PART: VALVE BTM **PART NO:** 05 **MATL:** ALUMINIUM DIM: 10x50MM ROD 501 INSPECT the part 1 min 502 FACE top surface for SURFACE FINISH of 1.6 5 min 1 min 503 **INSPECT** surface dimensions 504 CENTREDRILL centre of top surface 5 min DRILL 4mm through hole in centre of top surface 505 10 min INSPECT hole position and depth 1 min 506 BORE 7mm hole with 25mm depth in centre of 507 20 min top surface 508 INSPECT hole position and depth 1 min 509 SAW rod at 31mm from top surface 5 min FACE bottom surface to 30mm from top surface 510 10 min for SURFACE FINISH of 1.6 1 min **INSPECT surface dimensions** THREAD M10x1.0 on external surface for depth 512 10 min of 10mm from bottom surface THREAD M8x1.0 in 7mm hole from top surface 513 10 min for depth of 10mm 5 min 514 DEBURR edges 515

INSPECT the part

1 min

QTY: 2

PART: VALVE TOP PART NO: 06 MATL: ALUMINIUM DIM: 10x25MM ROD INSPECT the part 1 min 601 602 FACE top surface for SURFACE FINISH of 1.6 5 min TURN curved surface of rod for 8mm external 20 min 603 diameter for depth of 15mm from top surface for SURFACE FINISH of 1.6 1 min 604 **INSPECT surface dimensions** 5 min 605 CENTREDRILL centre of top surface DRILL 4mm through hole in centre of top 606 10 min surface INSPECT hole position and depth 1 min 607 608 SAW rod at 16mm from top surface 5 min FACE bottom surface to 15mm from top surface for SURFACE FINISH of 1.6 10 min 609 **INSPECT** surface dimensions 1 min 610 THREAD M8x1.0 on external surface for depth 10 min 611 of 10mm from bottom surface DEBURR edges 612 5 min

INSPECT the part

1 min

613

QTY: 2