

# F 602133

TAP DRILL 2 1/8 DEEP  
1/16 N.P.T.

TAP DRILL 2 1/8 DEEP  
1/16 N.P.T.

1/4 DRILL 3 1/4 DEEP  
TAP DRILL TO DEPTH SHOWN  
1/2-20 N.F. TAP 1 1/16 DEEP.  
NOTE: USE REAMER OIS-1042-T5  
TO FORM 20° VALVE SEAT.

SECTION A-A

SECTION B-B

NOTE: DIAMETERS X,Y,Z  
TO BE CONCENTRIC WITHIN  
.002 T.I.R

UNLESS OTHERWISE SPECIFIED  
ALL CAST CORNERS 1/8 R. AND  
FILLETS 1/8 R.

USED ON ASSEMBLY NO. OIS-01150

M-8  
MARK PART NUMBER AT ⊗

NAME		CYLINDER HEAD-LOWER		OWENS-ILLINOIS	
ALL FINISHED FRACTIONAL DIMENSIONS ± .001		DRAWN		DATE	
GWI		4-5-73		FULL	
A 2-20-74		MATERIAL		ASTM-A48 (LATEST)	
CHANGES		SURFACES FINISHES		CLASS 35 CAST IRON	
		NOT TO EXCEED		12.51	

DRAWING NUMBER  
OIS-9-463

\* MARCAR PIEZA CON NUMERO OWEN-ILLINOIS \*

DRAWING NUMBER OIS-9-463		CHANGE LETTER B		CHANGED BY RLS	
CHANGE DESCRIPTION & REASON WAS. 3/16 DRILL x 3/16 DEEP					
TO PROVIDE FOR TRACK PIPING OPTION.					
G.C.D. ENGINEERING & RESEARCH DEPT.					
EFFECTIVITY					
P. IN PROCESS					
UP TO AFFECTED OPERATION * F					
U. UNASSEMBLED PARTS - IN PROCESS.					
STORES, ASSEMBLY FLOOR * P					
A. PARTS IN ASSEMBLIES * U					
T. PARTS OR ASSEMBLIES IN MACHINES * A					
S. SPECIAL INSTRUCTIONS					
FOR HARD PARTS, MACHINE NO'S, ETC.					
R. RECORD ONLY					
FRAME NO. 235		CODE B		P	