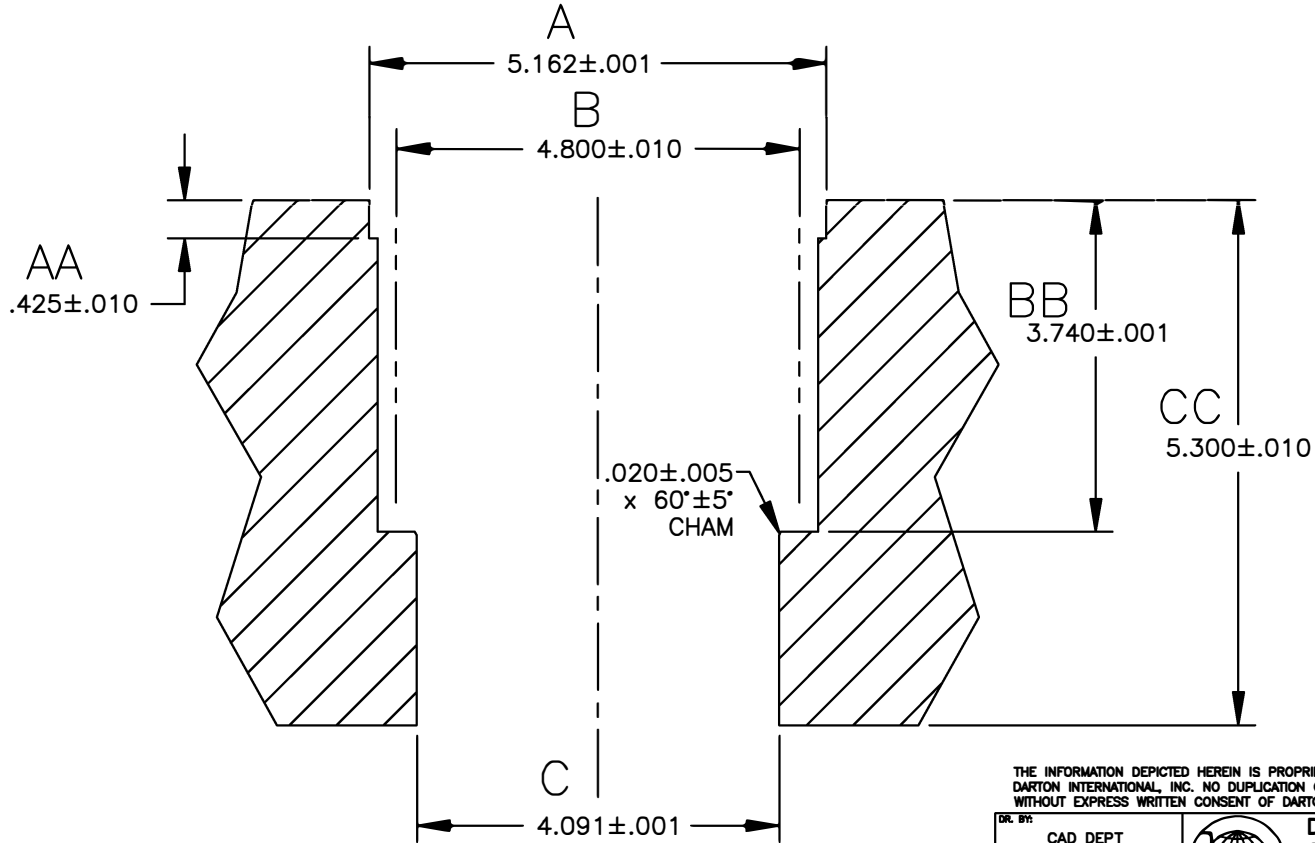



NOTE:

1. MACHINE BLOCK BORE AT .020 OVER FINISH BORE SIZE DOWN TO MAIN WEBBING (5.700-REF)
2. MACHINE DIMENSION A AT .002 TO .003 CLEARANCE.
3. MACHINE DIMENSION B TO REMOVE CYLINDER WALLS.
4. MACHINE DIMENSION C AT .001 TO .0015 CLEARANCE.
5. BLOCK BORE CENTER = 4.1535 (105.5mm).
6. APPLY LOCTITE #620 TO BLOCK BORE A.
7. APPLY MOLYKOTE 55 TO O RING AREA OF SLEEVES AND A LIGHT COAT IN BLOCK BORE C.
- 8) INSTALL SLEEVES, ALIGN FLATS USING THE HALF ROUND ALIGNMENT HOLES, THEN CLAMP SLEEVES DOWN UNTIL LOCTITE CURES (1 HOUR), RESURFACE BLOCK AND BORE FOR HONING IN THAT ORDER.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL



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DATE:	11/04/09	
CHKD BY:		TITLE: BLOCK SPECIFICATION- TOYOTA 2U M.I.D. 94-100mm
MATERIAL:		SIZE: A
HARDNESS:		DWG NO. 900-200
		SCALE 1/2
		REV A
		SHEET 1 OF 1