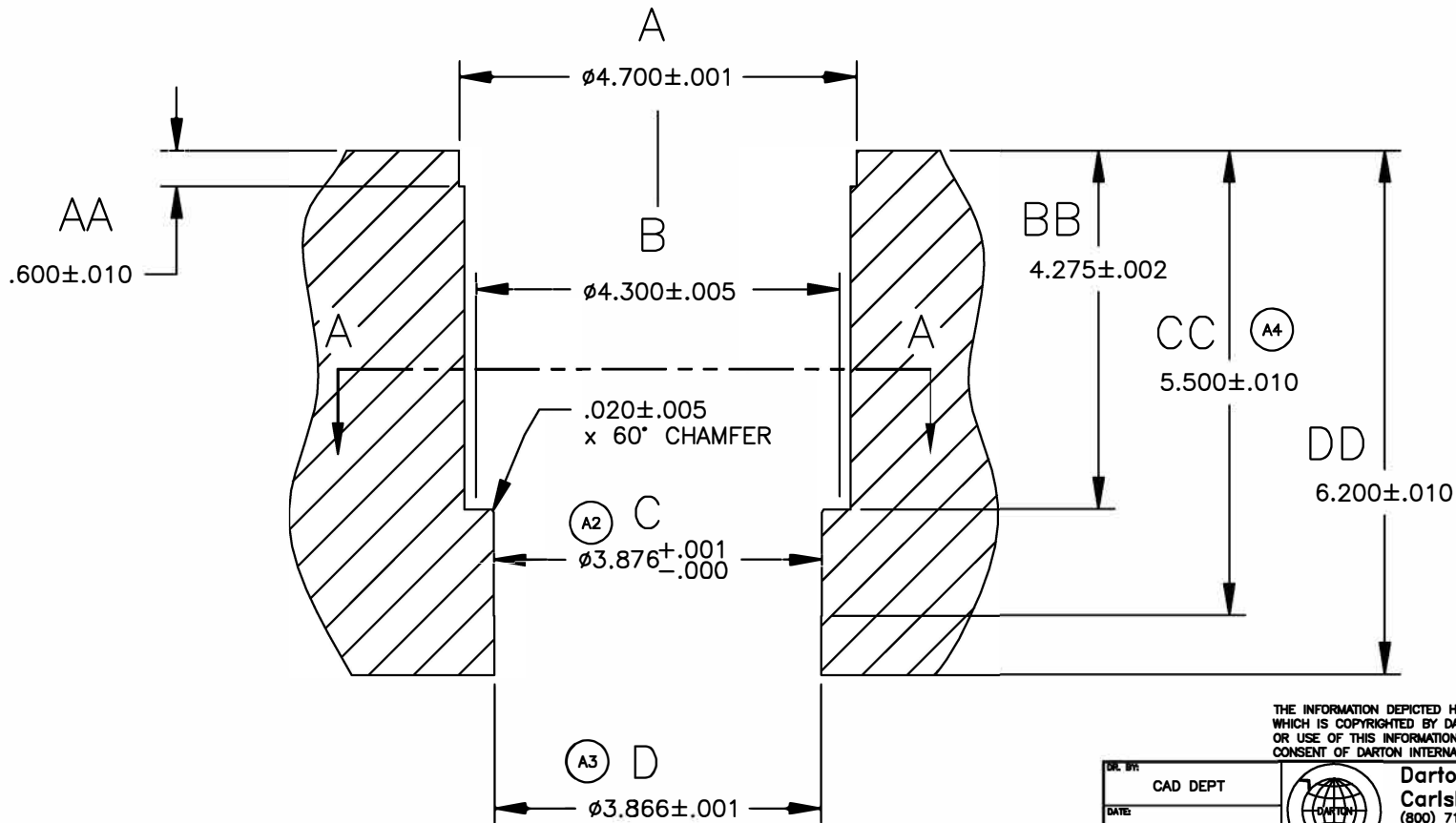



NOTE:

1. PRIOR TO MACHING FOR SLEEVES, BORE EXISTING CYLINDERS TO .010 OVER FINISH I.D. SIZE DOWN TO MAIN WEB FOR HONNING OVER STROKE CLEARANCE
2. MACHINE BLOCK AT BORE CENTER $\phi 3.938$
3. MACHINE BLOCK BORES A,C,& D TO BE .001 CLEARANCE OF SLEEVE
4. APPLY A SMALL AMOUNT OF LOCTITE #518 OR #620 TO BLOCK BORES A & D AT TIME OF INSTALLATION
5. INSTALL SLEEVES AT ROOM TEMPERATURE AND CLAMP SLEEVE DOWN TO DECK UNTILL LOCTITE HAS CURED, THEN DECK AND HONE

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL



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DR. BY:	CAD DEPT	 Darton International, Inc. Carlsbad, CA USA (800) 713-2788 (760) 603-9895 FAX (760) 603-9629 WWW.DARTON-INTERNATIONAL.COM
DATE:	01/11/05	
CHKD BY:		TITLE: BLOCK SPECIFICATION- FORD 5.4 ALUM V-8 M.I.D.
MATERIAL:		SIZE: A
HARDNESS:		DWG NO. 700-125
		REV: B
		SCALE: 1/2
		SHEET 1 OF 1