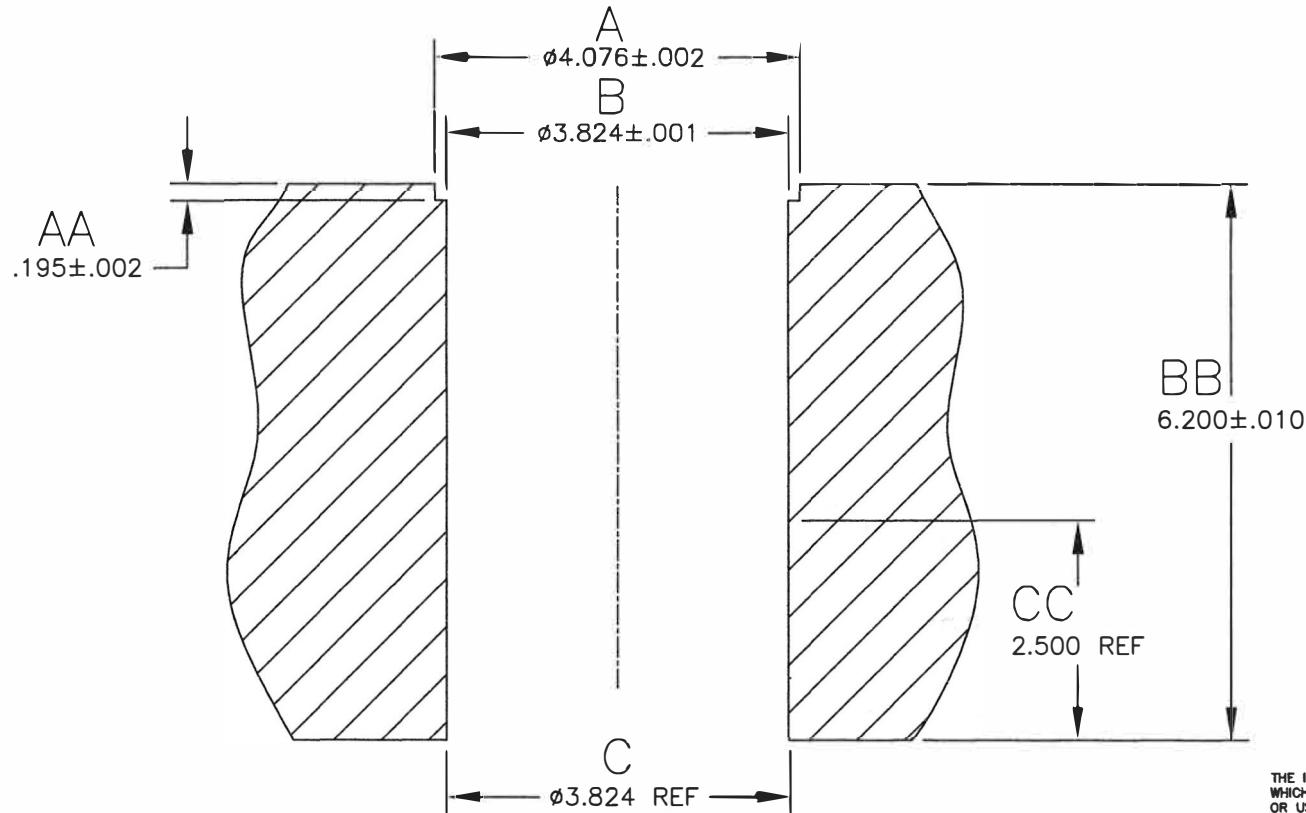


**NOTE:**


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 UNTILL LOCTITE HAS CURED 12 HOURS, THEN DECK AND HONE

REVISIONS

REV	DESCRIPTION	DATE	APPROVAL



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DRG. DT:	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:	12/14/2012	
CHK'D DT:		TITLE
MATERIAL:		<b>BLOCK SPECIFICATION-</b> <b>FORD 5.8L ALUM SEAL TITE 90/92mm</b>
HANDPICKED:		SIZE: <b>A</b> DWG. NO.: <b>300-058-SF/DF</b> REV: <b>-</b>
SCALE:	1/2	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		Darton 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:			FORD 5.4 ALUM SEAL TITE 90/92MM	
HARDNESS:		SIZE	DWG NO.	REV
		A	300-058-SF/DF	A
		SCALE	SHEET	
		1/2	2 OF 2	

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**Item Notes**

