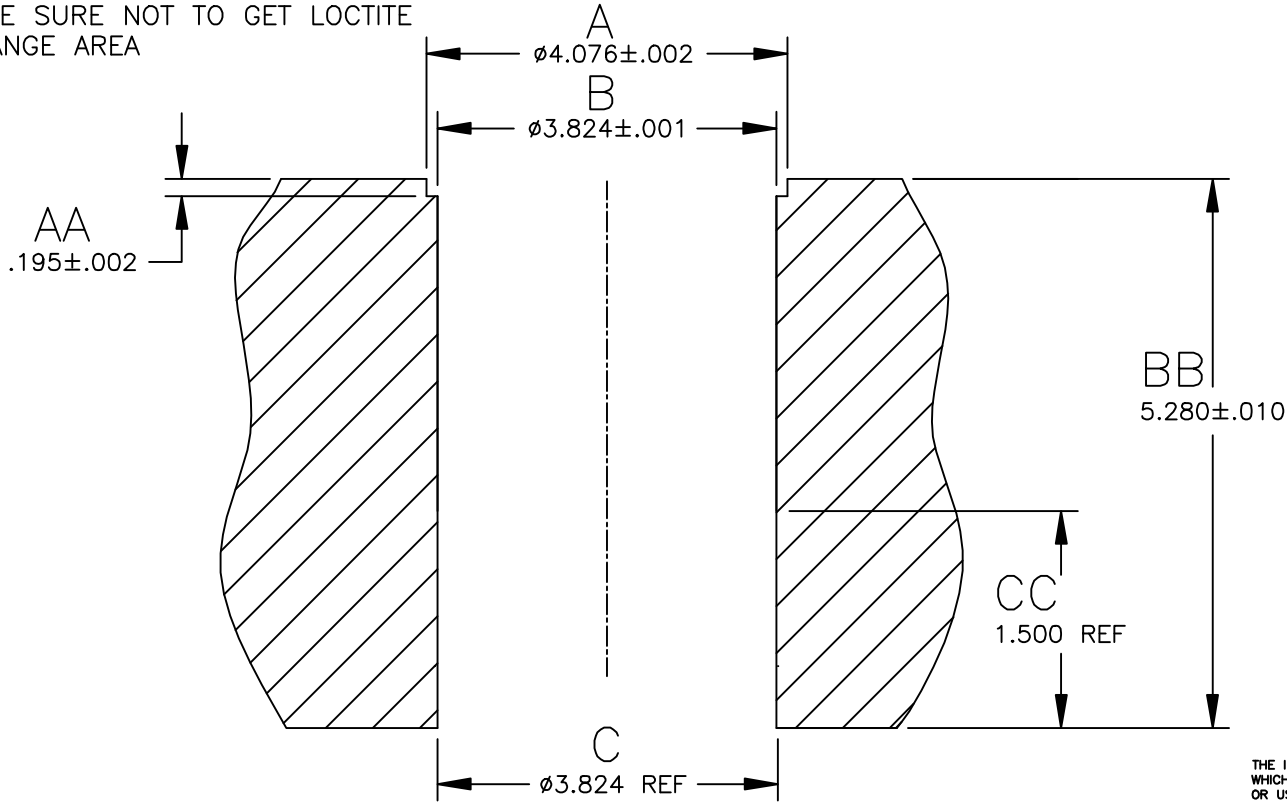


NOTE:


1. MACHINE DIMENSION A AT .001 TO .003 CLEARANCE
2. MACHINE DIMENSION B AT NET TO .0010 PRESS FIT
3. DIMENSION C AT .001 TO .002 CLEARANCE REF.
4. APPLY LOCTITE #518 OR #620 TO BLOCK BORE AT CC DEPTH
5. MACHINE BLOCK AT BORE CENTERS OF 100mm/3.938
6. INSTALL SLEEVES AT ROOM TEMPERATURE AND CLAMP SLEEVES DOWN TO DECK UNTIL LOCTITE HAS CURED 12 HOURS, THEN DECK AND HONE
7. NEW BLOCKS NEED TO BE VIBRATORYSTRESS RELIEVED PRIOR TO DECKING AND HONING
8. DO NOT PRESSURE WASH BLOCK AFTER INSTALL
9. MAKE SURE NOT TO GET LOCTITE ON FLANGE AREA



REVISIONS

REV	DESCRIPTION	DATE	APPROVAL
A	ADDED NOTES 7-9 S1	3/29/18	DLC
A	ADDED SHEET 2	3/29/18	DLC

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DR. BY:	CAD DEPT	 Darton International, Inc. Carlsbad, CA USA (800) 713-2786 (760) 603-9895 FAX (760) 603-9629 WWW.DARTON-INTERNATIONAL.COM
DATE:	3/29/18	
CHK'D BY:		TITLE
MATERIAL:		BLOCK SPECIFICATION-
SIZE:	A	FORD 4.6 TEKSID ALUM SEAL TITE 90/92mm
HARDNESS:		DWG NO. 300-053-SF/DF REV A
SCALE	1/2	SHEET 1 OF 2

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	
CHK'D BY:		TITLE:	BLOCK SPECIFICATION-	
MATERIAL:			FORD 4.6 TEKSID ALUM SEAL TITE 90/92mm	
HARDNESS:		SIZE:	A	REV
		DWG NO.:	300-053-SF/DF	
		SCALE:	1/2	SHEET 2 OF 2