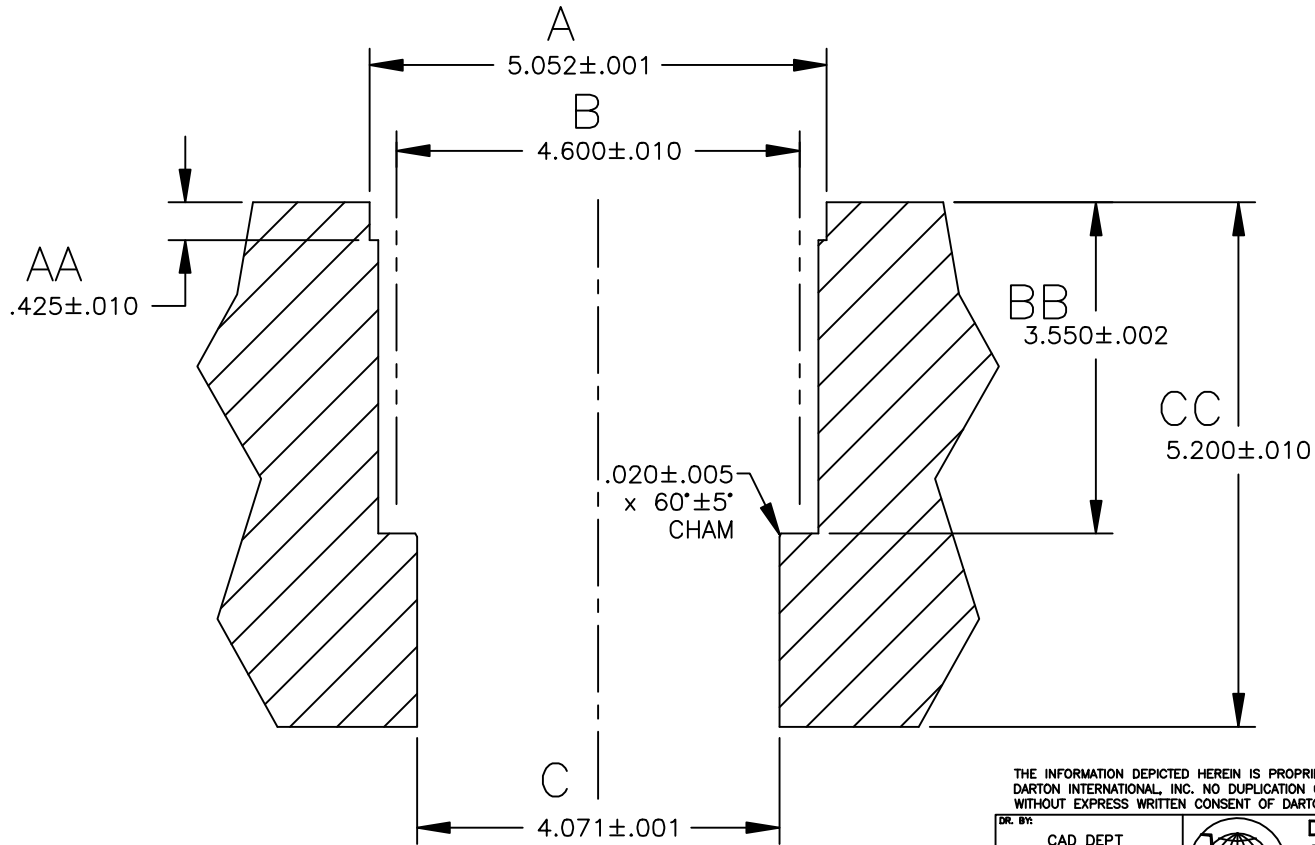



NOTE:

1. MACHINE BLOCK BORE AT .010 OVER FINISH BORE SIZE DOWN TO MAIN WEBBING BEFORE SLEEVE INSTALL.
2. MACHINE DIMENSION A AT .001 TO .002 CLEARANCE.
3. MACHINE DIMENSION B TO REMOVE CYLINDER WALLS.
4. MACHINE DIMENSION C AT .001 TO .002 CLEARANCE.
5. BLOCK BORE CENTER = 4.1535 (105.5mm).
6. APPLY LOCTITE #518 OR #620 TO BLOCK BORE A.
7. DECK BLOCK SURFACE AFTER LOCTITE HAS CURED (4 TO 8 HOURS).
8. PLUG PISTON OILER HOLES BEFORE MACHINING (IF NECESSARY)

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
	new		



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DATE: 10-26-11	
CHK'D BY:	TITLE: BLOCK SPECIFICATION- TOYOTA 2GR M.I.D. 94-97mm
MATERIAL:	SIZE: A
HARDNESS:	DWG NO. 900-500
SCALE: 1/2	REV: -
SHEET 1 OF 1	