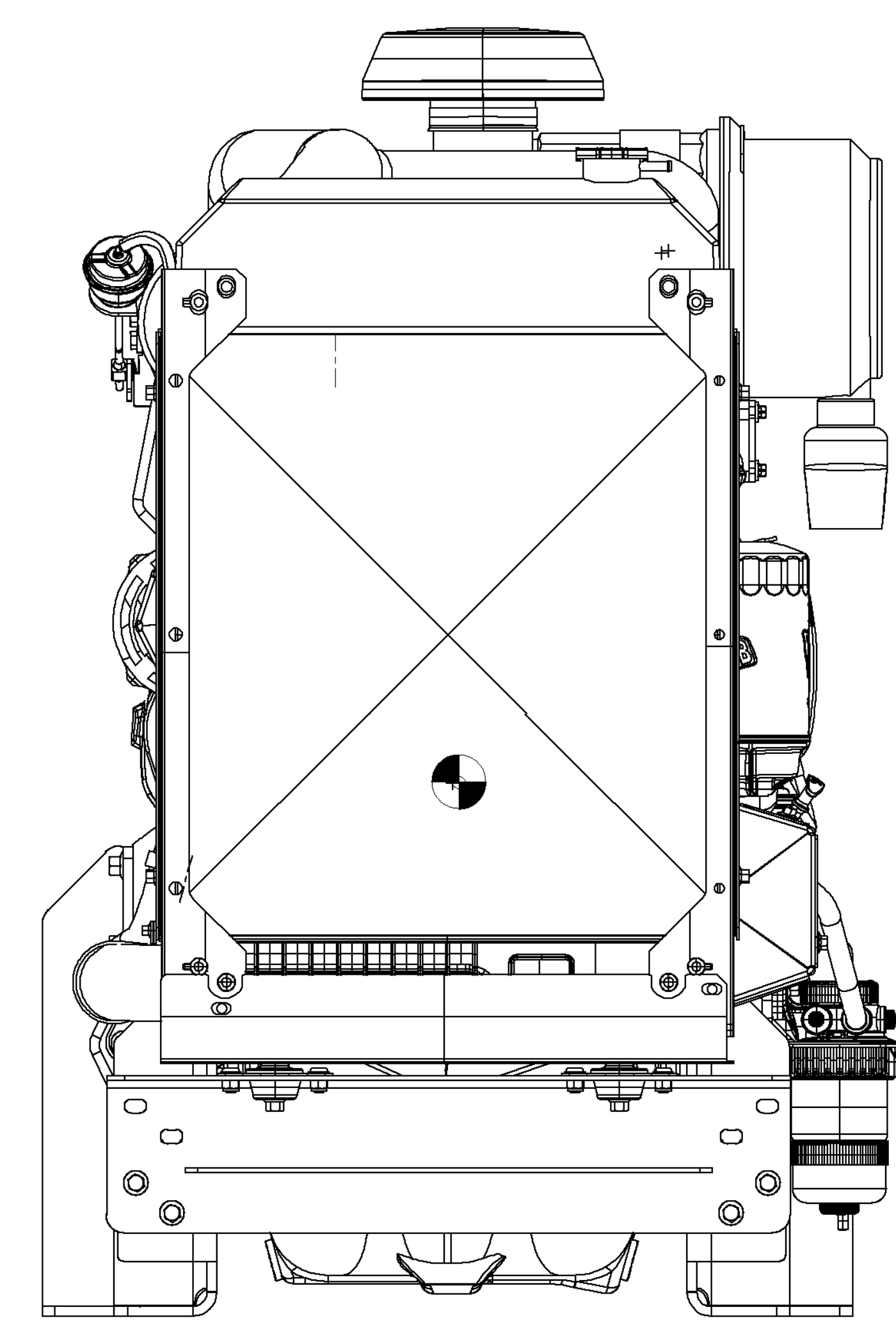
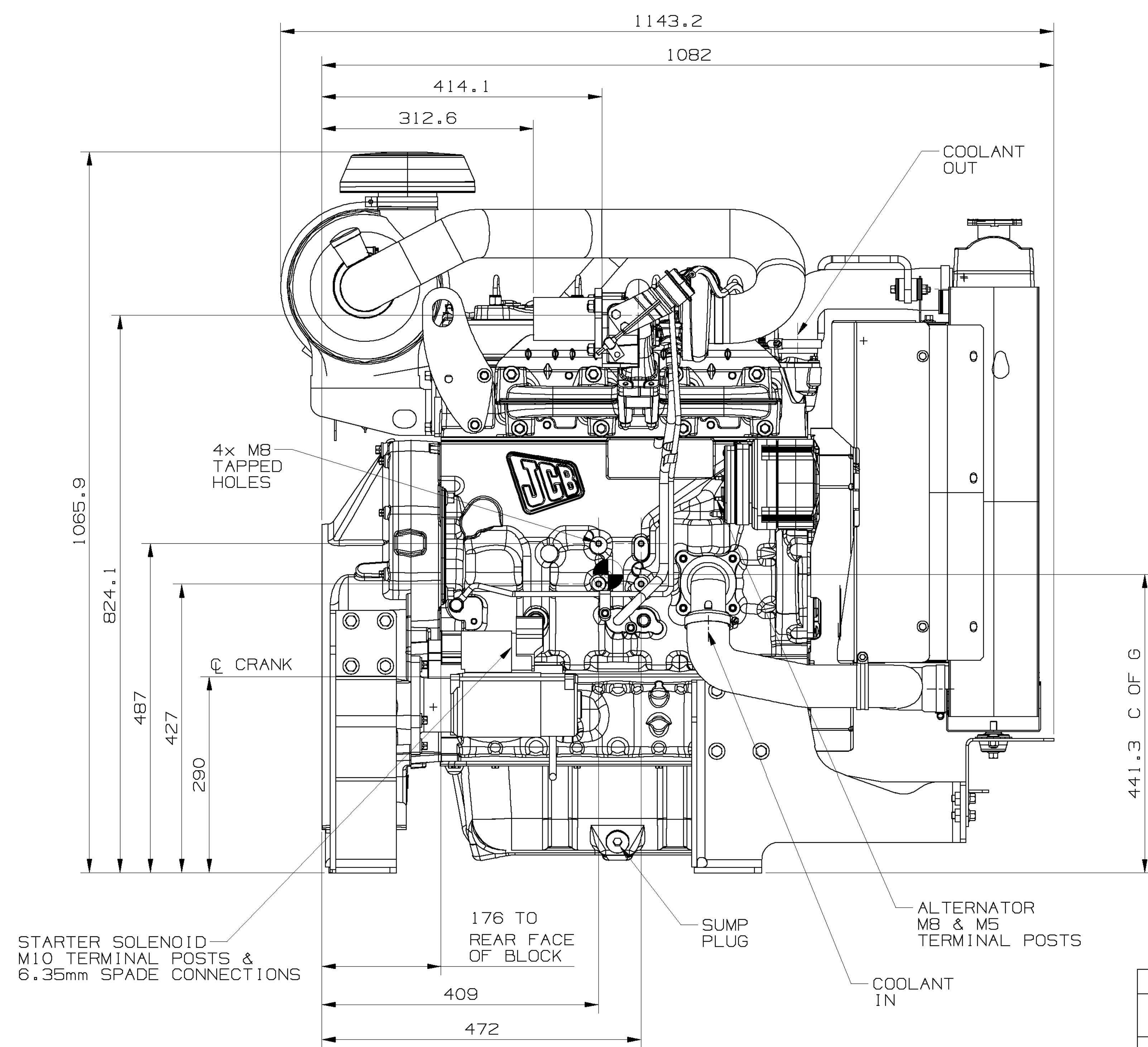
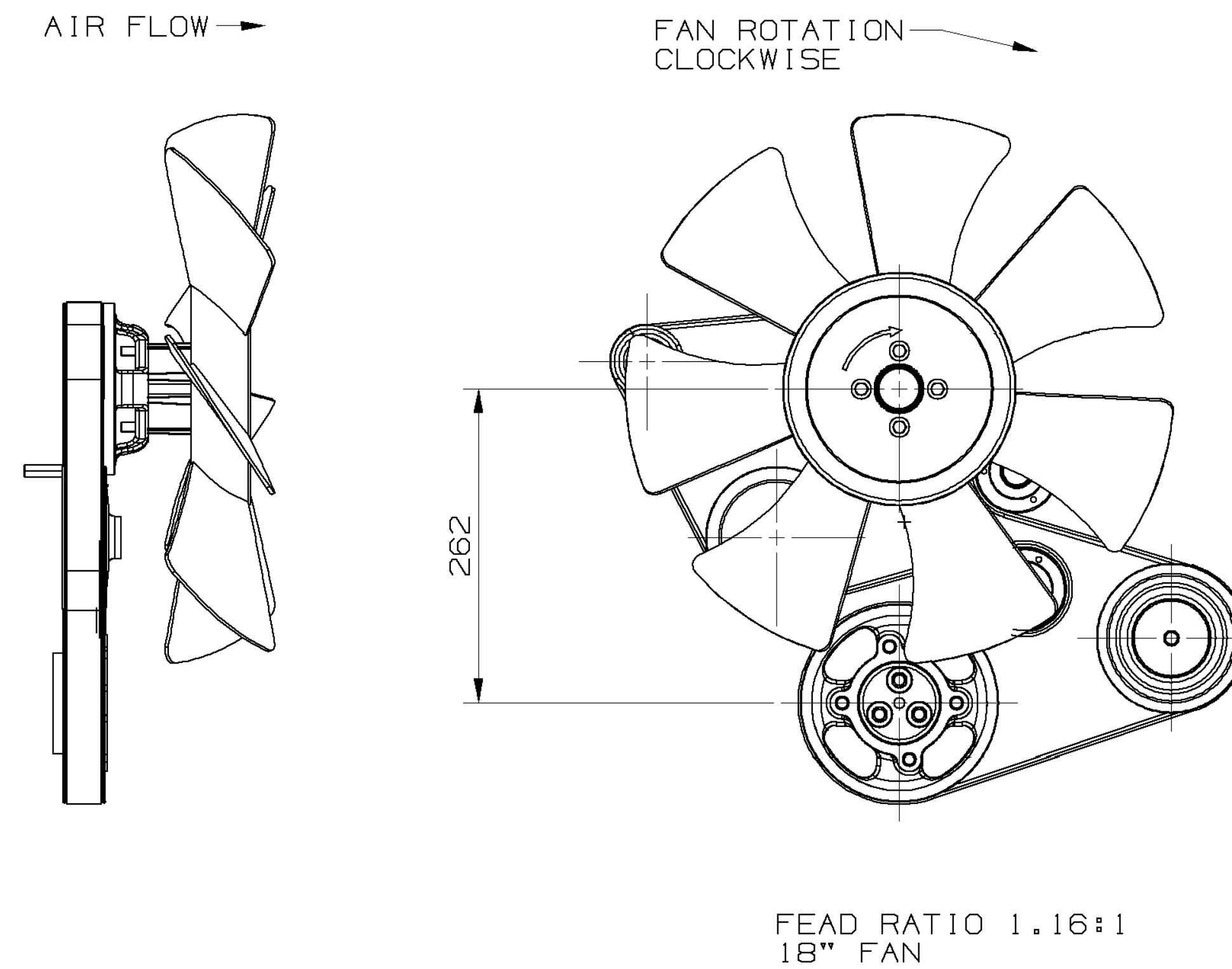
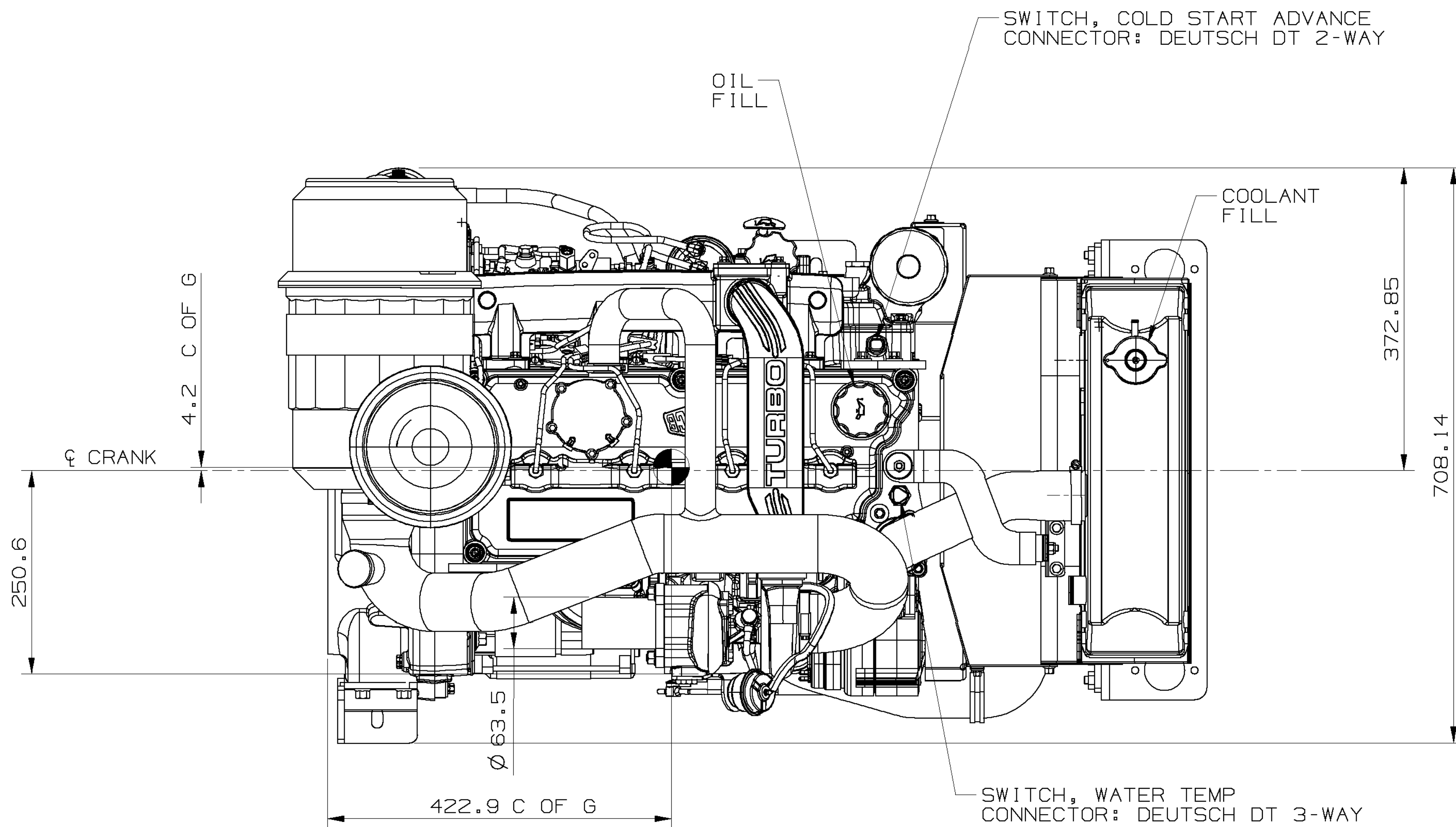


ALL DIMENSIONS IN mm IF IN DOUBT, ASK DO NOT SCALE DRAWING

PI No	X05/0081B	
ISSUE	DRAWN	DATE
1	D SAYSELL	02/06
PRODUCTION RELEASE		
PI No	X06/0050	
ISSUE	DRAWN	DATE
2	A ROYLE	09/06
ENGINE GA No. CHANGED WAS 320/50017. VIEWS UPDATED TO REFLECT CHANGES TO COOLANT GRP AND INDUCTION GRP		
PI No	X06/0113A	
ISSUE	DRAWN	DATE
3	A ROYLE	02/07
VIEWS UPDATED TO REFLECT CHANGES TO IPU GA. RELEASED ON eP1 C00254-AA.		

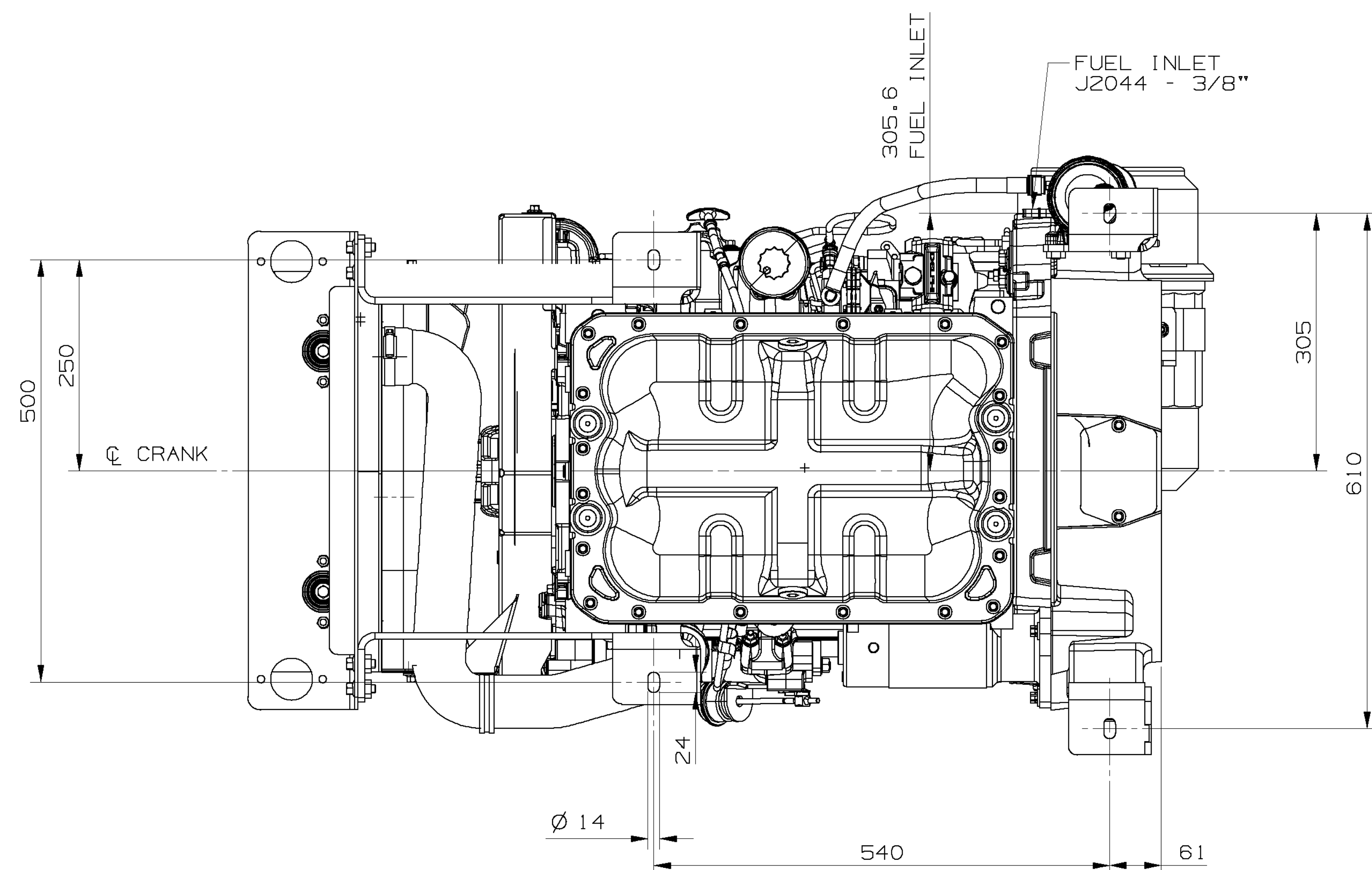
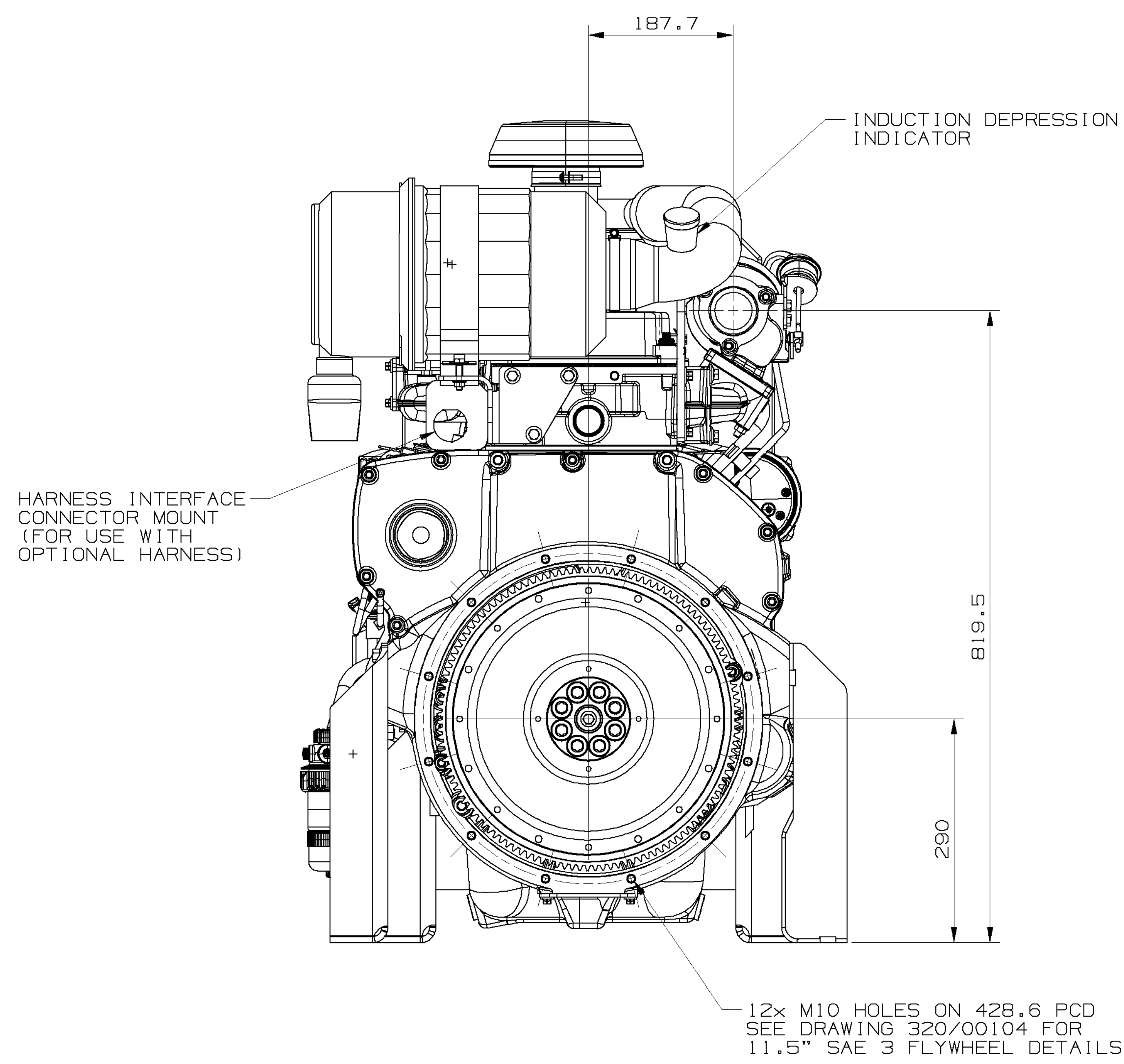
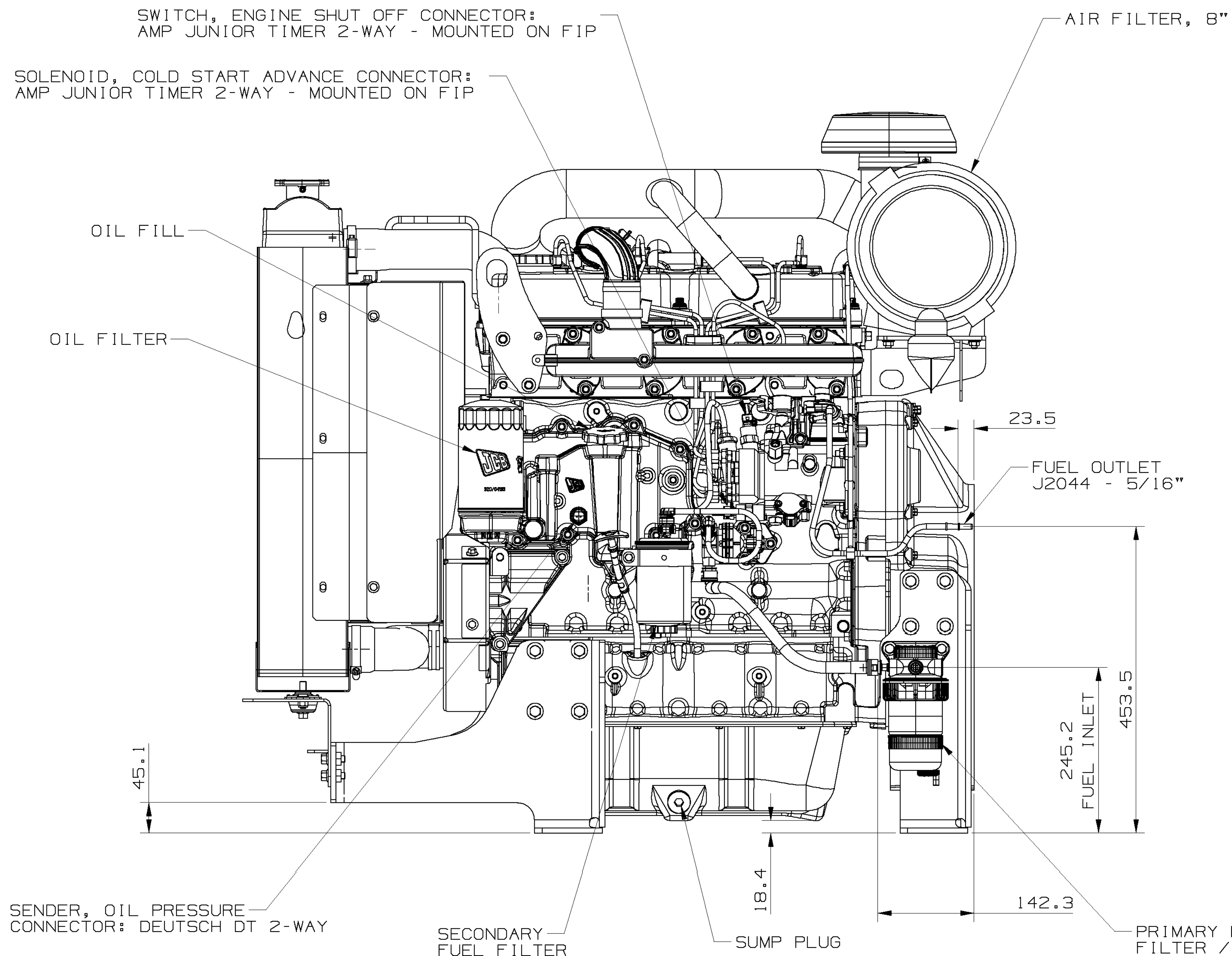


NOTES:
 WEIGHT = 586 KG DRY
 CENTRE OF GRAVITY SHOWN THUS LOCATED:
 X = 246.9
 Y = 4.2
 Z = 151.3
 FROM REAR FACE OF CYLINDER BLOCK,
 CRANKSHAFT

LINEAR DEVIATIONS		PERMISSIBLE DEVIATIONS FOR SIZE RANGE							MATERIAL		TITLE				
DIMENSION IN mm	0.5 UP TO 3	OVER 3 UP TO 6	OVER 6 UP TO 30	OVER 30 UP TO 120	OVER 120 UP TO 400	OVER 400 UP TO 1000	OVER 1000 UP TO 2000	OVER 2000 UP TO 4000	SEE DETAILS		TC IPU INSTALLATION DETAILS (B/W TURBO)				
	---	±0.5	±1	±1.5	±2.5	±4	±6	±8	FINISH		DRAWING NUMBER				
EXTERNAL RADII & CHAMFERS									SEE DETAILS		320/00111				
	±0.4	±1	±2									SHEET NUMBER		SCALE	
ANGULAR DEVIATIONS											1 OF 2				
SHORTER SIDE OF ANGLE mm	UP TO 10	OVER 10 UP TO 50	OVER 50 UP TO 120	OVER 120 UP TO 400	OVER 400										
	±3'	±2'	±1'	±0' 30"	±0' 20"										
GEOMETRIC TOLERANCE DEVIATIONS									HEAT TREATMENT		THIS DRAWING IS THE PROPERTY OF				
	UP TO 10	OVER 10 UP TO 30	OVER 30 UP TO 100	OVER 100 UP TO 300	OVER 300 UP TO 1000	OVER 1000 UP TO 3000	DRAWN		DATE		J.C.BAMFORD				
STRAIGHT/FLAT	0.05	0.1	0.2	0.4	0.6	0.8	A ROYLE		28/06/05		EXCAVATORS LTD				
PERPENDICULAR	0.4	0.4	0.4	0.6	0.8	1	DRAWN IN ACCORDANCE WITH STD 00024		BUSINESS UNIT		ROCESTER STAFFORDSHIRE ENGLAND				
									CIRCULAR RUN-OUT		MASS (kg)				
									0.2		SEE NOTES				
									TOLERANCES COMPLY TO STD 00023 VERY COARSE		GEOMETRIC TOLERANCE K		& MUST NOT BE COPIED OR REPRODUCED WITHOUT WRITTEN CONSENT		

ALL DIMENSIONS IN mm IF IN DOUBT, ASK DO NOT SCALE DRAWING

PI No	X05/0081B	DATE	
ISSUE	DRAWN	DATE	
1	D SAYSELL	02/06	
PRODUCTION ISSUE			
PI No	X06/0050	DATE	
ISSUE	DRAWN	DATE	
2	A ROYLE	09/06	
ENGINE GA No. CHANGED WAS 320/50017. VIEWS UPDATED TO REFLECT CHANGES TO COOLANT GRP AND INDUCTION GRP			
PI No	X06/0113A	DATE	
ISSUE	DRAWN	DATE	
3	A ROYLE	02/07	
VIEWS UPDATED TO REFLECT CHANGES TO IPU GA. RELEASED ON ePI 00254-AA.			



LINEAR DEVIATIONS		PERMISSIBLE DEVIATIONS FOR SIZE RANGE								MATERIAL			TITLE		
DIMENSION IN mm	0.5 UP TO 3	OVER 3 UP TO 6	OVER 6 UP TO 30	OVER 30 UP TO 120	OVER 120 UP TO 400	OVER 400 UP TO 1000	OVER 1000 UP TO 2000	OVER 2000 UP TO 4000	SEE DETAILS			TC IPU INSTALLATION DETAILS (B/W TURBO)			
EXTERNAL RADIUS & CHAMFERS	---	±0.5	±1	±1.5	±2.5	±4	±6	±8	SEE DETAILS			DRAWING NUMBER			
ANGULAR DEVIATIONS	±0.4	±1	±2	HEAT TREATMENT			DRAWING NUMBER			SHEET NUMBER			SCALE		
SHORTER SIDE OF ANGLE	UP TO 10	OVER 10 UP TO 50	OVER 50 UP TO 120	OVER 120 UP TO 400	OVER 400	DRAWN			DATE			BUSINESS UNIT			
GEOMETRIC TOLERANCE DEVIATIONS	±3"	±2"	±1"	±0° 30'	±0° 20'	A ROYLE			28/06/05			Power-Systems			
STRAIGHT/FLAT	UP TO 10	OVER 10 UP TO 30	OVER 30 UP TO 100	OVER 100 UP TO 300	OVER 300 UP TO 1000	OVER 1000 UP TO 3000	DRAWN IN ACCORDANCE WITH STD 00024			THIS DRAWING IS THE PROPERTY OF			J.C.BAMFORD		
PERPENDICULAR	0.05	0.1	0.2	0.4	0.6	0.8	TOLERANCES COMPLY TO STD 00023 VERY COARSE			GEOMETRIC TOLERANCE K			ROCESTER STAFFORDSHIRE ENGLAND		
	0.4	0.4	0.4	0.6	0.8	1	CIRCULAR RUN-OUT			MASS (kg)			388		
							0.2								

