



- NOTES: UNLESS OTHERWISE SPECIFIED
1. REMOVE BURRS & BREAK ALL SHARP EDGES
 2. HOLES FOR MOUNTING CYLINDER & VALVE HEADS MAY BE MATCH DRILLED FROM CYLINDER & VALVE HEADS (CYLINDER GROUP #2)
 3. BORE FOR CYLINDER & VALVE LINERS NOMINAL, TURN LINERS FOR .002 PRESS FIT IN CYLINDER BLOCK. BORES FOR LINERS TO BE PARALLEL WITH SPLIT MOUNTING SURFACE OF CYLINDER BLOCK & MOUNTING SURFACE TO FRAME
 4. HOLES FOR MOUNTING SMOKEBOX WILL BE DRILLED IN CYLINDER SADDLE FOR TRANSFER DRILLING IN SMOKEBOX
 5. HOLES MARKED "X" FOR MOUNTING CYLINDER WRAPPER. TRANSFER FROM CYLINDER WRAPPER, DRILL #51 (.047) & TAP 2-56 x 5/16 DEEP FOR 2-64 x 1/4 SCREWS OR BOLTS, TO BE PERFORMED BY BUILDER ON ASSEMBLY.

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DR. J.R. Oetting 21 Nov 51	FINISH	TITLE	
DR. J.R. Oetting		MACHINING CYLINDER BLOCK USRA	
APP.		DATE	2026
TOLERANCES		SCALE	FULL
ANGLES 3/4		SHEET	1 OF 1
DECIMAL .XX - ± .015			
FRACTIONS 3/16			
DECIMAL .XXX - ± .005			
FRACTIONS 1/32			
DECIMAL .XXXX - ± .001			
FRACTIONS 1/64			
DECIMAL .XXXXX - ± .0005			
FRACTIONS 1/128			
DECIMAL .XXXXXX - ± .0002			
FRACTIONS 1/256			