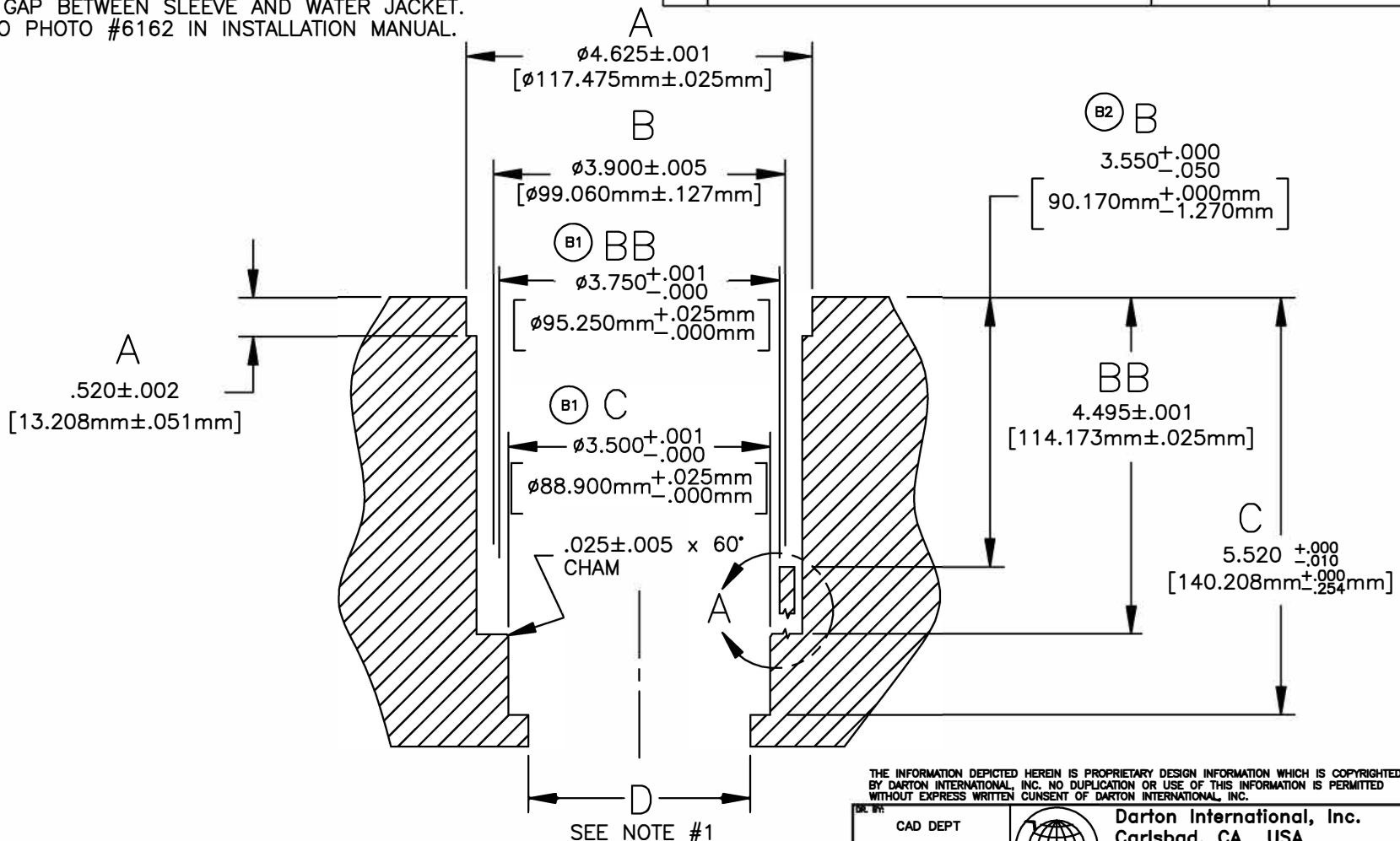



NOTE:

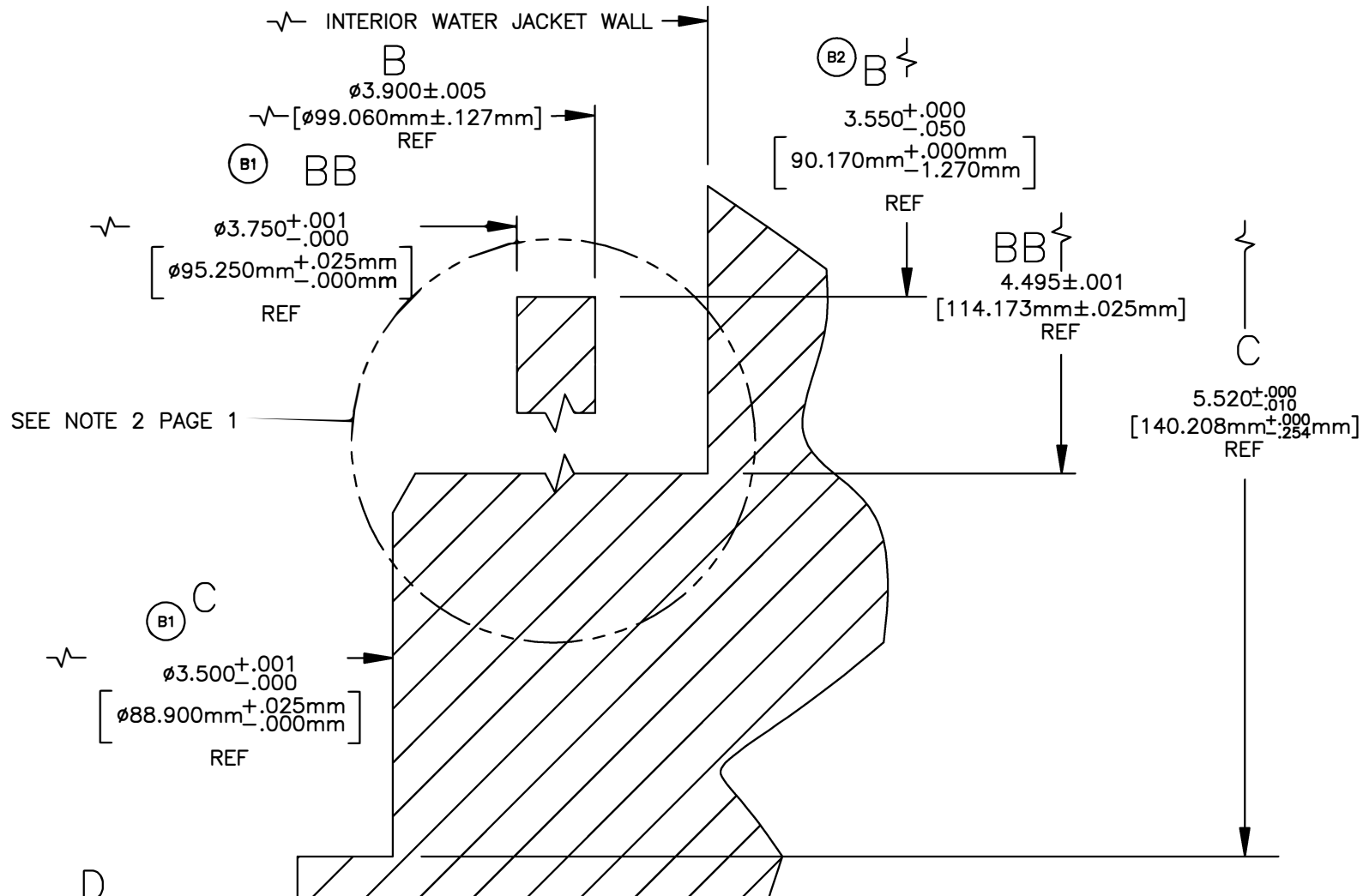
1. BORE THRU TO MAIN WEB AT FINISH
BORE DIA +.010
2. ON #1 CYL ONLY REMOVE REMAINING 320° ALUM WALL
DOWN TO 4.495 BY MILLING OR HAND GRINDING.
THIS WILL ELIMINATE ALL ALUM. WALL THAT WOULD
FORM A GAP BETWEEN SLEEVE AND WATER JACKET.
REFER TO PHOTO #6162 IN INSTALLATION MANUAL.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL



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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:	02/03/03	
CHK'D BY:		TITLE: BLOCK SPECIFICATION-CYL #1 HONDA M.I.D. B-18 84mm
MATERIAL:		SIZE: A
HARDNESS:		DWG NO. 400-140-D
		SCALE: 1/2
		REV: B
		SHEET 1 OF 6



D
 FINISH BORE $+0.010$ $[\phi .254 \text{mm}]$
 BORE THRU TO MAIN WEBS
 REF

DETAIL A
NO SCALE

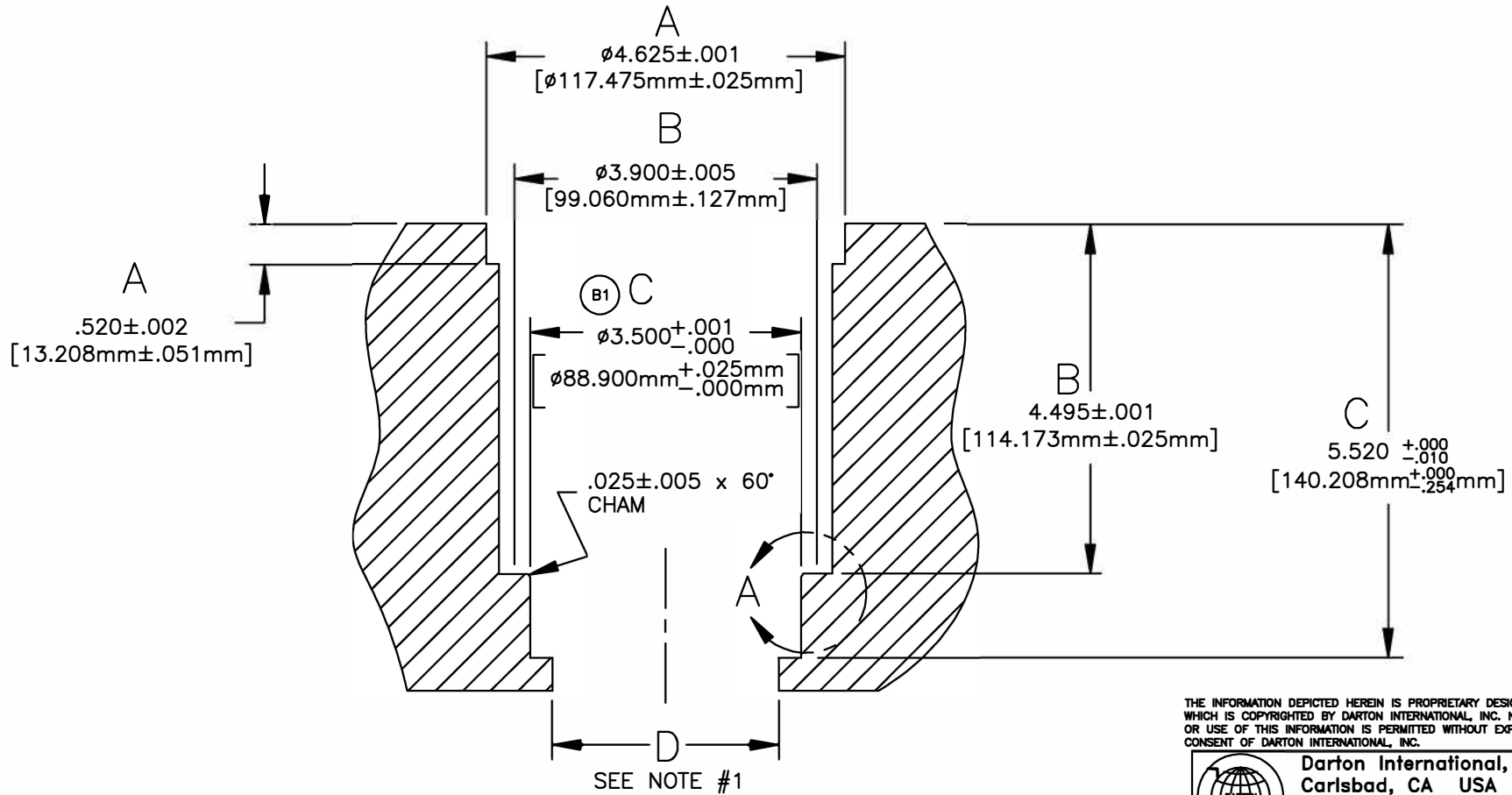
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TITLE BLOCK SPECIFICATION-CYL #1 HONDA M.I.D. B-18 84mm		
SIZE A	DWG NO. 400-140-D	REV B
SCALE 1/2	SHEET 2 OF 6	

NOTE:

- BORE THRU TO MAIN WEB AT FINISH
BORE DIA +.010

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL



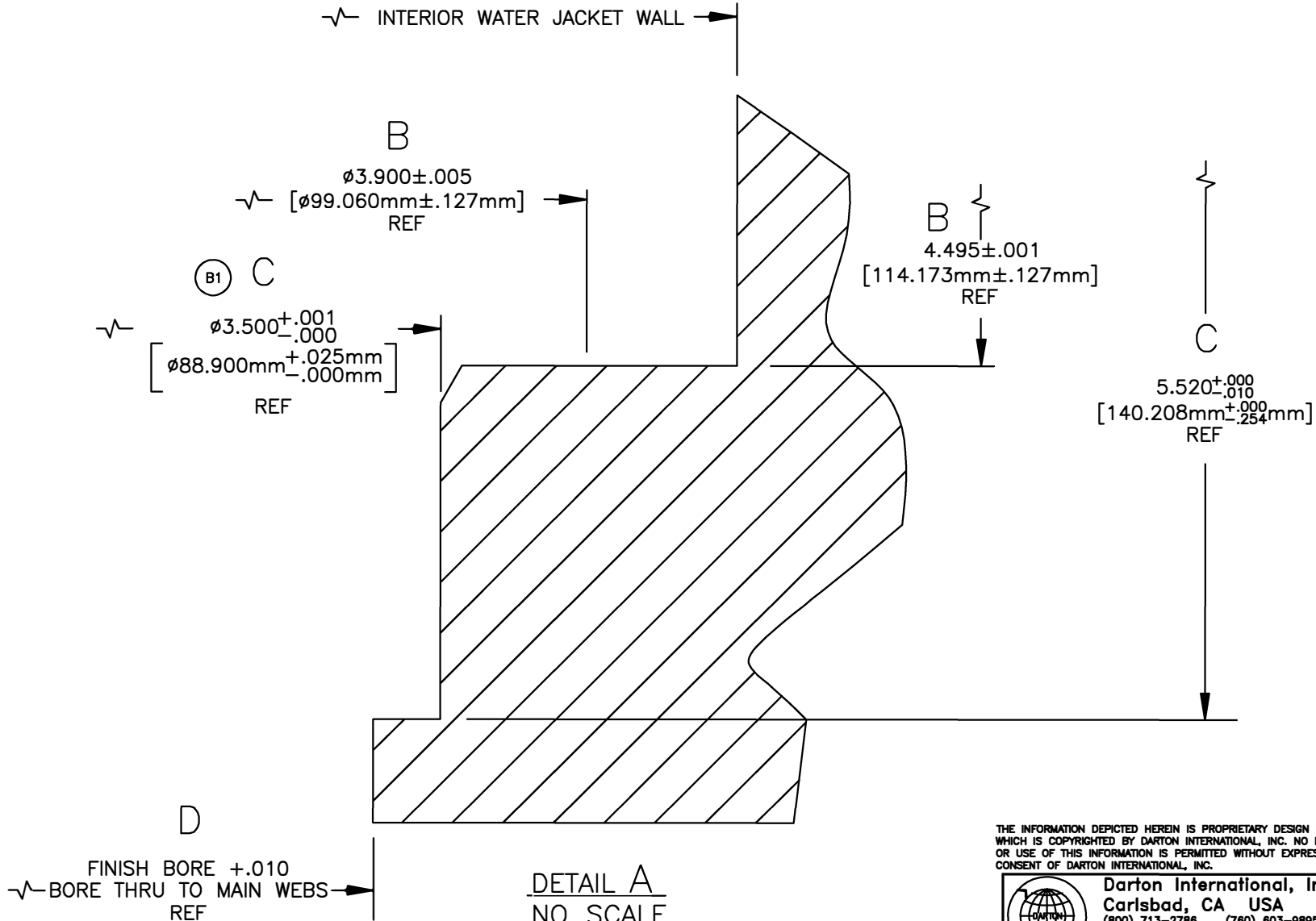
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TITLE BLOCK SPECIFICATION-CYLS #2-3
 HONDA M.I.D. B-18 84mm

SIZE A	DWG NO. 400-140-D	REV B
SCALE 1/2	SHEET 3 OF 6	



DETAIL A
NO SCALE

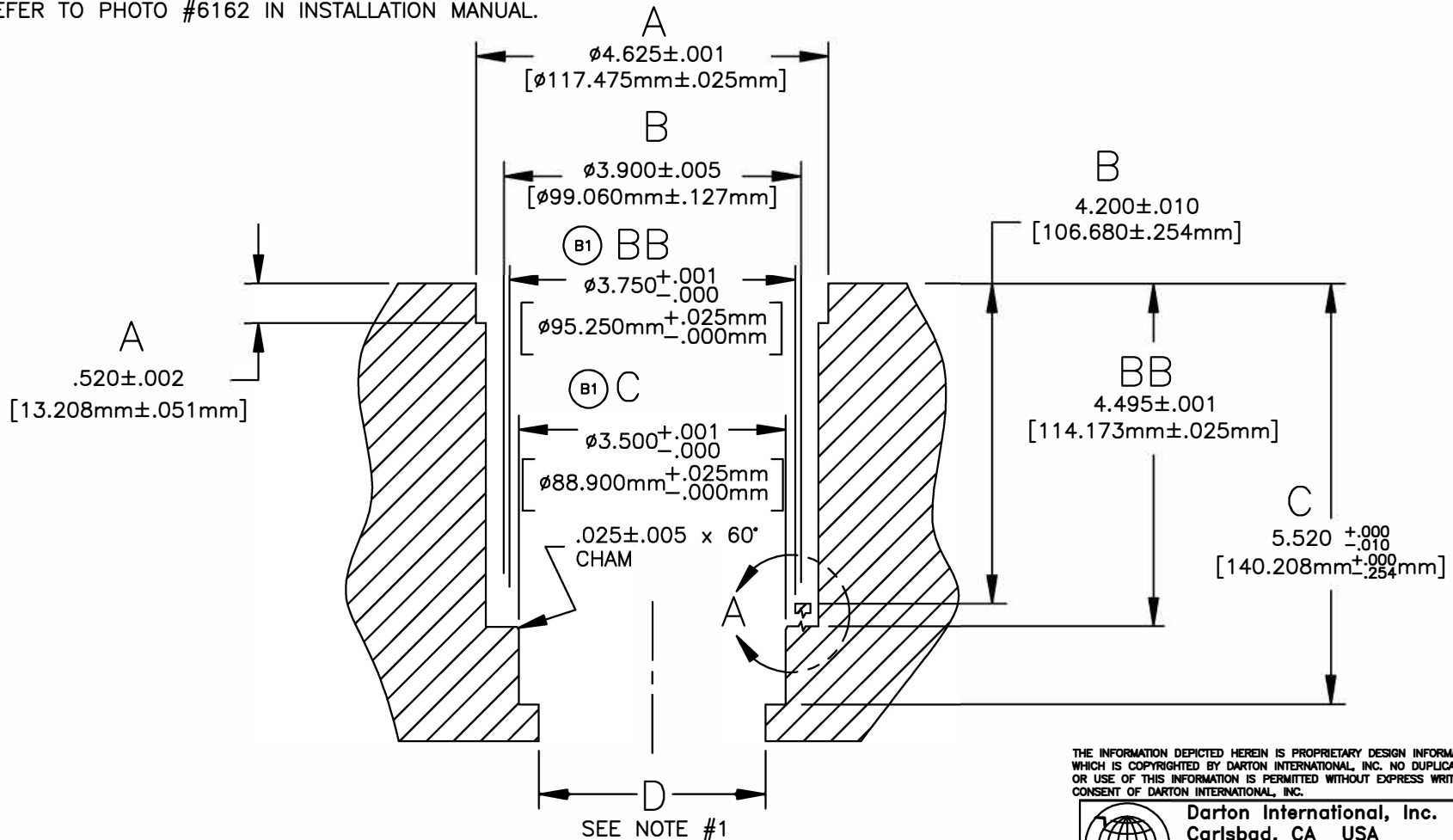
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		TITLE BLOCK SPECIFICATION-CYLS #2-3 HONDA M.I.D. B-18 84mm	
SIZE A	DWG NO. 400-140-D	REV B	
SCALE 1/2	SHEET 4 OF 6		

NOTE:

1. BORE THRU TO MAIN WEB AT FINISH
BORE DIA +.010
2. ON #4 CYL ONLY REMOVE REMAINING 280° ALUM WALL
DOWN TO 4.495 BY MILLING OR HAND GRINDING.
THIS WILL ELIMINATE ALL ALUM. WALL THAT WOULD
FORM A GAP BETWEEN SLEEVE AND WATER JACKET.
REFER TO PHOTO #6162 IN INSTALLATION MANUAL.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL



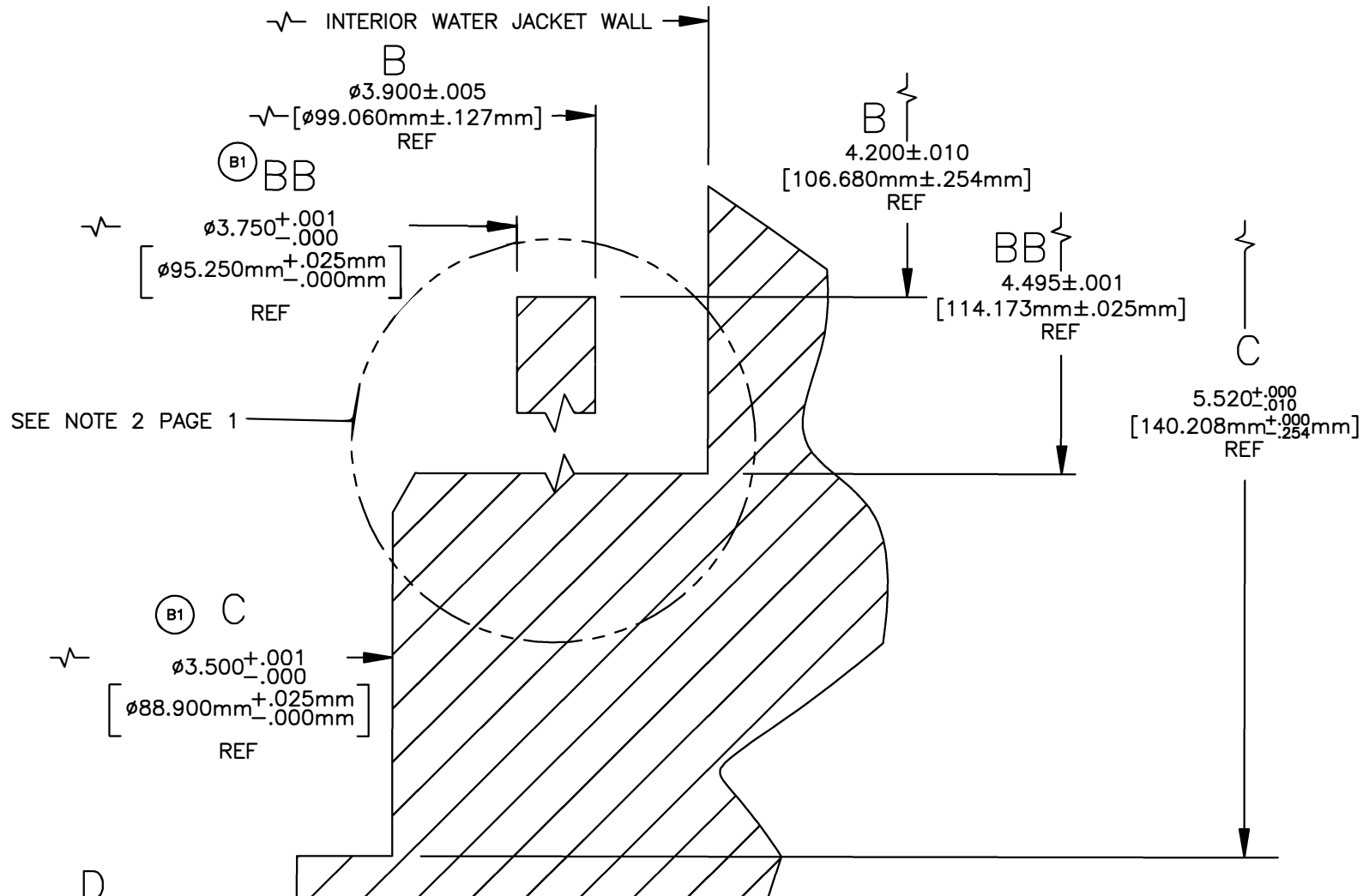
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TITLE BLOCK SPECIFICATION-CYL #4
 HONDA M.I.D. B-18 84mm

SIZE	DWG NO.	REV
A	400-140-D	B
SCALE	SHEET 5 OF 6	
1/2		



D
 FINISH BORE $+0.010$ [.254mm]
 BORE THRU TO MAIN WEBS
 REF

DETAIL A
NO SCALE

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		TITLE BLOCK SPECIFICATION-CYL #4 HONDA M.I.D. B-18 84mm	
SIZE A	DWG NO. 400-140-D	REV B	
SCALE 1/2	SHEET 6 OF 6		