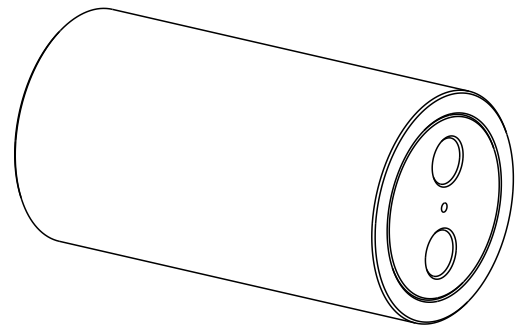
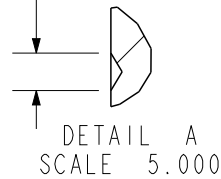




SCALE 1.250

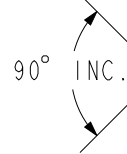
BREAK EDGE 0.008-0.012
[0,21-0,30]
EDGE MUST BE BROKEN BOTH ENDS
(CRITICAL TO SOLENOID PERFORMANCE)

Ø0.039 [0,99] MAX (BOTH ENDS)
CRITICAL - MUST NOT BE OVERSIZED



CHAMFER 45° X 0.005-0.015 [0,13-0,38]
BOTH HOLES / BOTH ENDS

0.005-0.010
[0,13-0,25]



DETAIL B
SCALE 5.000

0.002 [0,05] A
0.002 [0,05]

[0.8]
Ra 32
GROUND

0.002 [0,05] A
0.002 [0,05]

Ø0.990-0.992
[25,15-25,19]
0.001 [0,02] M
0.0005 [0,012] L
-A-

1.862-1.868
[47,30-47,44]

2 X Ø0.7840-0.7910 [19,914-20,091]
V-GROOVE

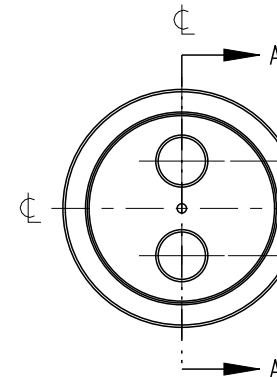
SEE DETAIL A

SEE DETAIL B

SECTION A-A
SCALE 1.250

Ø0.192-0.202
[4,88-5,13]

Ø0.192-0.202
[4,88-5,13]



0.192-0.202
[4,88-5,13]

0.192-0.202
[4,88-5,13]

NOTES

1. MATERIAL: COLD DRAWN AISI SAE 1215 STEEL Ø1.000" STOCK PER LISK ENGINEERING SPECIFICATION EM-110. ACCEPTABLE ALTERNATIVES ARE 220M07, 230M07 AND EN1A.
2. MACHINE AND DRILL TO DIMENSIONS SHOWN.
3. THROUGH HOLES MUST BE 180°±2° APART.

NOTICE

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ECN:	SEE ECNH-21356REVK		
K	REDRAWN IN PRO/E. IN NOTE #1 "EM-110" WAS "ES-002". ALL SECONDARY (METRIC) DUAL DIMENSIONS ROUNDED TO BE INSIDE LIMITS OF PRIMARY (IMPERIAL) DIMENSIONS. ADDED DETAIL VIEWS A AND B FOR CLARITY.	24MAR14	R.D.
REV.	DESCRIPTION	DATE	APPR.

DRAWN BY: K. LERNIHAN 24-Mar-14
CHECKED BY: N. DILLON 24-MAR-14
APPROVED BY: R. DEVITT 24-MAR-14

MATL:	EM-110 (SEE NOTE #1)	USED ON:	
HEAT:	N/A		D19-****
FINISH:	SEE NOTES	REF.	
WEIGHT:	173.5 g		---
3RD ANGLE PROJECTION			
UNLESS OTHERWISE SPECIFIED			
✓ Ra93	✓ Rmax600	EN-22768-mK TOLERANCE LEVELS	
↗ 0.005TIR	ALL DIA.	≠ RADIUS OR CHAMFER ACCEPTABLE	
◎ 0.004TIR	ALL DIA.	BREAK ALL EDGES 0.010 MAX	
UNITS: INCH [mm]		fSMOOTH FINISH FOR APPEARANCE ONLY	

LISK

LISK IRELAND Ltd., Ennis Rd., Gort, Co. Galway.

DESCRIPTION

PLUNGER

PART No.		REV.
H-21356		K
SIZE	SCALE: 1.000 DO NOT SCALE	SHEET NO. 1 of 1

PART NUMBER: H-21356