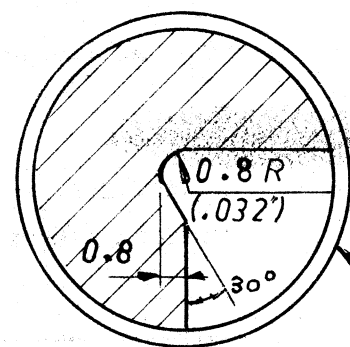


DRG. No. X1831042

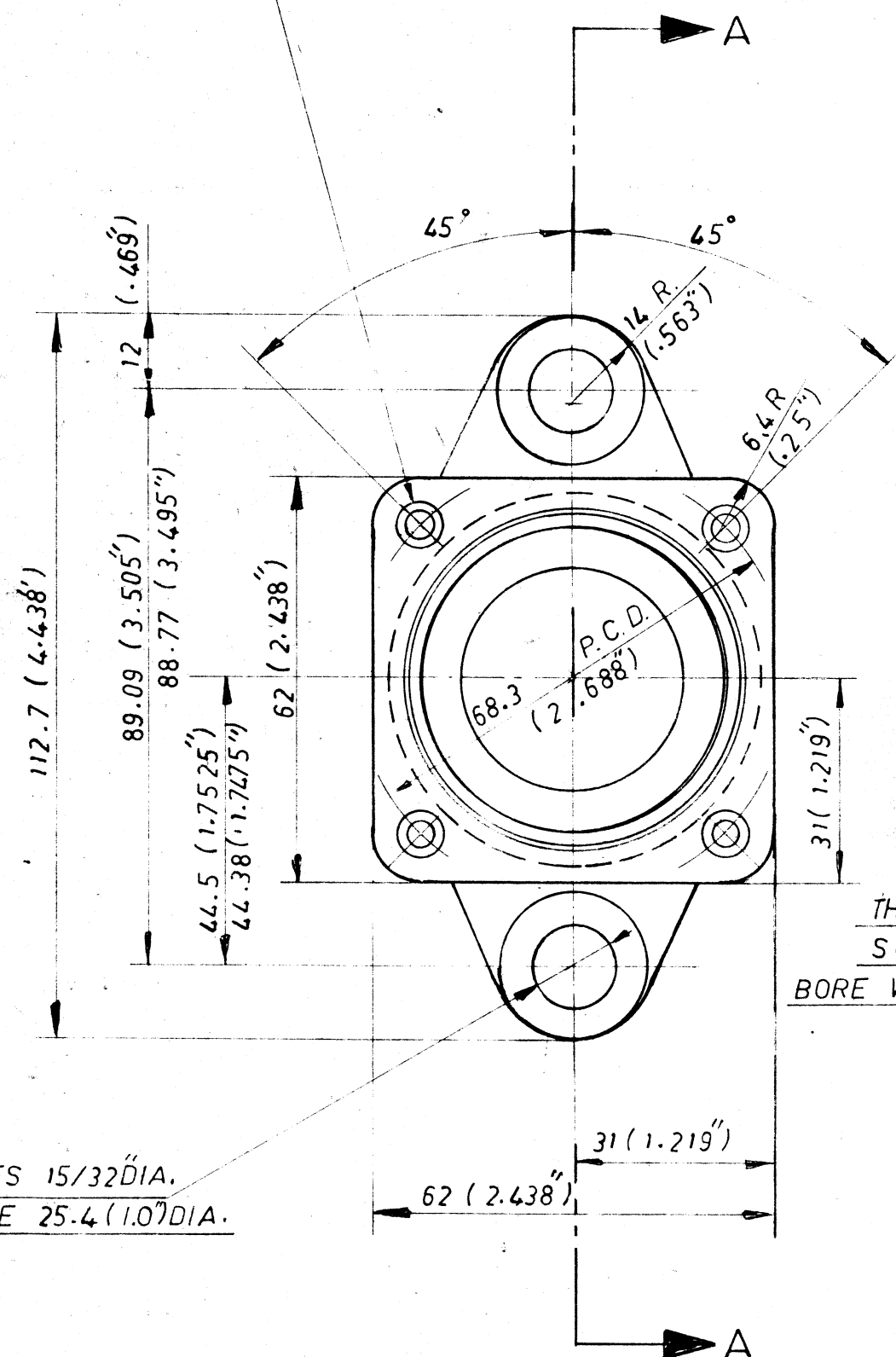
ALL DIMS ARE IN MM.
UNLESS OTHERWISE STATED.

4 HOLES DRILL 14.3 (9/16") DEEP
1/4"-20 UNC - 2B X 11 (7/16") DEEP

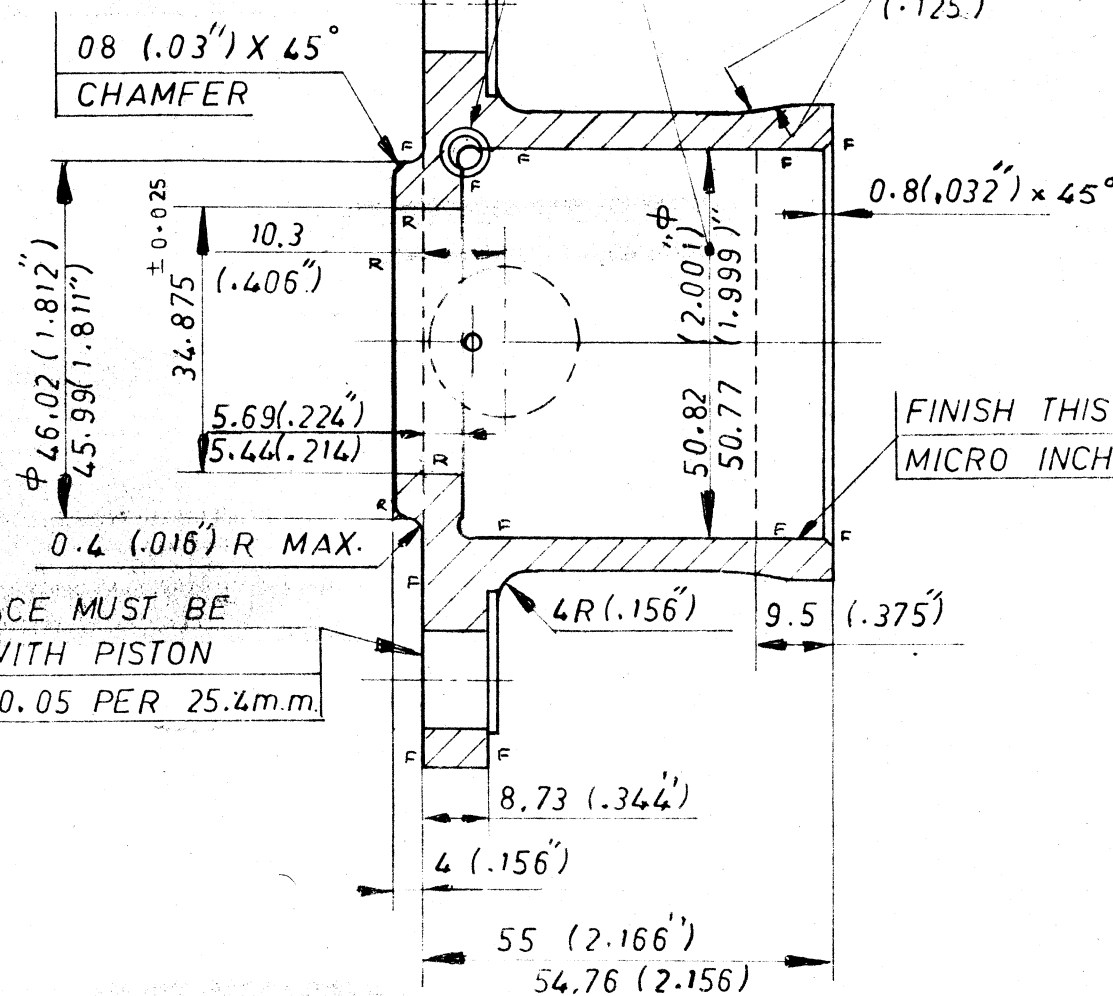


ENLARGED VIEW
OF UNDERCUT

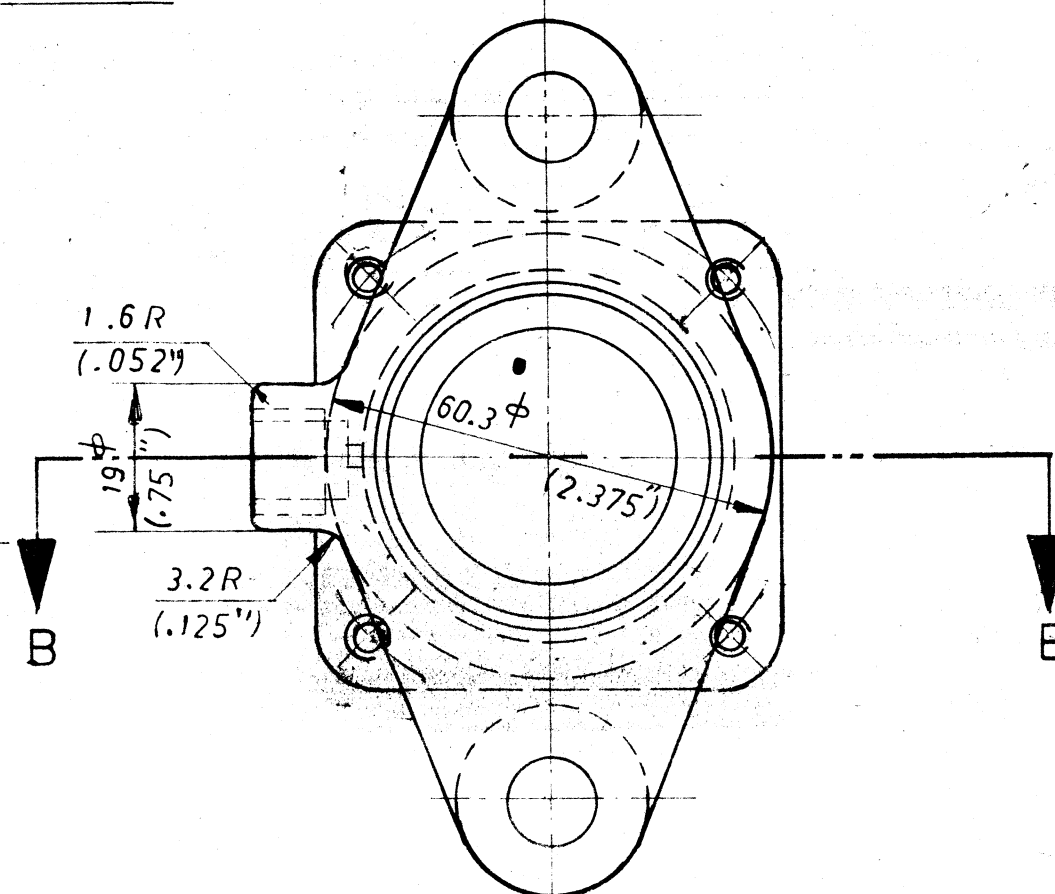
THIS DIA. MUST BE CONCENTRIC WITH 46/45.99 (1.812"/1.811")
WITH IN 0.05 (0.002") TOTAL INDICATOR READING.



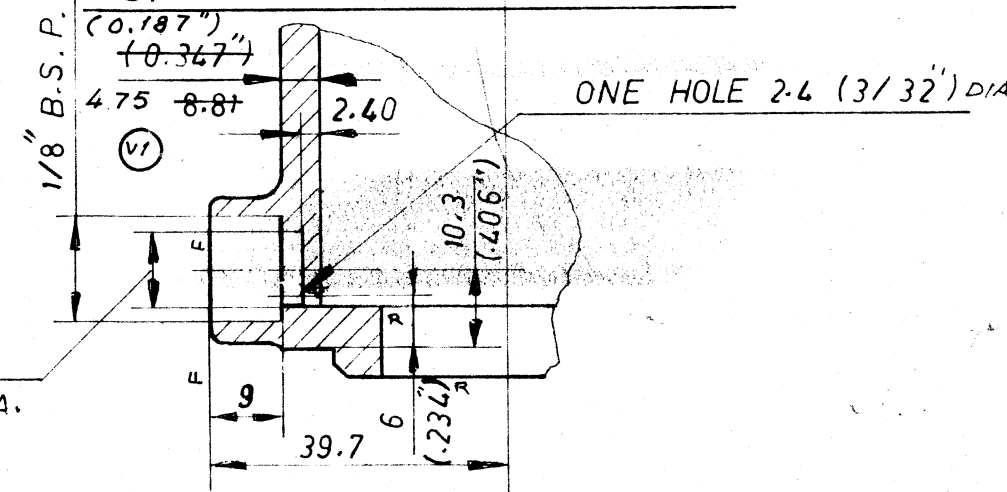
THIS SURFACE MUST BE
SQUARE WITH PISTON
BORE WITHIN 0.05 PER 25.4mm.



SECTION A - A



SCARP SECTION B - B



END MILL TO
THREAD ROOT DIA.

MATERIAL — CAST ALUM B.S.-1490 LM 21 M

NOTE — CYLINDER TO WITHSTAND AT LEAST
90 lb/SQ. IN. AIR PRESSURE WITHOUT LEAKAGE.
— ALTERNATE MATERIAL SPECIFICATION
CAST ALUMINIUM LM4M AS PER B.S.-1490

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SIGNATURE

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PART NO.	DESCRIPTION	MATERIAL	NO. OFF.	DRG. NO.	DIFFERENCE
50128-01M	SHIFT CYLINDER BODY	CAST ALUM B.S.-1490 LM 21 M		X1831042	
50128-01M (0.187") 4.75 WAS VI (0.347") 8.81MM. DRAWING RETRACED.					
Index: 1. Unmachined 2. Rough 3. Smooth 4. Hard 5. Harden 6. Final					
For: AUX. GEAR BOX Group: STALLION MARK-III					
VEHICLE FACTORY JABALPUR.					
Scale: 1:1 Replaced By: JGM/TS Replacement for: X1831042					

V1
A