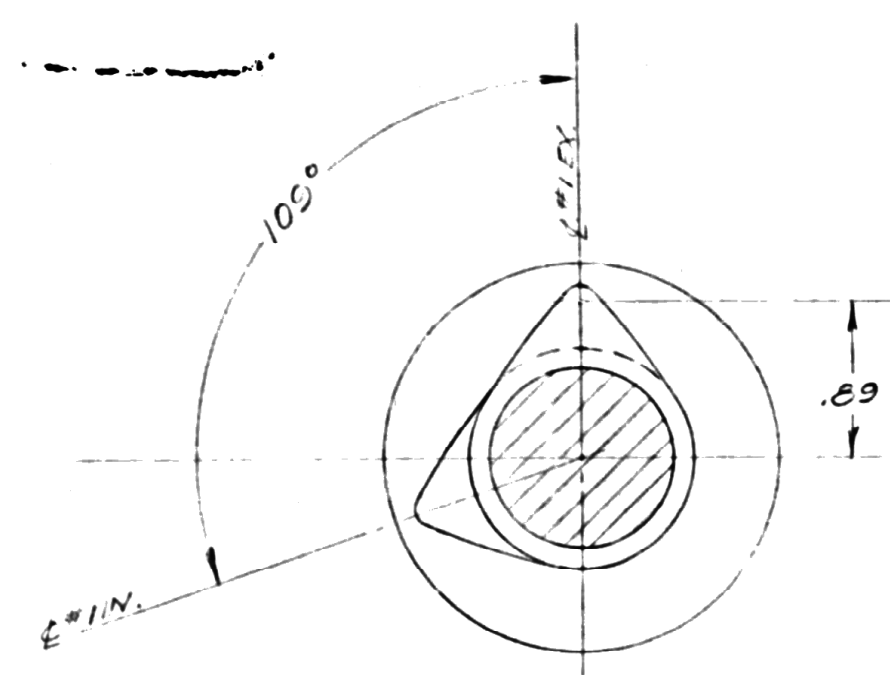
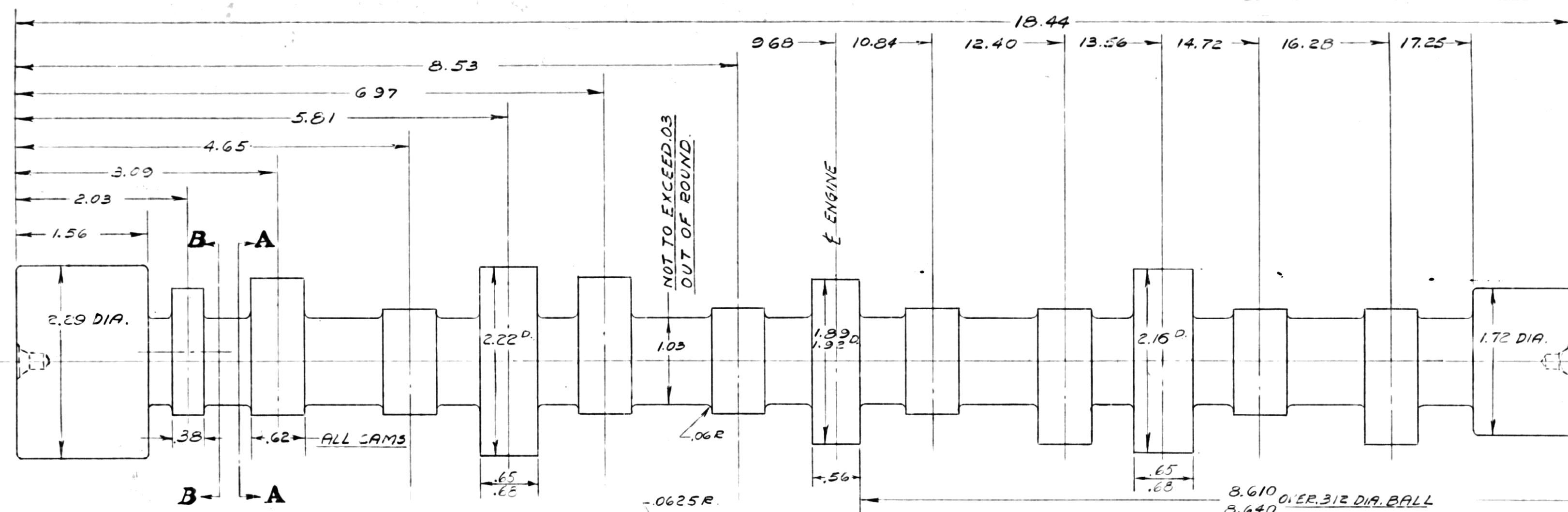


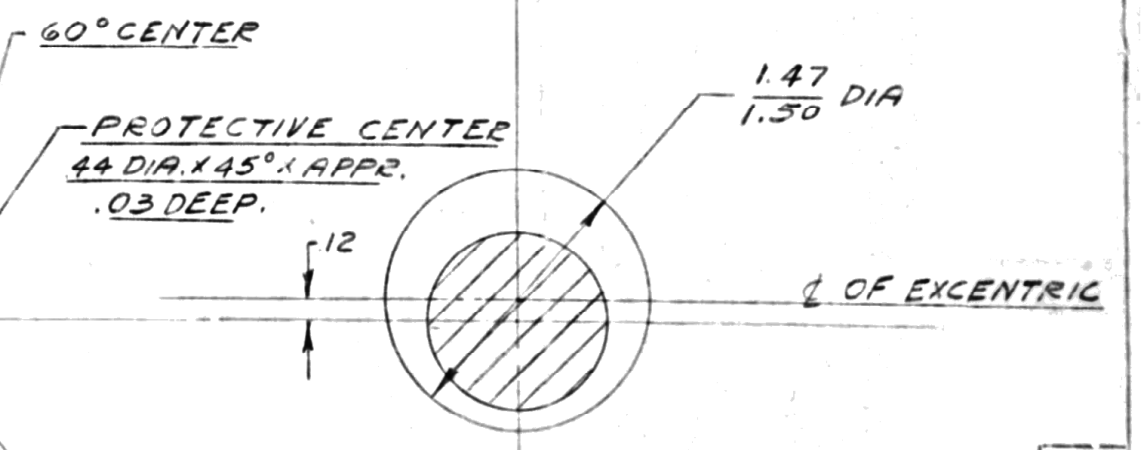
DRWG. STARTED	10-22-41
DRWG. COMPLETED	10-27-41
DESIGN	11-8-41
110	46
110	41
110	41
110	41
110	41



SECTION A-A



CHILL FACE OF ALL CAM LIFTS TO SCLEROSCOPE HARDNESS 65 MIN. FOR A DISTANCE OF NOT LESS THAN 85° EACH SIDE OF CENTER AS INDICATED



SECTION B-B

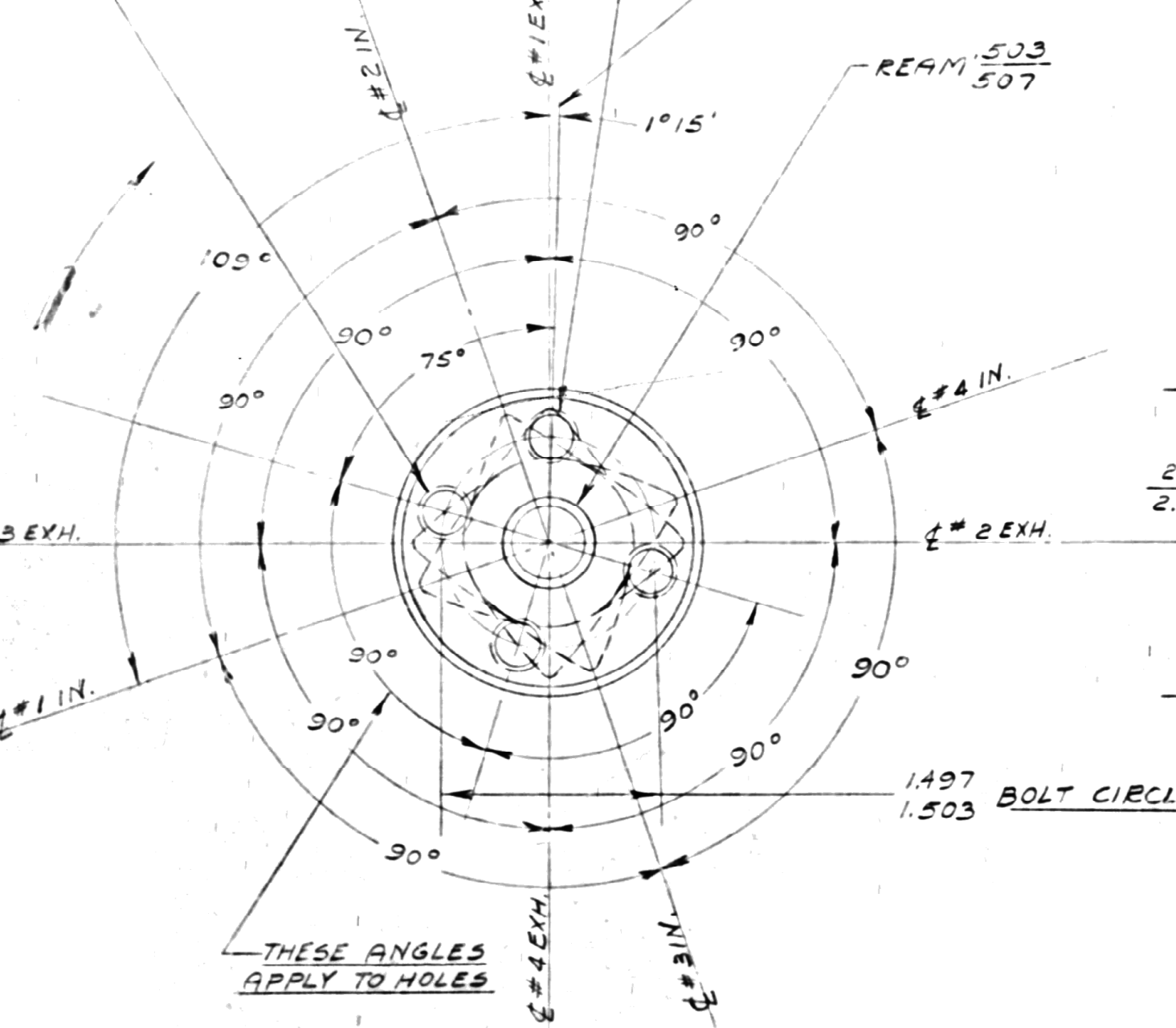
NOTE: FOUNDRY TO FLASH GRIND & CENTER EACH END, STRAIGHTEN SHAFT

NOTE: WIDTH OF CAMS, GEAR, FUEL PUMP ECCENTRIC AND BEARINGS TO BE CAST TO SIZE

NOTE: ALLOW .015 TO .03 FINISH ON ENTIRE FACE OF EXHAUST & INTAKE CAMS.

DRILL 3/32" THRU TAP 3/32" U.S.F. 1.06 DEEP PITCH DIA. 3/32" - 3512 REAM 3/32" .25 DEEP 1 HOLE TO BE OFF CENTER OF 1/2 EXH. CAM AS SHOWN 3 MINUTES.

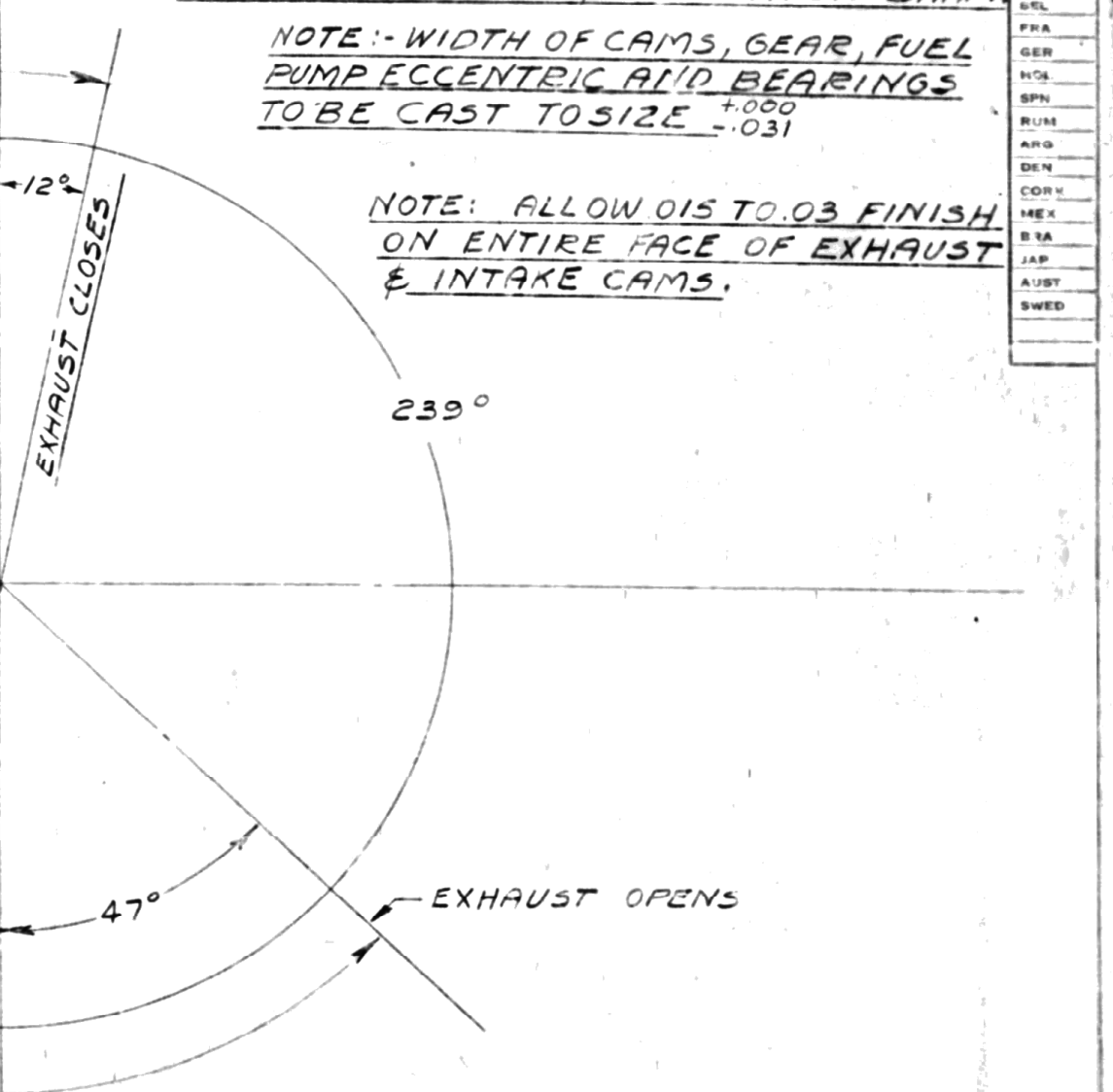
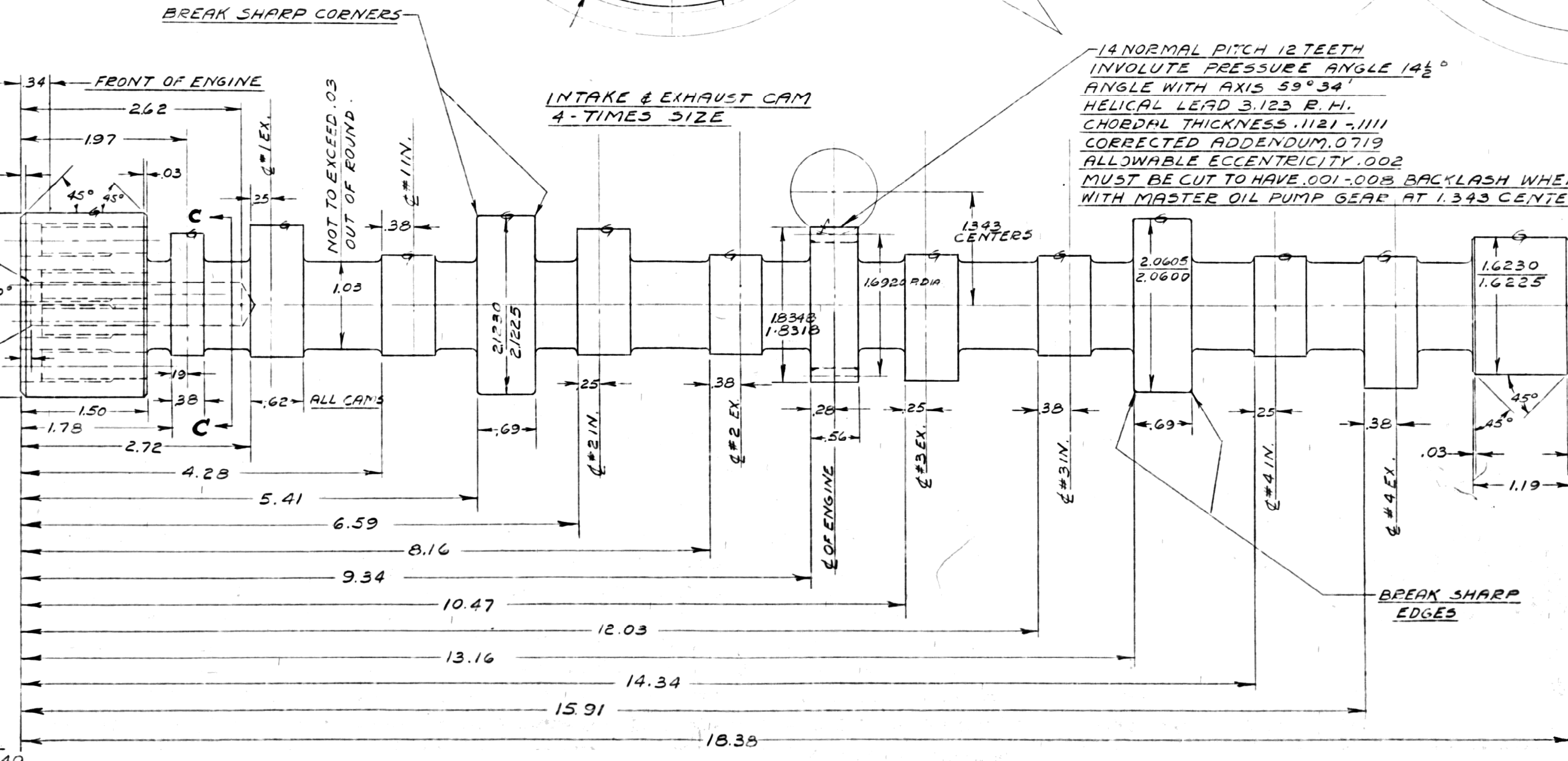
DRILL 3/32" THRU TAP 3/32" U.S.F. 1.06 FULL THREAD PITCH DIA. 3/32" - 3512 REAM 3/32" .25 DEEP 3 HOLES.



HEAT TREAT AT FOUNDRY
CHILL FACE OF FUEL PUMP ECCENTRIC AND LIFTS OF ALL CAMS TO SCLEROSCOPE 65 MIN.
BEARINGS AND BASE CIRCLE OF CAMS NOT TO BE CHILLED
BEARINGS BRINELL HARDNESS 262-293
SCLEROSCOPE HARDNESS 45-52
ALLOY CAST IRON.

AVERAGE ANALYSIS	OPTIONAL ANALYSIS
TOTAL CARBON - 3.10-3.60	TOTAL CARBON 3.20-3.40
SILICON - .210-.240	SILICON 2.10-2.40
SULPHUR - .10 MAX.	SULPHUR .010 MAX.
PHOSPHORUS - .20 MAX.	PHOSPHORUS .020 MAX.
MANGANESE - .50-.75	MANGANESE .070-.090
CHROMIUM - .75-1.00	CHROMIUM .080-1.00
NICKEL - .20-.40	COPPER .050-.075
MOLYBDENUM - .040-.060	MOLYBDENUM .040-.060

GPW6250



SECTION C-C

CRANKSHAFT TIMING - FIRING ORDER 1-3-4-2
INTAKE ADJUSTED TO .014 CLEARANCE
EXHAUST ADJUSTED TO .014 CLEARANCE.

14 NORMAL PITCH 12 TEETH INVOLUTE PRESSURE ANGLE 14 1/2°
ANGLE WITH AXIS 59° 34'
HELICAL LEAD 3.123 P.H.
CHORDAL THICKNESS .1121 - .1111
CORRECTED ADDENDUM .0719
ALLOWABLE ECCENTRICITY .002
MUST BE CUT TO HAVE .001-.003 BACKLASH WHEN MATED WITH MASTER OIL PUMP GEAR AT 1.343 CENTERS

PLACE LETTER IN SCRIPT IN CONVENIENT PLACE

BRINELL HARDNESS ON CAMS 912 MIN. FILE HARD
BRINELL HARDNESS ON BEARINGS 255 MIN.

CAMSHAFT
TYPE E CAST IRON

SHT. 1 OF 2 SHOTS

DESIGN	11-8-41	CHK. D.K.	11-8-41
DATE	11-8-41	CHK. D.K.	11-8-41
DRAWN BY	F.SCHIFFER	CHK. D.K.	11-8-41
DATE	11-8-41	CHK. D.K.	11-8-41
DESIGN	11-8-41	CHK. D.K.	11-8-41
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DRAWN BY	F.SCHIFFER	CHK. D.K.	11-8-41
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DESIGN	11-8-41	CHK. D.K.	11-8-41
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DRAWN BY	F.SCHIFFER	CHK. D.K.	11-8-41
DATE	11-8-41	CHK. D.K.	11-8-41

GPW-6250