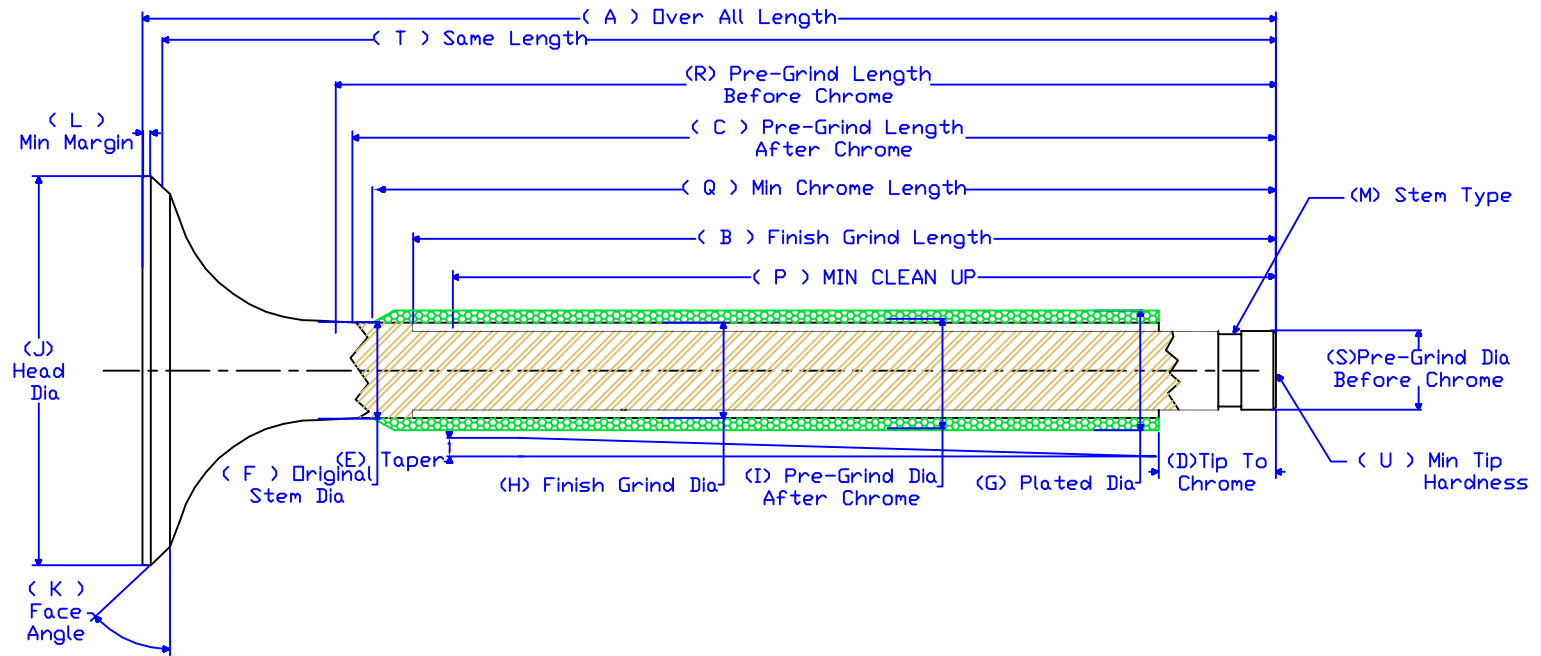
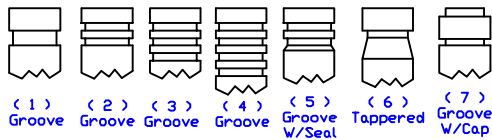


CAL GRINDING, INC. TYPICAL TOLERANCES FOR VALVE REMANUFACTURING

B	+ 0 / - 1/16 IN.	STEM LOBBING FINISH GROUND: 0.0002 IN. MAX
C	+ 1/16 / - 0 IN.	STEM FINISH: 18 RA MAX
D	+/- 1/32 IN.	FACE RUNOUT: 0.0015 IN.
E	0.0007 IN. (WHEN REQUIRED)	FACE FINISH: 32 RA MAX
H	+/- 0.00035 IN.	TIP HARDNESS: 48 HRC MIN.
I	+/- 0.001 IN.	
K	+/- 0° 15'	
R	+/- 1/32 IN.	
S	+/- 0.0005 IN.	
T	+/- 0.005 IN.	



STEM EXAMPLES - NOT ALL INCLUSIVE



CAL GRINDING, INC.
1401 NORTH 26TH STREET
ESCANABA, MI 49829

1-800-523-5962
WWW.CALVALVES.COM

CONFIDENTIAL AND PROPRIETARY

ITEM	REQD	DRAWING/PART NO.	DESCRIPTION
BILL OF MATERIALS			
TYPICAL TOLERANCES			
UNLESS OTHERWISE SPECIFIED:			
1. ALL DIAS ARE IN INCHES.			
2. ALL DIMENSIONING AND TOLERANCING IS IN ACCORDANCE WITH ANSI Y14.5M-1986.			
3. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.			
4. ALL MACHINED SURFACE FINISHES = 125/			
5. DIMENSIONAL TOLERANCES ARE AS FOLLOWS:			
TWO PLACE DECIMALS =		±.010	
THREE PLACE DECIMALS =		±.005	
FOUR PLACE DECIMALS =		±.0005	
ANGLES =		±0° 30'	
6. STAMP DRAWING NO. ON ALL DETAILS			
DRAWN BY: HUK	DATE: 07-24-01	THIS DRAWING AND ALL INFORMATION CONTAINED HEREIN IS THE SOLE PROPERTY OF CAL GRINDING, INC. REPRODUCTION OF THIS DRAWING IS STRICTLY PROHIBITED WITHOUT AUTHORIZATION FROM CAL GRINDING, INCORPORATED.	
CHKD BY: MC	DATE: 07-24-01		
APVD BY:	DATE:	DESCRIPTION:	SCALE: None
DRAWING NO.:		REV.:	