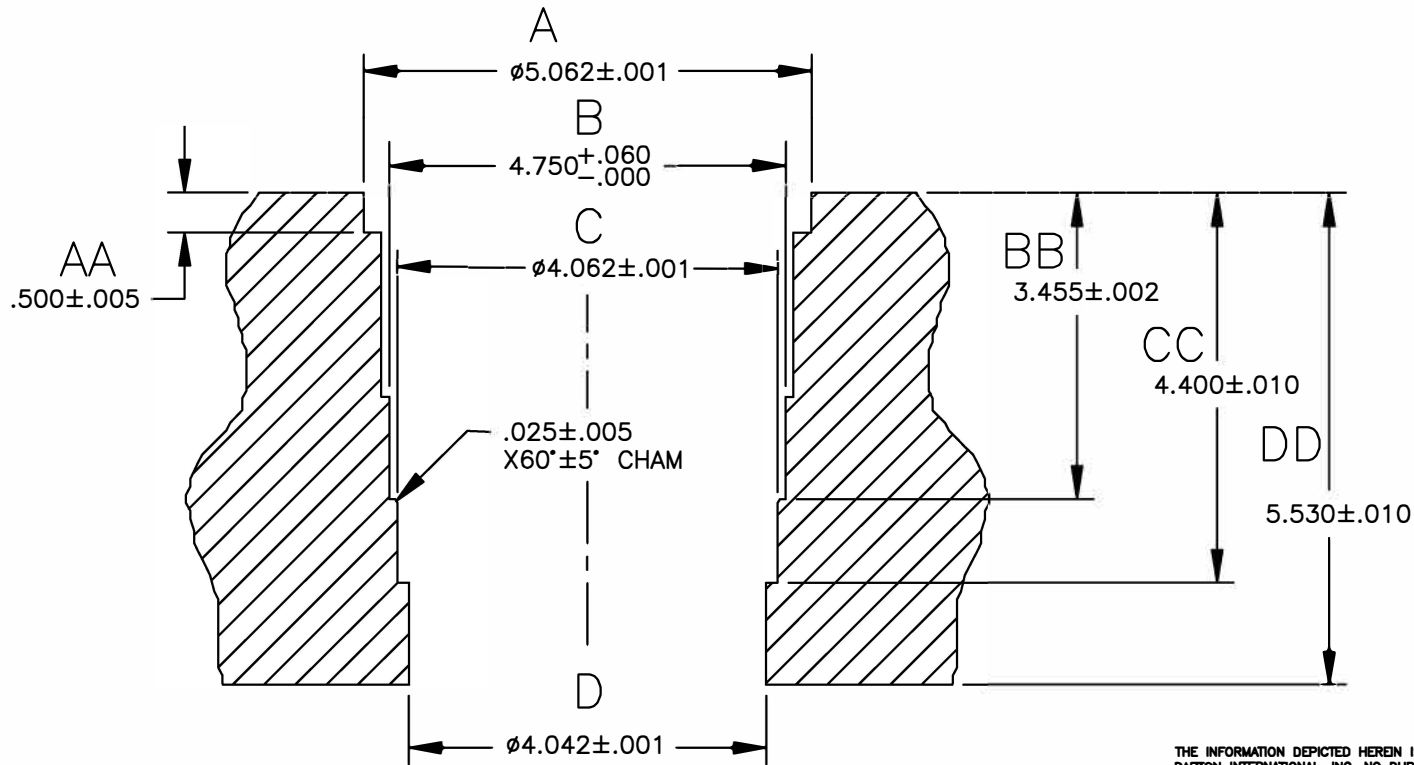


**NOTE:**

1. MACHINE BLOCK BORE DOWN TO  $\phi 5.900 \pm .010$  AT  $\phi 3.950 \pm .005$  FOR HONE CLEARANCE
2. MACHINE BLOCK AT BORE CENTER OF 108mm / 4.252
3. MACHINE BLOCK BORES A, C, & D TO BE .001 TO .0015 CLEARANCE OF SLEEVE DIAMETERS
4. AT TIME OF INSTALLATION APPLY A SMALL AMOUNT OF LOCTITE #515 OR #518 TO THE INSIDE OF BLOCK BORE A
5. INSTALL SLEEVES AT ROOM TEMPERATURE AND CLAMP SLEEVES DOWN TO DECK UNTILL LOCTITE HAS FULLY CURED, THEN DECK SURFACE AND HONE

REVISIONS

REV	DESCRIPTION	DATE	APPROVAL



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DR. WR.	CAD DEPT		Darton International, Inc.	
DATE:	04/08/2010		Carlsbad, CA USA	
CHK'D BY:		(800) 713-2786 (760) 603-9895		
MATERIAL:		FAX (760) 603-9829		
HARDNESS:		WWW.DARTON-INTERNATIONAL.COM		
TITLE		BLOCK SPECIFICATION-		
SIZE		NISSAN VR-38 95.5-100mm		
SCALE		DWG NO.	800-215-D	REV
1/2				-
SHEET			1 OF 1	