERATE HIGH TEMP. RESISTANCE
- SHEER STRENGTH : 3800 (PSI)
- MAX. TEMP.: 450 DEG. (F)
- APPLICATION: SHAFT MOUNT, SLIP FIT
- TYPE: HIGH TEMP.
- FULL CURE: 4 HR.
- COMPOUND TYPE: HIGH VISCOSITY, HIGH TEMP. ADHESIVE
- STANDARDS: CFIA LISTED
- FILLING GAO SIZE: UP TO 0.015"
- PRIMER: N 7649 TO SPEED CURE ON INACTIVE METALS
- ITEM: RETAINING COMPUND
- (USING LOCTITE #620 AS A HEAT TRANSFER MAY MAKE IT DIFFUCULT TO REMOVE SLEEVE)
- (WE DO NOT SUPPLY #620 LOCTITE)

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL

DR. BY:	CAD DEPT		Dart International, Inc.	
DATE:	3.29.18		Carlsbad, CA USA (800) 713-2786 (760) 603-9895 FAX (760) 603-9629 WWW.DARTON-INTERNATIONAL.COM	
CHKD BY:		TITLE:	BLOCK SPECIFICATION-	
MATERIAL:		SIZE:	A	REV:
HARDNESS:		SCALE:	1/2	SHEET 2 OF 2