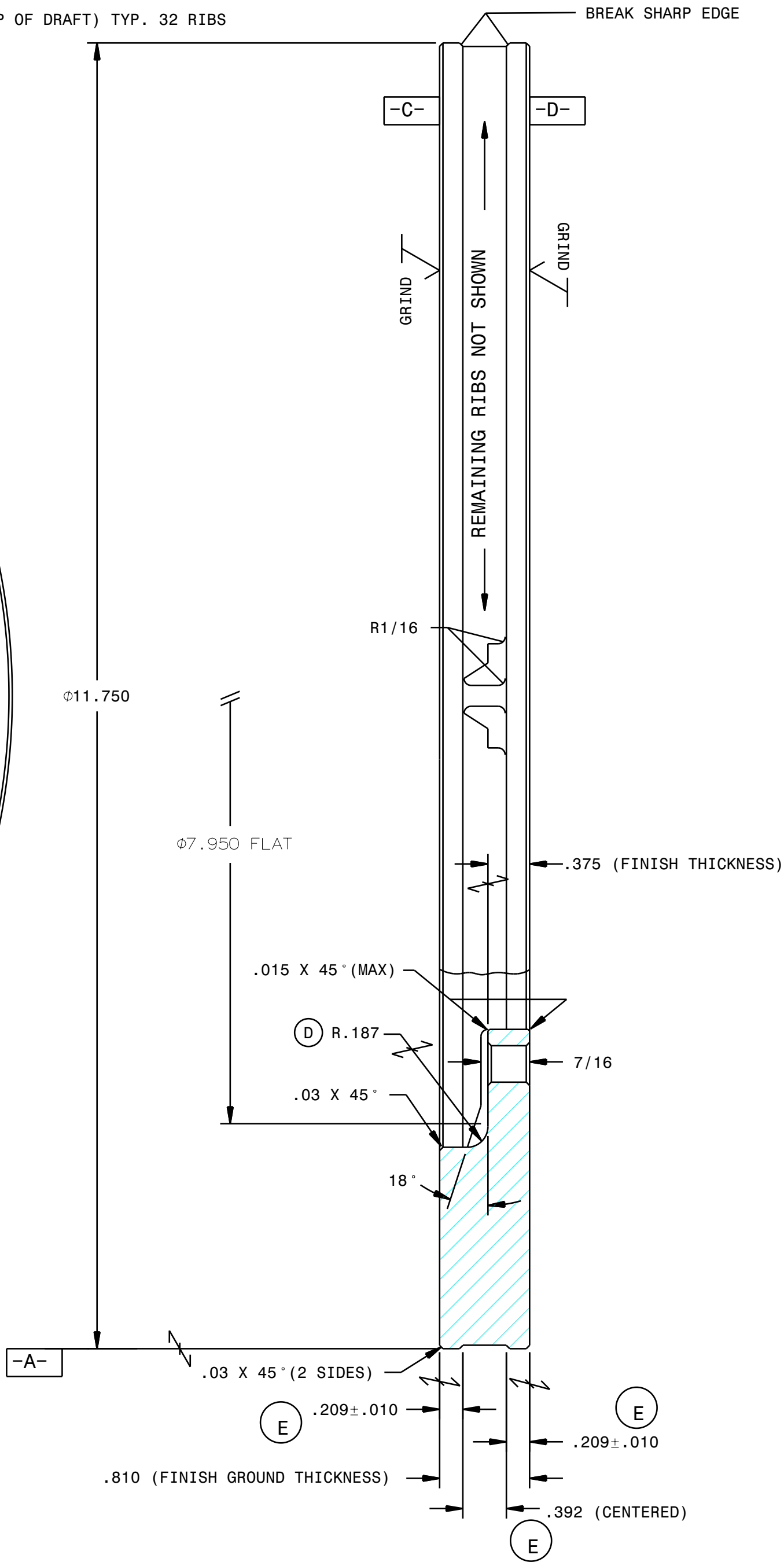
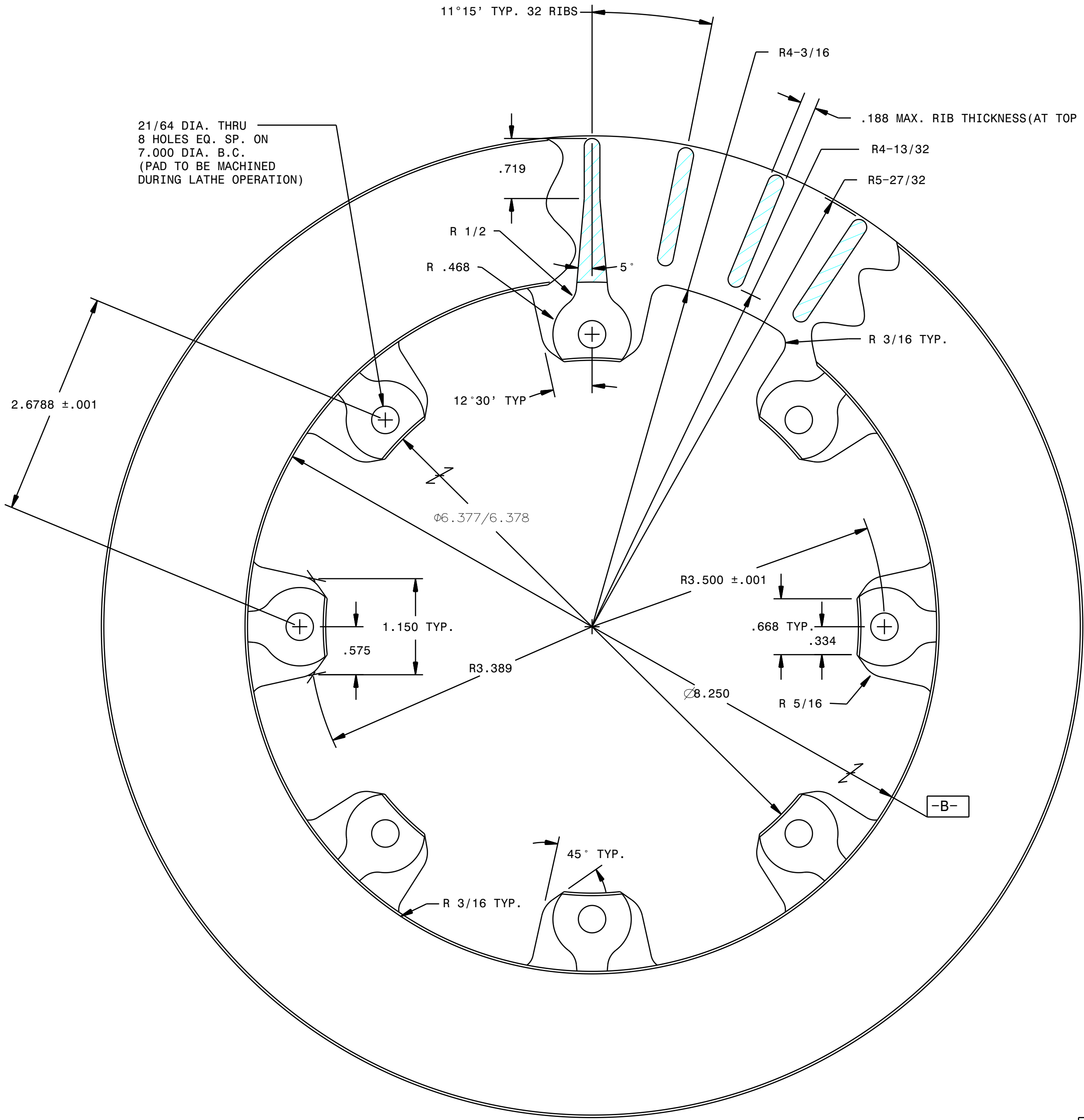


R E V I S I O N S			
ISSUE	CHANGE	DATE	BY
D	INCREASED RADIUS	9/5/01	BEM/VW
E	.209±.010 WAS .250±.015	3/27/07	V.W.JR.



- NOTES:
1. MATERIAL TO BE CAST IRON, TYPE 35 (G3500B OR 3500C), HARDNESS Bhn 207-255
 2. DENOTES MACHINED SURFACE
 3. CAST SURFACE FINISH TO BE 250 MICRO-INCHES (6.3 Ra)
 4. MACHINED SURFACES TO BE 63 MICRO-INCHES (1.6 Ra)
 5. GROUND SURFACES TO BE 32 MICRO-INCHES (0.8 Ra)
 6. ALL FILLETS AND RADII 1/16 U.O.N.
 7. DIAMETERS -A-, AND -B- MUST BE CONCENTRIC WITH O.D. OF FINS WITHIN .030 T.I.R.
 8. SURFACES -C-, AND -D- MUST BE PARALLEL & SQUARE WITHIN .001 T.I.R.
 9. DEBURR ALL SHARP EDGES .010 X 45°
 10. SURFACES -C- AND -D- MUST BE GROUND AS SHOWN 100%, ANY STEPS OR SHOULDERS WILL NOT BE ACCEPTABLE
 11. INDIVIDUAL ROTORS ARE TO BE PACKAGED IN HERMETICALLY SEALED PLASTIC OR FOIL BAGS, AND PACKAGED IN CARDBOARD BOXES MARKED WITH PART NUMBER AND COUNTRY OF ORIGIN.

PART MUST BE PARALLEL, PERPENDICULAR, AND CONCENTRIC WITHIN .002 T.I.R. U.O.N.														
ALL DIMENSIONS APPLICABLE AT 68 °F/20 °C DIMENSIONAL TOLERANCE U.O.N.			ROTOR											
FRACTION	DECIMAL	ANGULAR												
±1/64	±.001	±30 SEC.												
LAYOUT #			SCALE					DRAWN		DATE		SIZE		DRAWING NUMBER
2394GM.DWG			7/8		C.CLARK		12/22/97		C		2394GM		E	