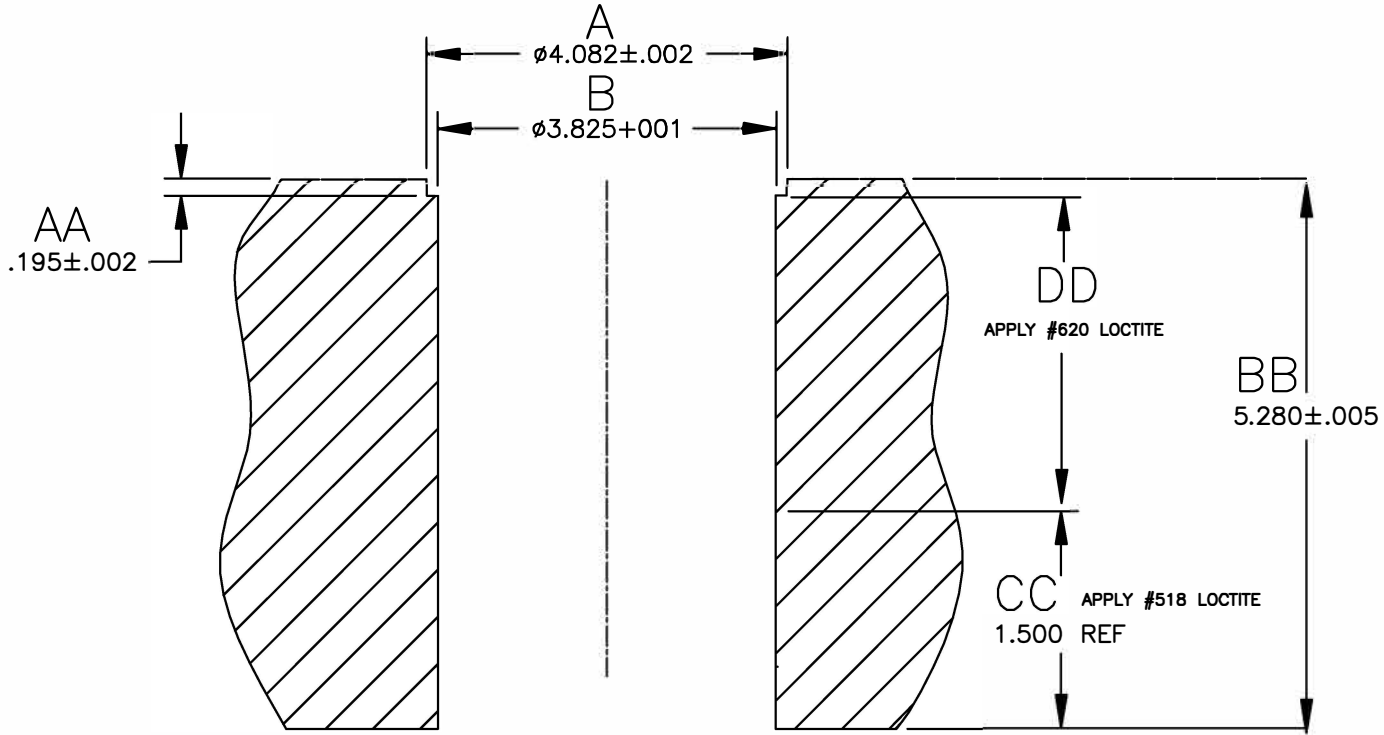



**NOTE:**

1. MACHINE DIMENSION A AT .005 TO .010 CLEARANCE
2. MACHINE DIMENSION B AT NET TO .0010 CLEARANCE
3. APPLY LOCTITE #518 AT CC (BLOCK SURFACE ONLY)
4. APPLY LOCTITE #620 AT DD (BLOCK SURFACE ONLY)
5. MACHINE BLOCK AT BORE CENTERS OF 100mm/3.937
6. INSTALL SLEEVES AT ROOM TEMPERATURE AND CLAMP SLEEVES DOWN AT DECK UNTIL LOCTITE HAS CURED, THEN DECK AND HONE
7. NEW BLOCKS NEED TO BE VIBRATORY STRESS RELIEVED PRIOR TO DECKING AND HONING
8. DO NOT PRESSURE WASH BLOCK AFTER INSTALL.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL



THE INFORMATION DEPICTED HEREIN IS PROPRIETARY DESIGN INFORMATION WHICH IS COPYRIGHTED BY DARTON INTERNATIONAL, INC. NO DUPLICATION OR USE OF THIS INFORMATION IS PERMITTED WITHOUT EXPRESS CONSENT OF DARTON INTERNATIONAL, INC.

DR. BY: CAD DEPT		<b>Darton International, Inc.</b> Carlsbad, CA USA (800) 713-2786 (760) 603-9895 FAX (760) 603-9629 WWW.DARTON-INTERNATIONAL.COM	
DATE: 1/12/18		TITLE: BLOCK SPECIFICATION - FORD 5.0 ALUM SEAL TITE 92/94mm	
CHKD BY:	MATERIAL:	SIZE: A	REV: C
HARDNESS:	DWG NO. 300-056-SF/DF		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		<b>Darton International, Inc.</b>	
DATE:	1/12/18		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 5.0 ALUM SEAL TITE 92/94mm		
HANDNESS:	A	SIZE	DWG NO.	REV
			300-056-SF/DF	C
	SCALE	1/2		SHEET 2 OF 2