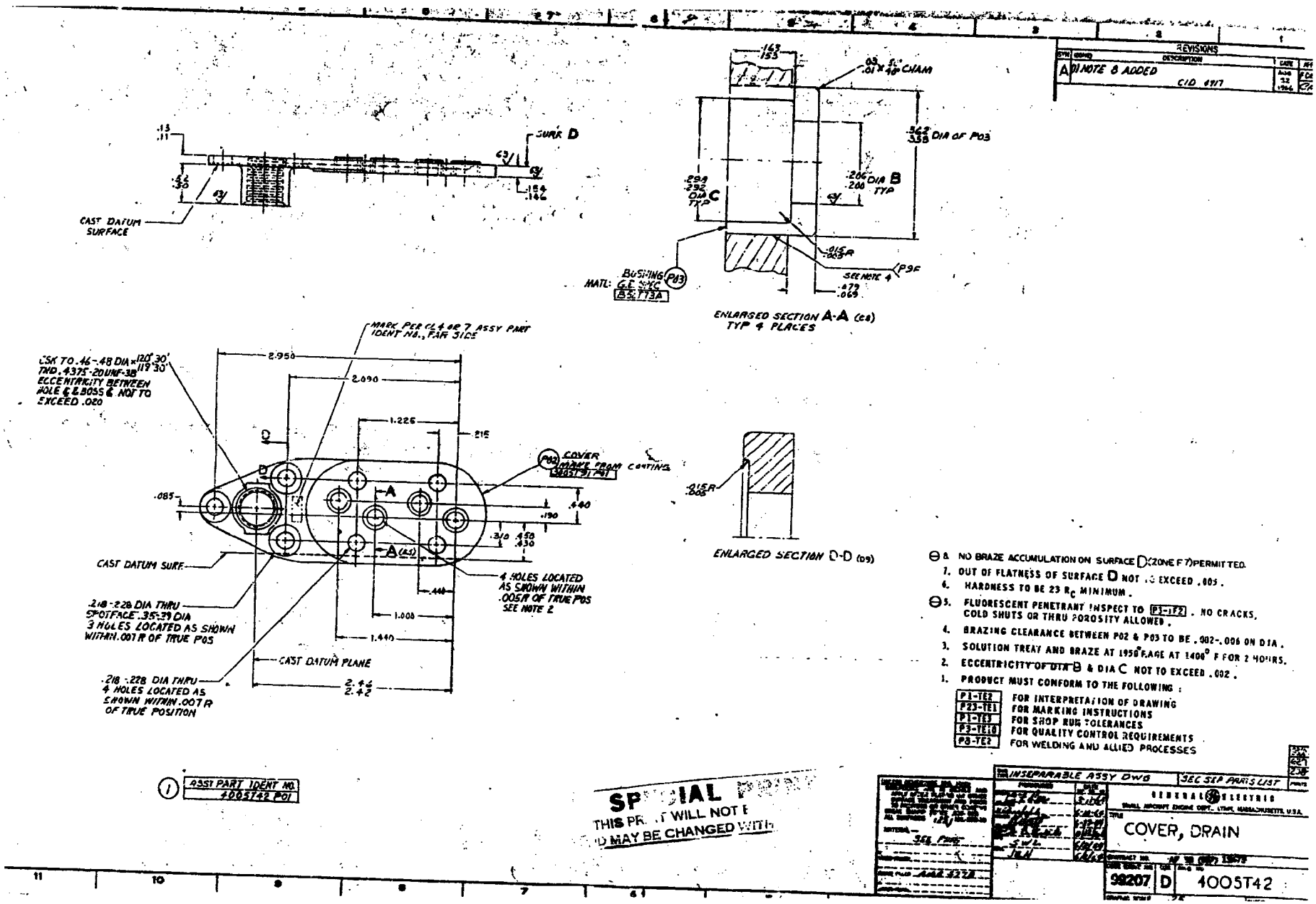

REVISIONS
A 01 NOTE 8 ADDED
CID 4917
SURF D
CAST DATUM SURFACE
.13
.11
.52
.30
.154
.146
.163
.153
.03 .01 X 50° 40° CHAM
.362 .358 DIA OF P03
.206 .200 DIA B TYP
.294 .292 DIA C TYP
.015 .005 R
SEE NOTE 4
P9F
.079
.069
BUSHING P03
MATL: G.E. SPEC B5T73A
ENLARGED SECTION A-A (C8)
TYP 4 PLACES
MARK PER CL 4 OR 7 ASSY PART IDENT NO., FAR SIDE
CSK TO .46-.48 DIA x 120° 30' 119° 30' TWD .4375-20UNF-3B ECCENTRICITY BETWEEN HOLE ℄ & BOSS ℄ NOT TO EXCEED .020
2.950
2.090
1.225
.215
P02 COVER MAKE FROM CASTING
.085
.440
.190
.310
.450
.430
CAST DATUM SURF
4 HOLES LOCATED AS SHOWN WITHIN .005R OF TRUE POS SEE NOTE 2
.218-.228 DIA THRU SPOTFACE .35-.39 DIA 3 HOLES LOCATED AS SHOWN WITHIN .007R OF TRUE POS
.440
1.000
1.440
CAST DATUM PLANE
.218-.228 DIA THRU 4 HOLES LOCATED AS SHOWN WITHIN .007R OF TRUE POSITION
2.46
2.42
.015R .005
ENLARGED SECTION D-D (D9)
8. NO BRAZE ACCUMULATION ON SURFACE D (ZONE F 7) PERMITTED.
7. OUT OF FLATNESS OF SURFACE D NOT TO EXCEED .005.
6. HARDNESS TO BE 23 R_C MINIMUM.
5. FLUORESCENT PENETRANT INSPECT TO P3-1F2. NO CRACKS, COLD SHUTS OR THRU POROSITY ALLOWED.
4. BRAZING CLEARANCE BETWEEN P02 & P03 TO BE .002-.006 ON DIA.
3. SOLUTION TREAT AND BRAZE AT 1950°F AGE AT 1400° F FOR 2 HOURS.
2. ECCENTRICITY OF DIA B & DIA C NOT TO EXCEED .002.
1. PRODUCT MUST CONFORM TO THE FOLLOWING:
P1-TE2 FOR INTERPRETATION OF DRAWING
P23-TE1 FOR MARKING INSTRUCTIONS
P1-TE3 FOR SHOP RUN TOLERANCES
P3-TE10 FOR QUALITY CONTROL REQUIREMENTS
P8-TE2 FOR WELDING AND ALLIED PROCESSES
1 ASSY PART IDENT NO. 4005T42 P01
SPECIAL PRINT
THIS PRINT WILL NOT BE
AND MAY BE CHANGED WITH
INSEPARABLE ASSY DWG
SEC SEP PARTS LIST
GENERAL ELECTRIC
SMALL AIRCRAFT ENGINE DEPT., LYNN, MASSACHUSETTS, U.S.A.
COVER, DRAIN
99207 D 4005T42