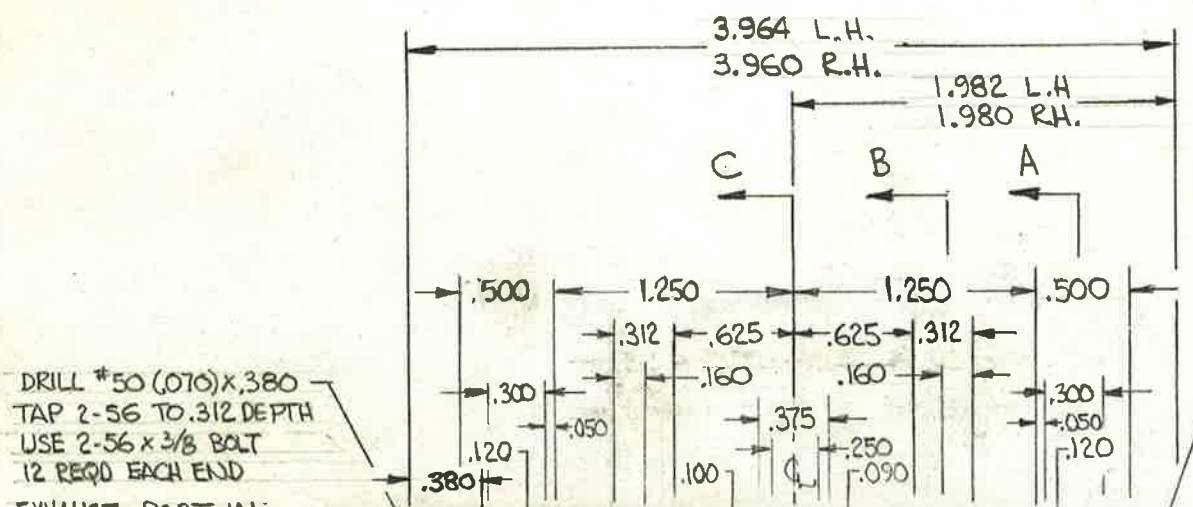
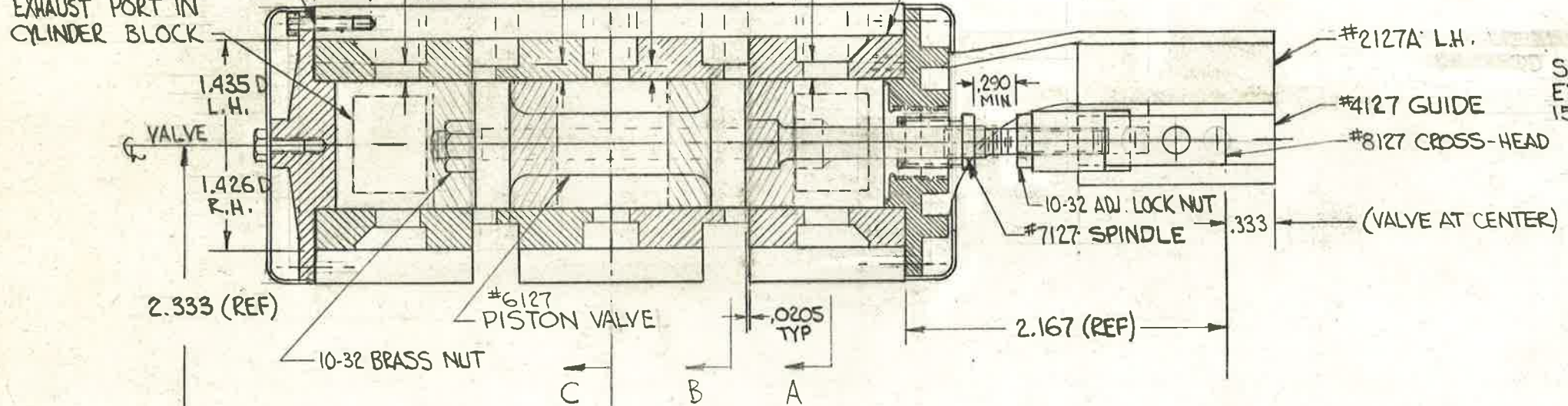
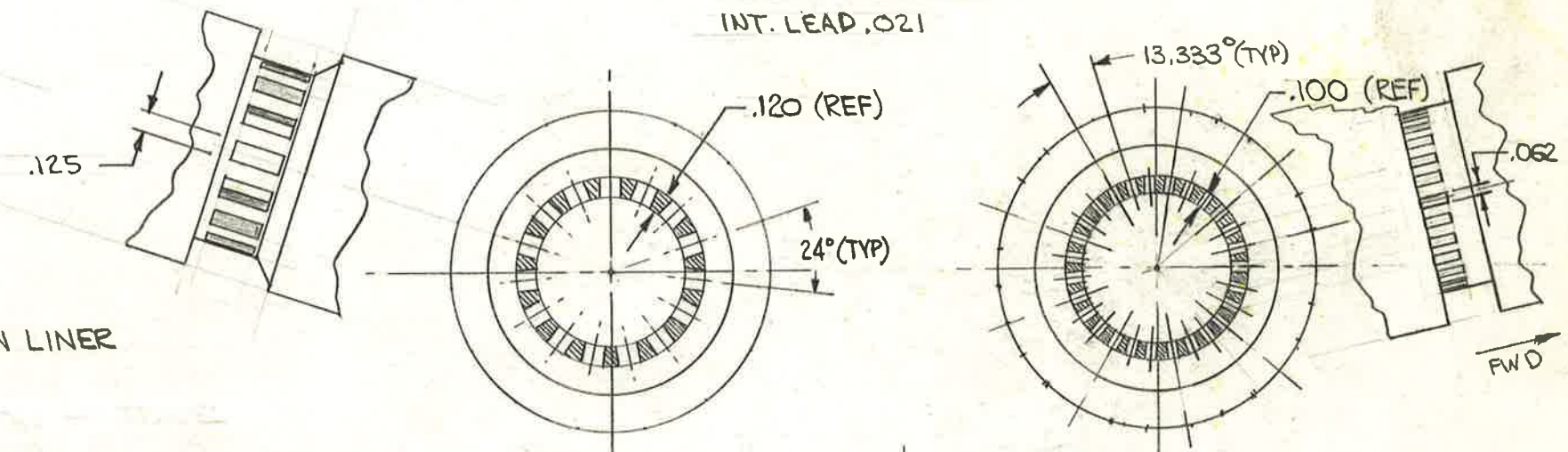


27 PORTS PER CIRCLE @ 13.333° APART
 NOTE: 15 PORTS PER CIRCLE @ 24° APART
 EXH. LAP -.0205
 INT. LEAD .021

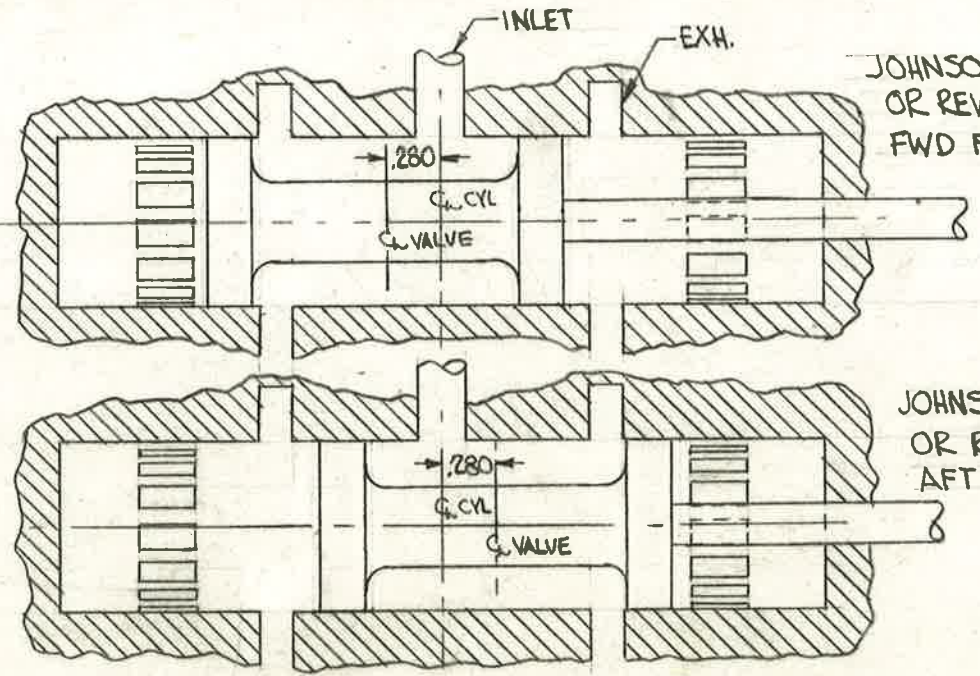
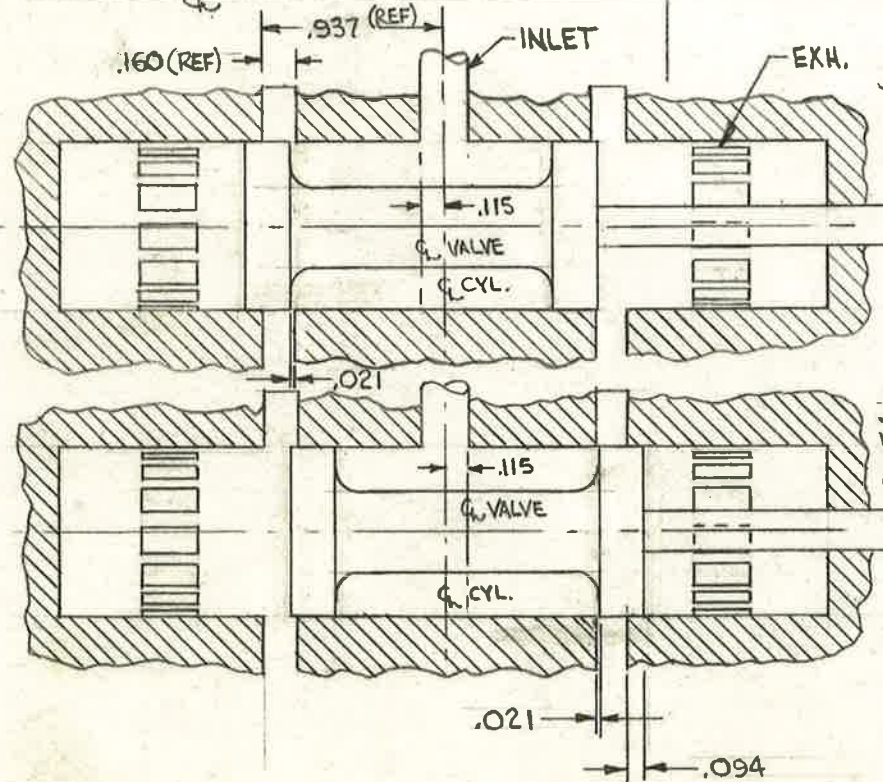


DRILL #50 (.070) x .380
 TAP 2-56 TO .312 DEPTH
 USE 2-56 x 3/8 BOLT
 12 REQD EACH END
 EXHAUST PORT IN
 CYLINDER BLOCK

CAST IRON LINER



CYLINDER (REF)



PISTON VALVE ASSY &
 VALVE SLEEVE DETAIL
 1" B40 P-7
 PISTON VALVE
 I.D. ALKIRE 1961