

PERMISSIBLE VARIATION ON COMMON
FRACTION DIMENSIONS TO MACHINED SURFACES
TO $\pm .010$ UNLESS OTHERWISE SPECIFIED.
FABRICATION TOLERANCE.

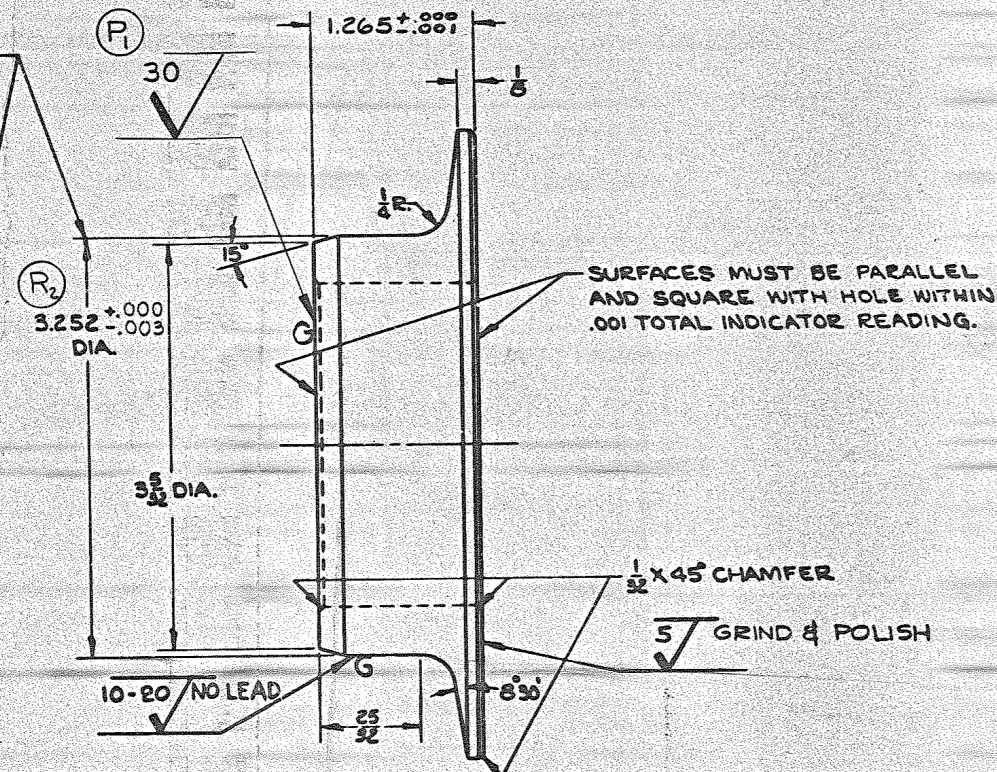
**BREAK ALL SHARP CORNERS
UNLESS OTHERWISE SPECIFIED.**

COUNTERSINK ALL TAPPED HOLES 118° X ONE THRD DEEP

SURFACE FINISH SPECS. TO BE IN ACCORDANCE WITH G.M. ENGR. STDS.

FORGING TOL. $\pm \frac{1}{32}$

THESE SURFACES MUST BE CONCENTRIC
WITHIN .001 TOTAL INDICATOR READING.



FINISH ALL OVER.
GRIND WHERE SHOWN.

**ENGINEERING APPROVAL
OF SOURCE REQUIRED**

CARBURIZE FOR ".030-.040" FINISH CASE.

COOL TO 1475°F. (R_i)
QUENCH IN OIL.
TEMPER AT 300°F.
ROCKWELL "C" 58 MINIMUM ON GROUND SURFACES.

[illegible]