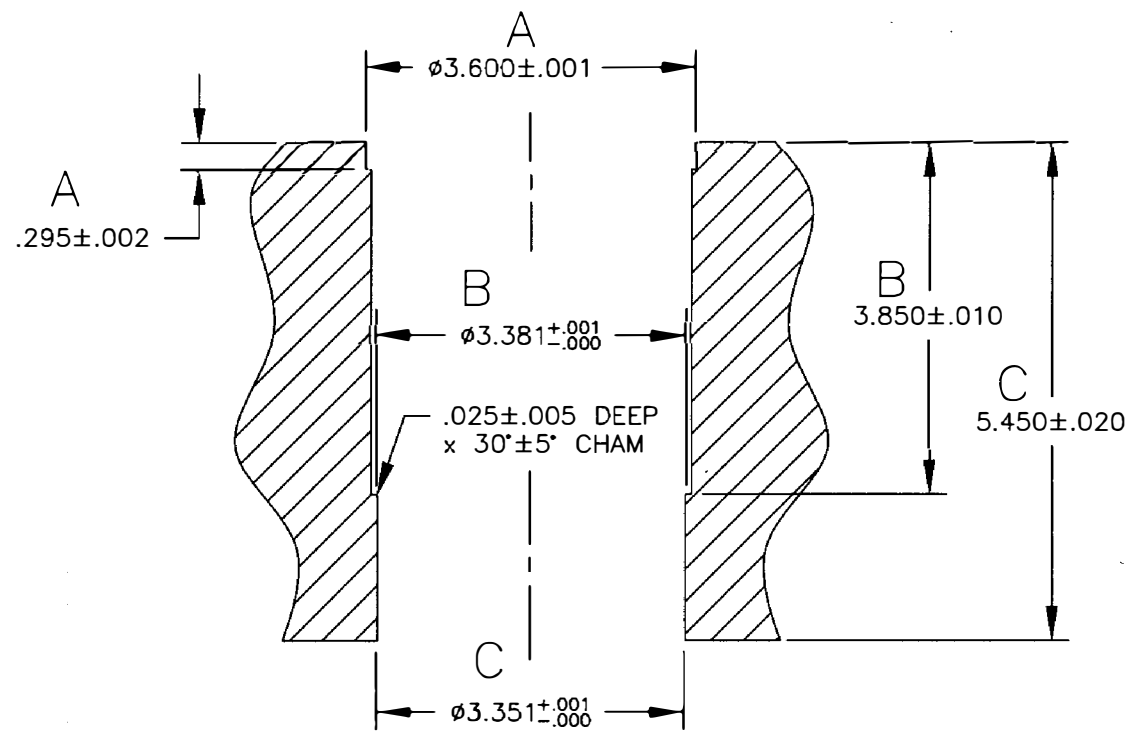


APPROVED


NOTE:

- 1. MACHINE BLOCK BORES A, B, & C TO BE .001 CLEARANCE OF SLEEVE
- 2. MACHINE BLOCK AT BORE CENTER 87.5mm/3.445
- 3. APPLY A SMALL AMOUNT OF LOCTITE #518 OR #620 TO SLEEVE AT B DIAMETER AND TO BLOCK BORE C
- 4. INSTALL AT ROOM TEMPERATURE AND CLAMP SLEEVE DOWN TO DECK UNTILL LOCTITE HAS CURED

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
A	1 .DIA 3.600+0.001/-0.000 WAS DIA 3.530±.0005 2. ADDED SF/DF TO TITLE BLOCK	10/13/07	
B	1. DELETED NOTE 1 & ADDED NOTES 1-4 2. Ø3.381+.001-.000 WAS Ø3.3805+.0005-.0000; Ø3.351+.001-.000 WAS Ø3.3500+.0005-.000	2/2/2010	<i>GC</i>



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DRG BY:	CAD DEPT		Darton International, Inc.		
DATE:	09/29/04		Carlsbad, CA USA		
CHKD BY:		(800) 713-2786 (760) 603-9895			
MATERIAL:		FAX (760) 603-9629			
HARDNESS:		WWW.DARTON-INTERNATIONAL.COM			
TITLE:		CYLINDER SLEEVE- TOYOTA			
SCALE:		1ZZ 79mm-82mm SF/DF			
SIZE:	A	DWG NO.	300-041	REV	B
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

1. MACHINE BLOCK BORES A, B, & C TO BE .001 CLEARANCE OF SLEEVE
2. MACHINE BLOCK AT BORE CENTER 87.5mm/3.445
3. APPLY A SMALL AMOUNT OF LOCTITE #518 OR #620 TO SLEEVE AT B DAIAMTER AND TO BLOCK BORE C
4. INSTALL AT ROOM TEMPERATURE AND CLAMP SLEEVE DOWN TO DECK UNTIL LOCTITE HAS CURED
5. INSTALL SLEEVES AT ROOM TEMPERATURE AND CLAMP SLEEVES DOWN AT DECK UNTIL LOCKTITE HAS CURED, THEN DECK AND HONE
6. NEW BLOCKS NEED TO BE VIBRATORY STRESS RELIEVED PRIOR TO DECKING AND HONING
7. DO NOT PRESSURE WASH BLOCK AFTER INSTALL
8. MAKE SURE NOT TO GET LOCKTITE ON FLANGE AREA

DR. BY:	CAD DEPT		Dartton International, Inc.	
DATE:	4/13/18		Carlsbad, CA USA (800) 713-2786 (760) 603-9895 FAX (760) 603-9829 WWW.DARTTON-INTERNATIONAL.COM	
CHKD BY:		TITLE:	BLOCK SPECIFICATION-	
MATERIAL:			1ZZ TOYOTA 79-82mm	
HARDNESS:		SIZE:	A	DWG NO. 300-041
		SCALE:	1/2	SHEET 2 OF 2