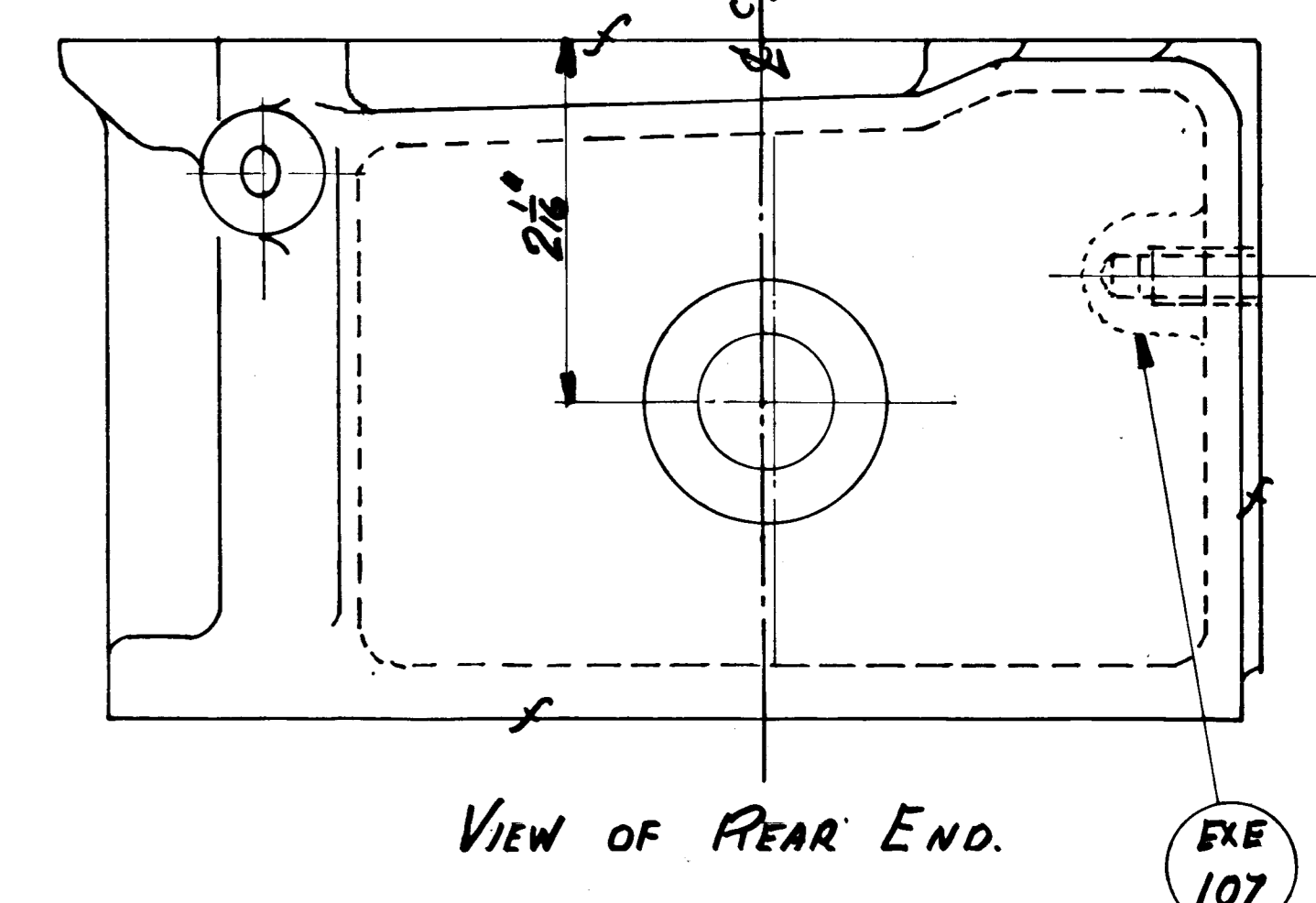
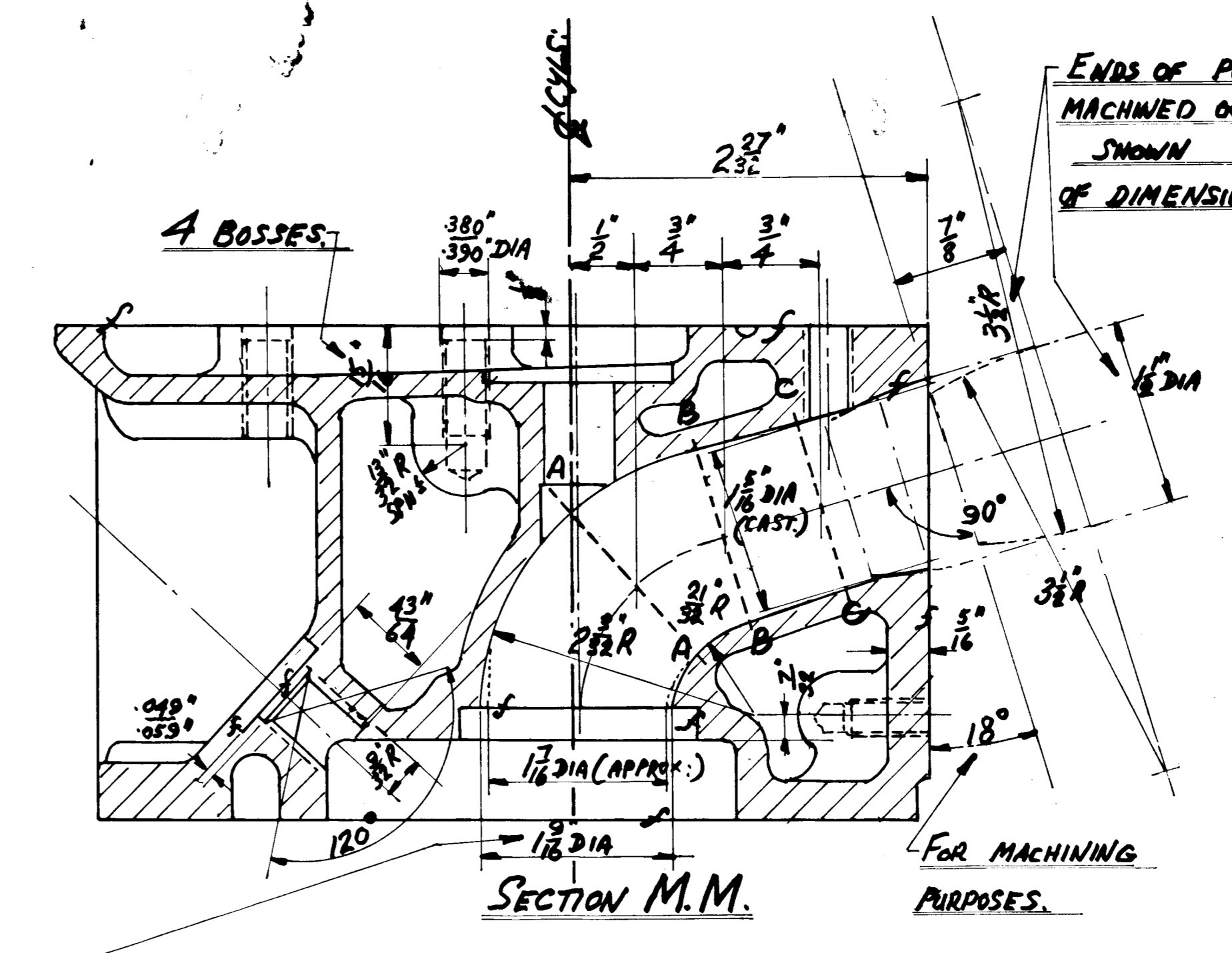
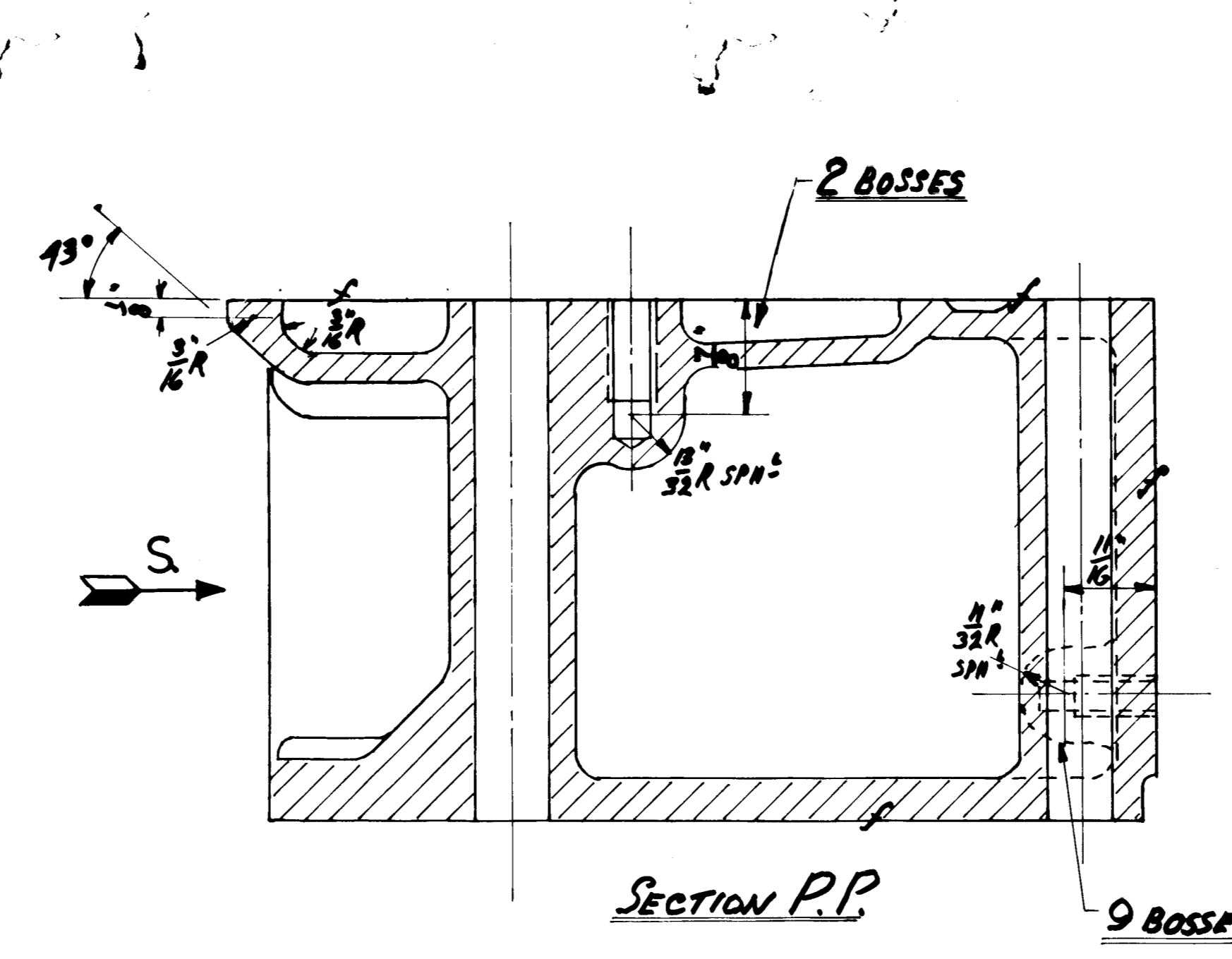
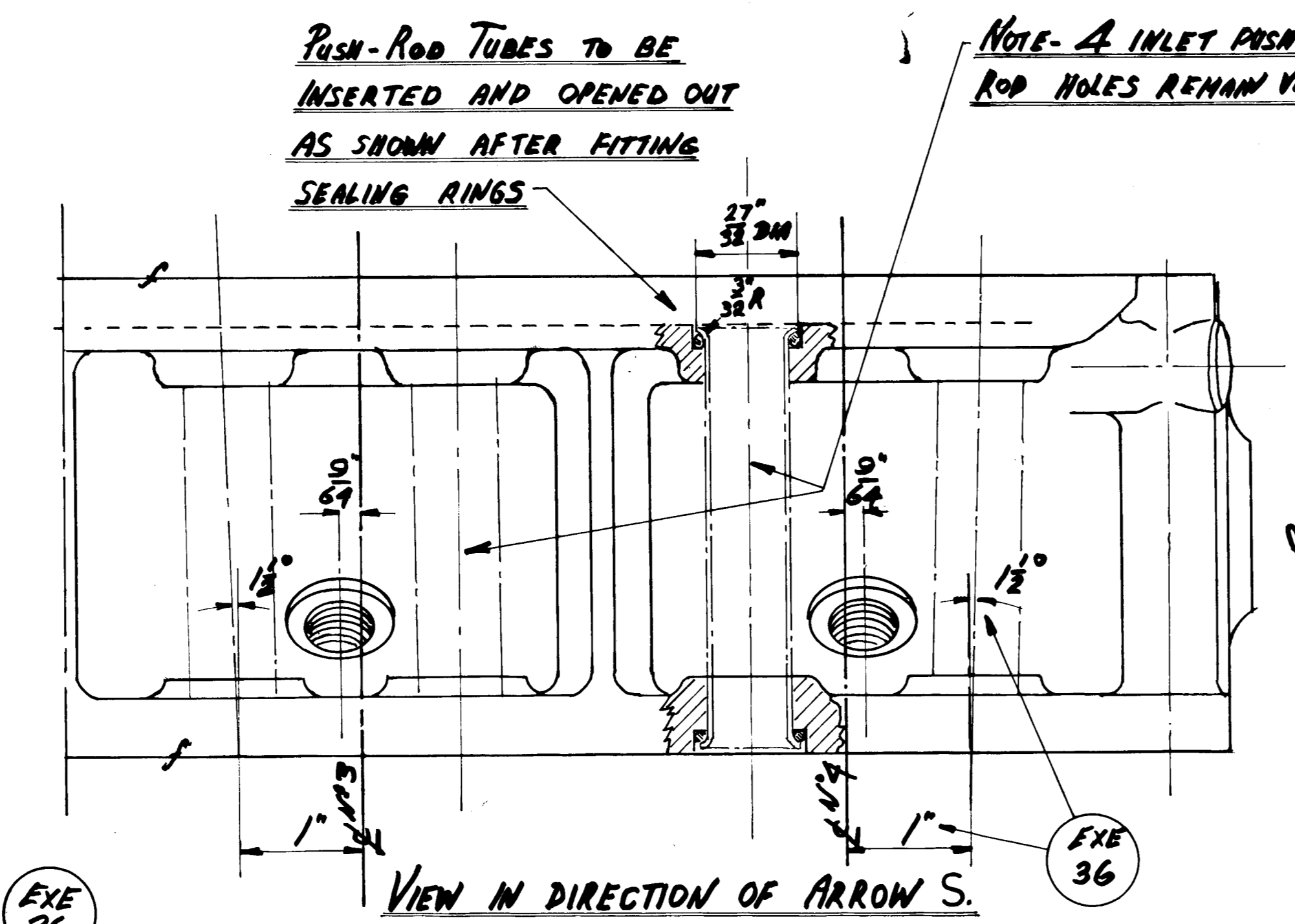
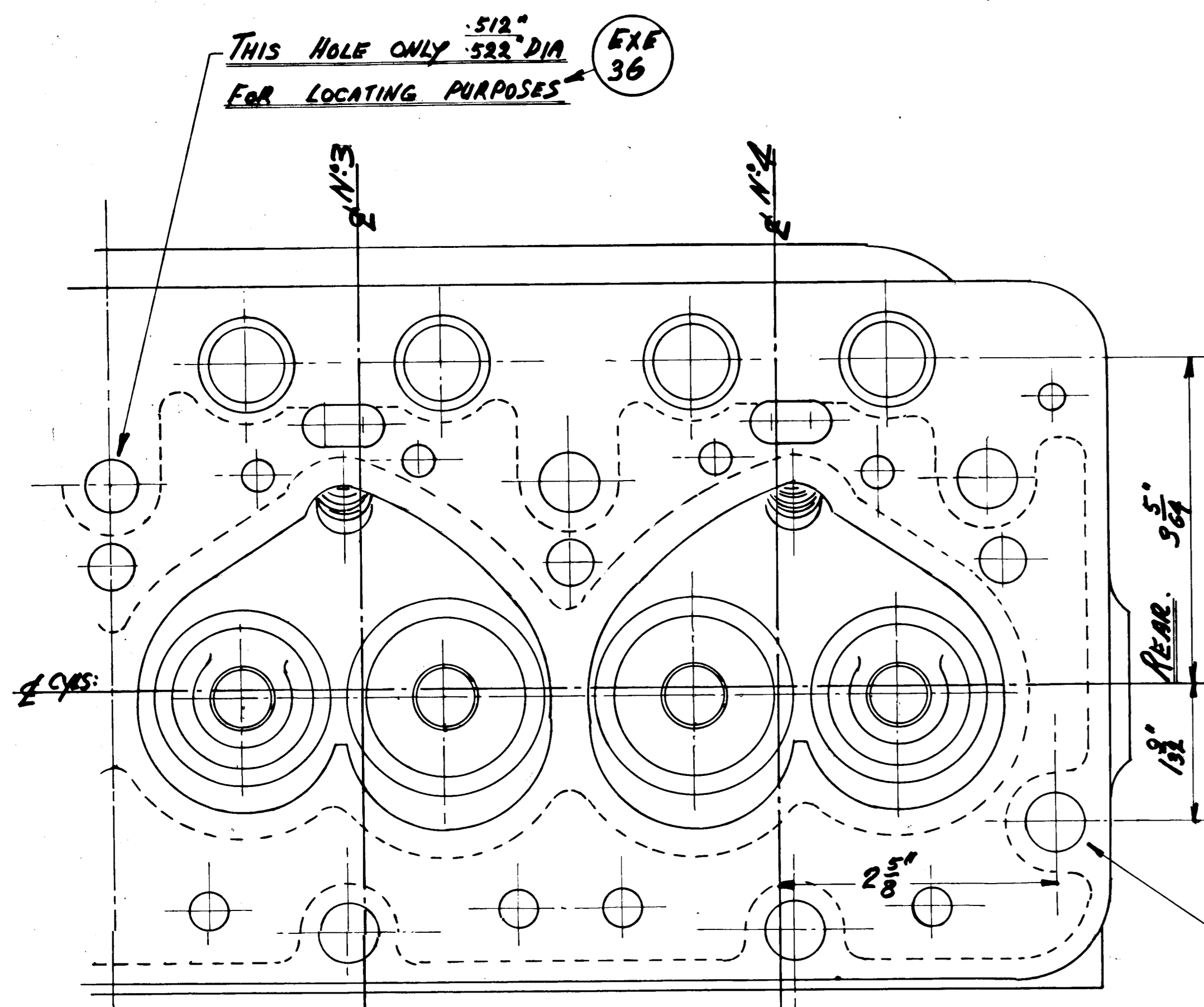


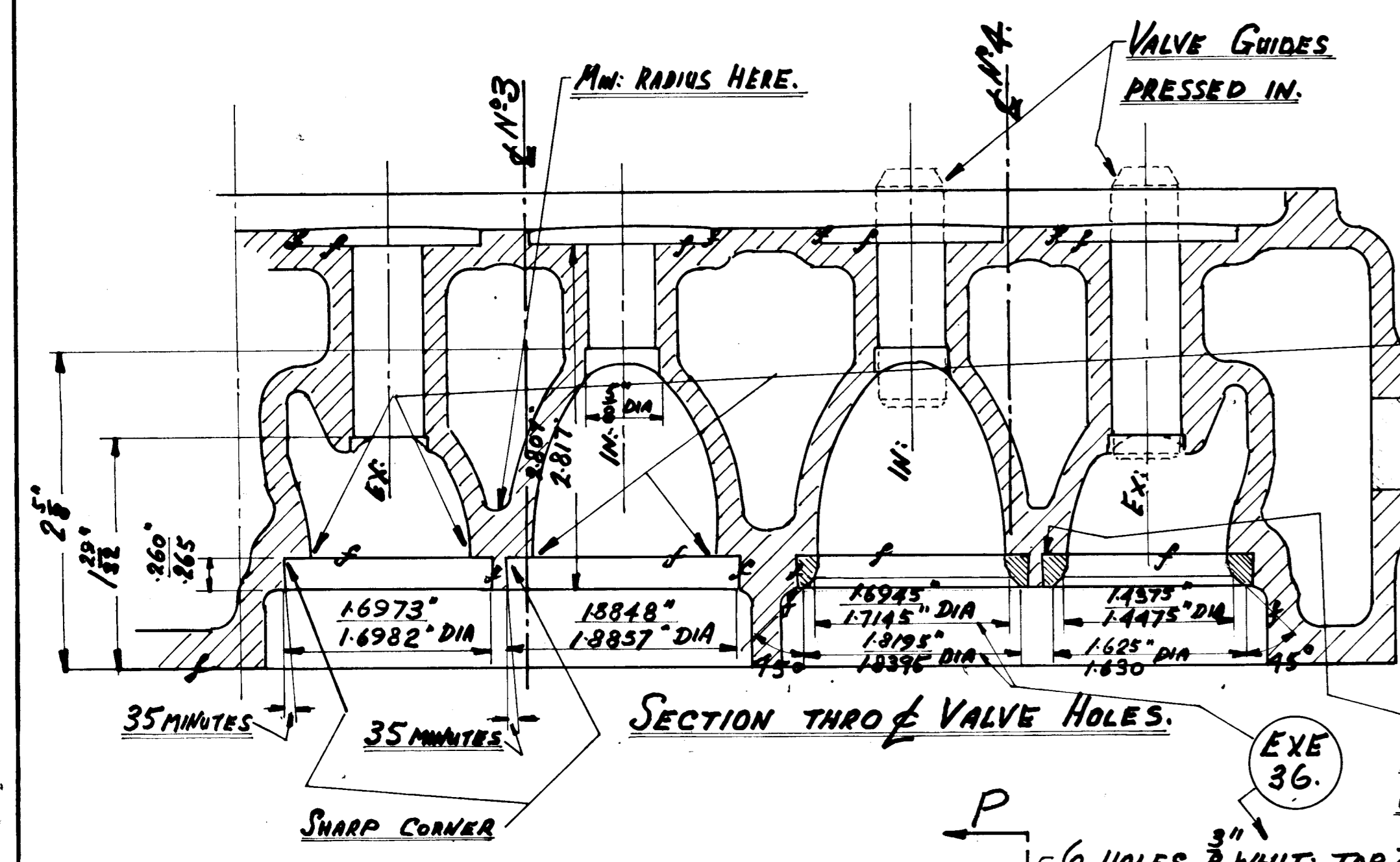
NOTE	ALTERATIONS
EXE 36	2 HOLES 1/8" DIA. MACHINED OUT TO DIM. GIVEN TO BE SECURELY PLUGGED TO MAKE WATER TIGHT JOINT. PLUG 9D7122 TO BE DRIVEN IN FLUSH.
EXE 41	2 HOLES 3/8" DIA. MACHINED OUT TO DIM. GIVEN TO BE SECURELY PLUGGED TO MAKE WATER TIGHT JOINT. PLUG 9D7122 TO BE DRIVEN IN FLUSH.
EXE 107	13 HOLES 1/8" B.S.F. DRILL 1/8" DEEP TAP 3/8" DEEP FULL THREAD.



INVERTED PLAN

10 HOLES 1/8" DIA DRILL.

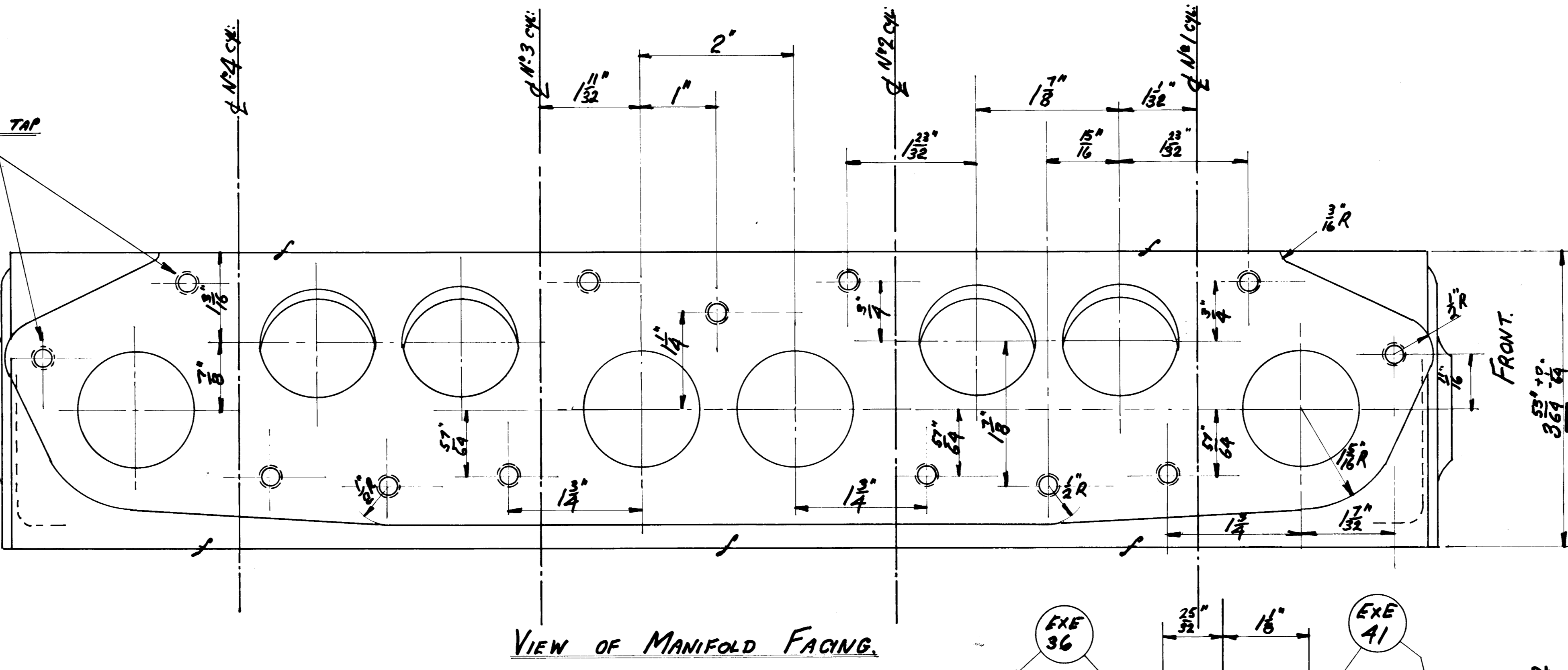
13 HOLES 1/8" B.S.F. DRILL 1/8" DEEP TAP 3/8" DEEP FULL THREAD.



IMPORTANT - THE PORT MUST BLEND SMOOTHLY & BE CONCENTRIC TO THE THROAT DIA. OF THE INSERT. NO LEDGES TO BE LEFT AT THESE POINTS.

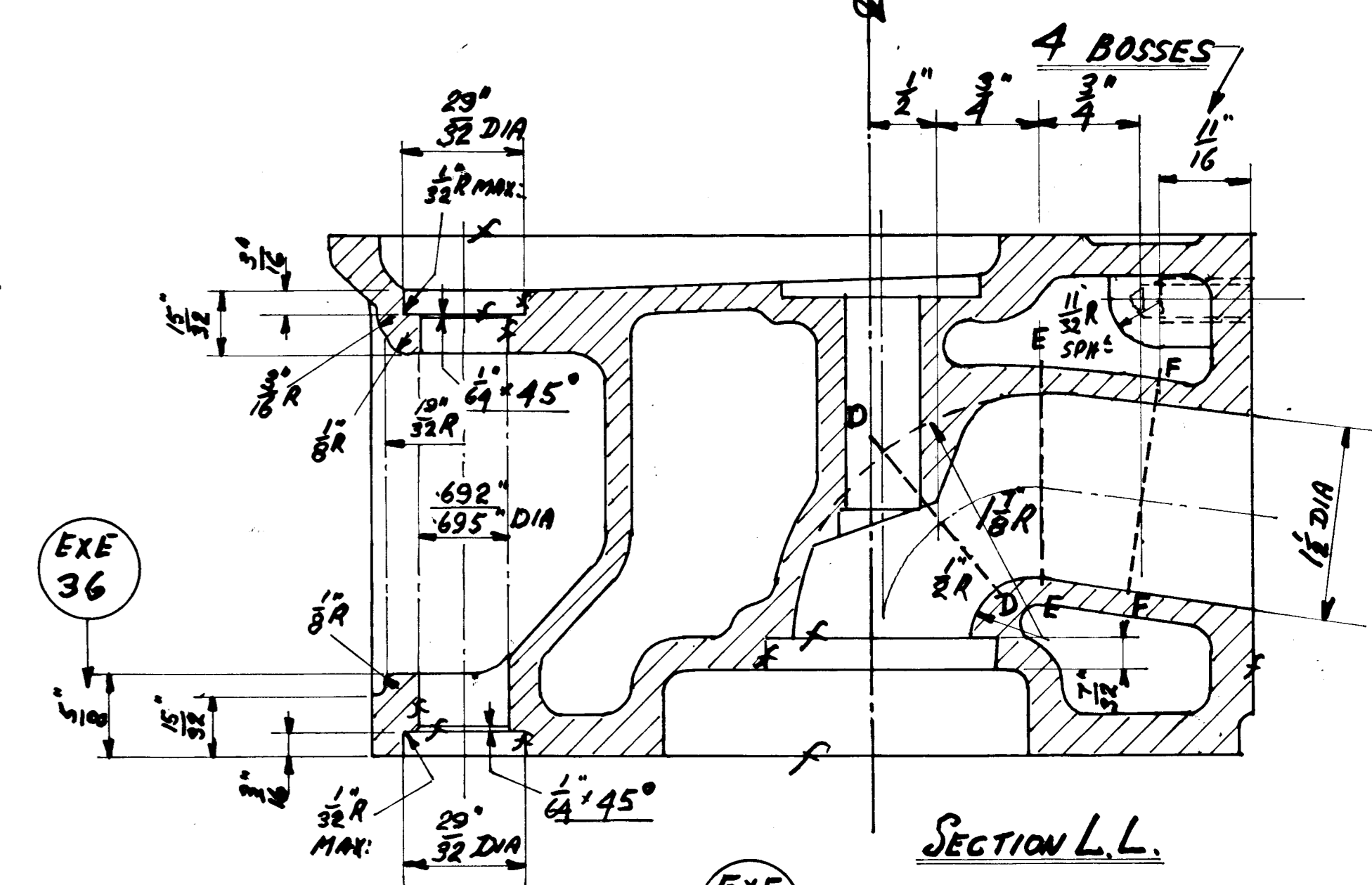
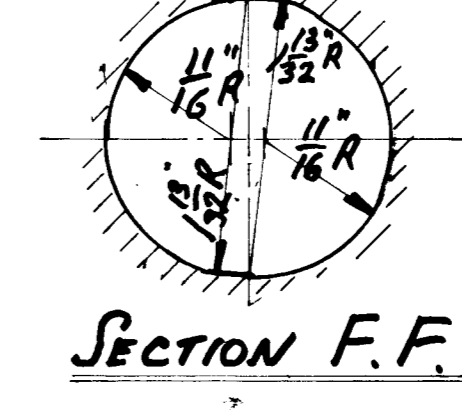
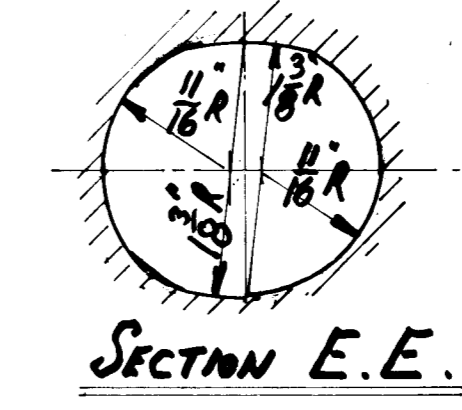
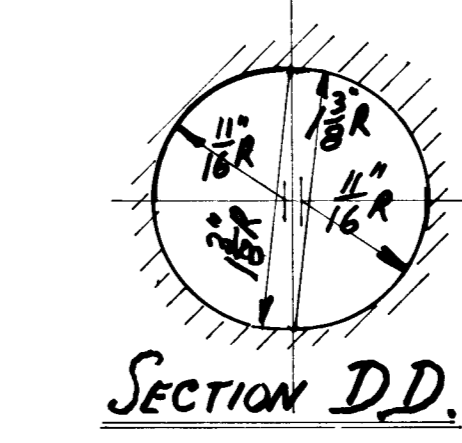
VALVE INSERTS PRESSED IN AND MACHINED TO DIMENSIONS GIVEN.

SECTION THRO VALVE HOLES.

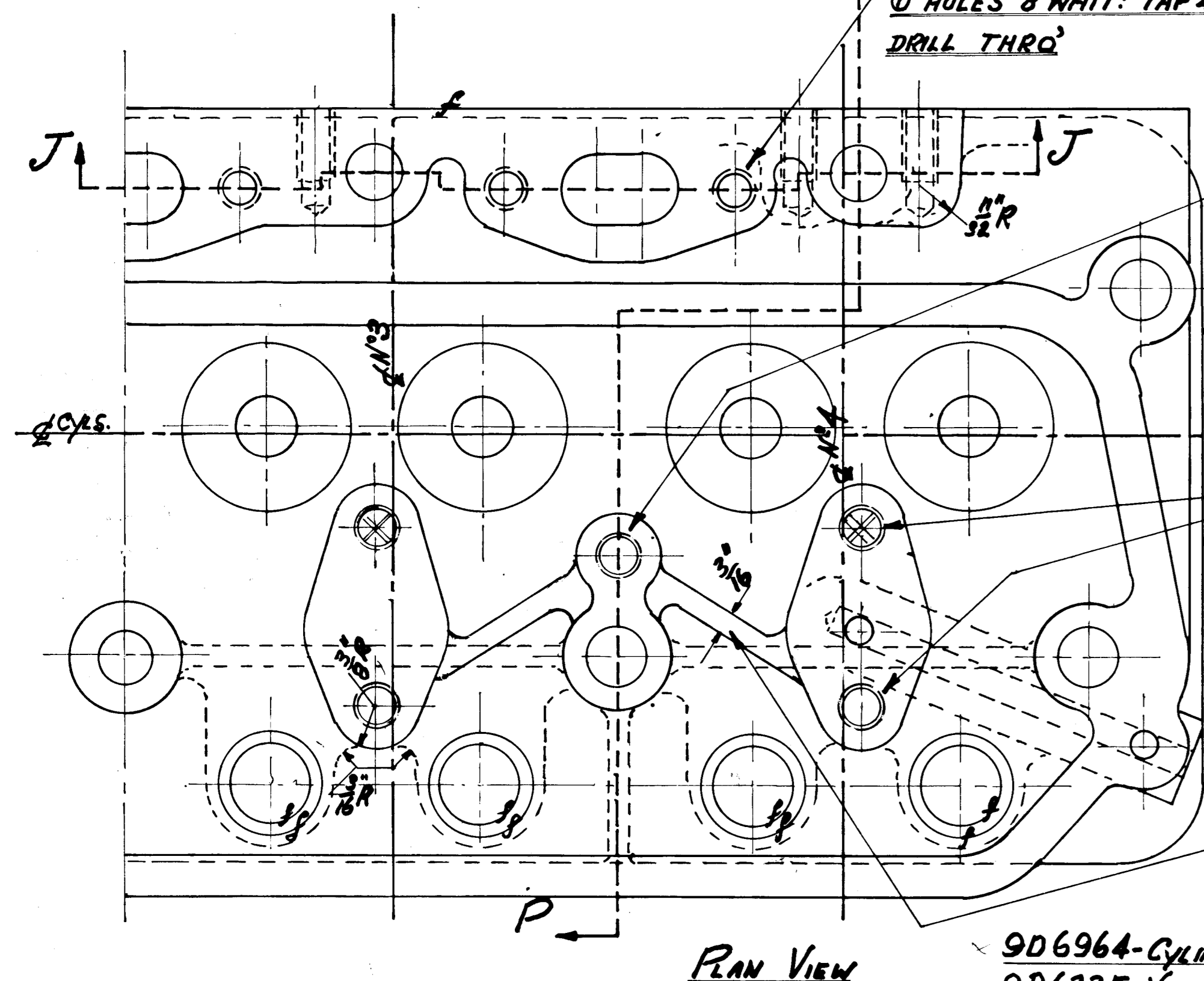


VIEW OF MANIFOLD FACING.

VOLUME OF COMBUSTION CHAMBER TO BE 84 TO 87 CC. WITH VALVES FITTED BUT SPARK PLUG HOLE NOT DRILLED.



2 HOLES CORED 3/8" DIA. MACHINED OUT TO DIM. GIVEN TO BE SECURELY PLUGGED TO MAKE WATER TIGHT JOINT. PLUG 9D7122 TO BE DRIVEN IN FLUSH.

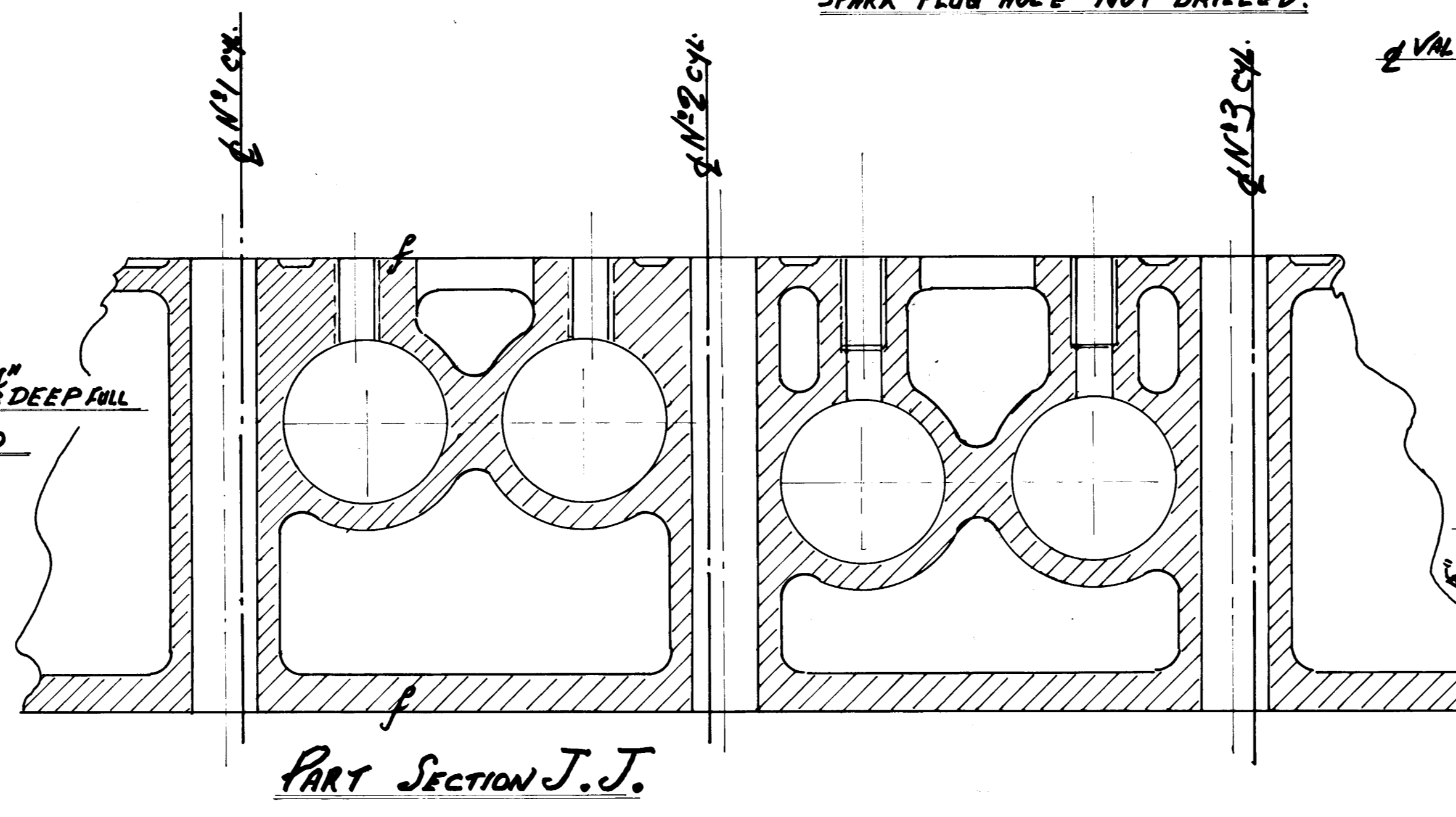


PLAN VIEW

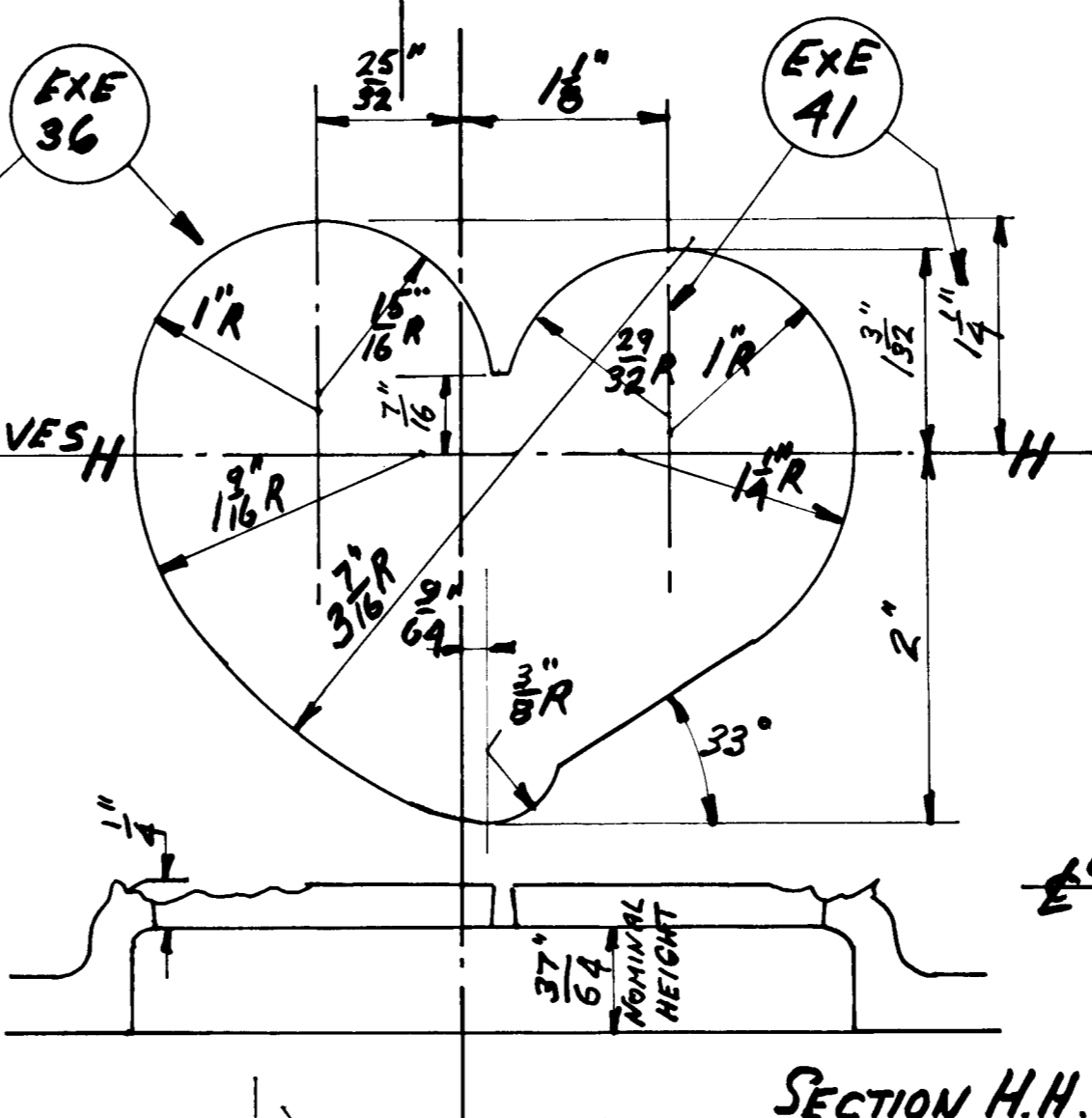
2 HOLES 3/8" WHIT. TAP 3/8" DEEP FULL THD. DRILL 1/8" DEEP.

8 HOLES 3/8" WHIT. 4 HOLES THUS 1/8" TAP 3/8" DEEP FULL THD. (FROM TOP FACE) DRILL 1/8" DEEP. OTHERS DRILL AND TAP THRO. ALL 8 HOLES TO BE COUNTERBORED. SEE SECTION M.M.

A RIBS THUS, 2 AT FRONT END AND 2 AT REAR END AS SHOWN.

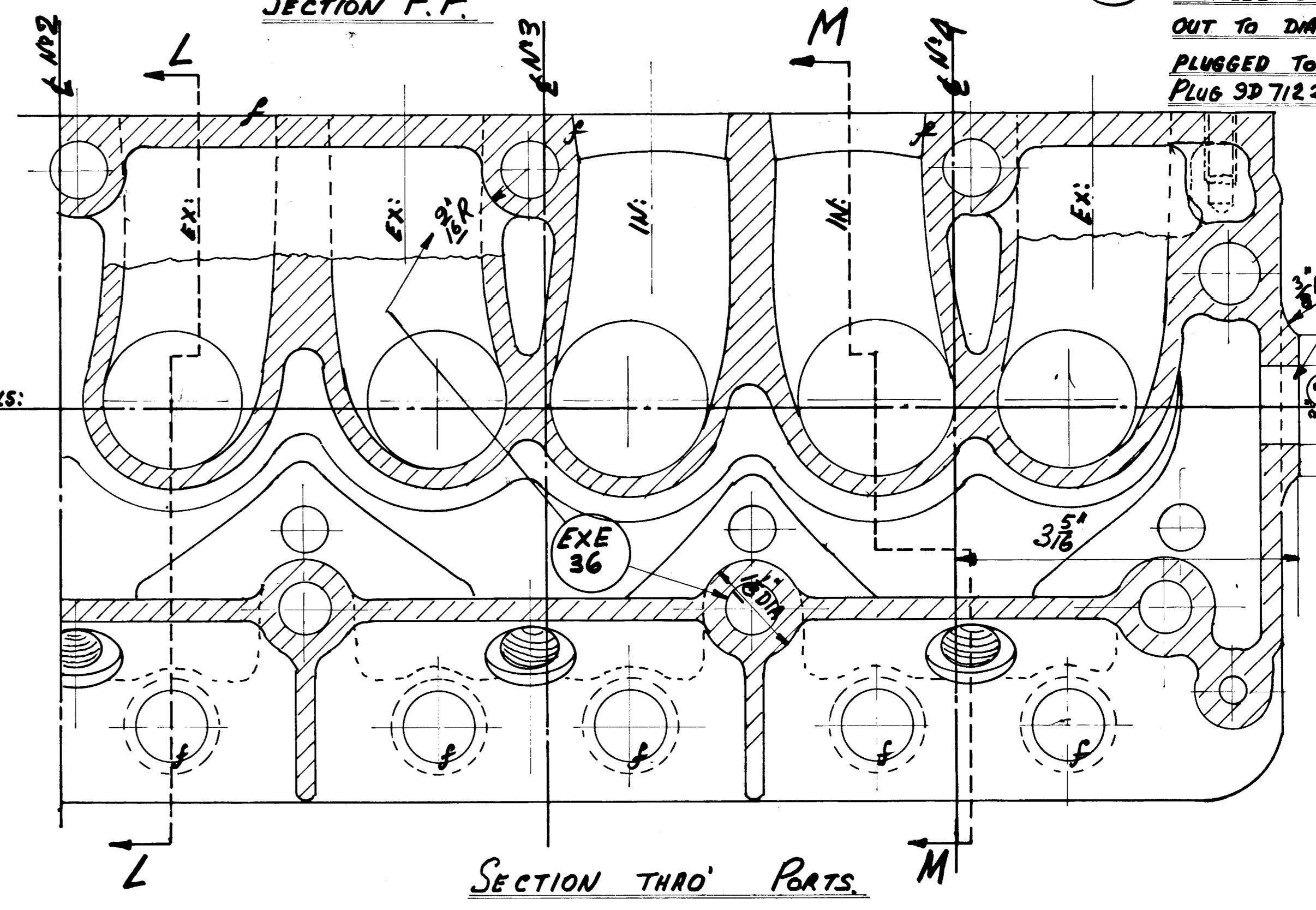


PART SECTION J.J.



SECTION H.H.

VARYING RADII LOCUS LINE.



SECTION THRO PARTS.

CYLINDER HEAD COMPLETE.	
PART N°	
9D6963	

- 9D6964-CYLINDER HEAD-B51490-LM4-M.
- 9D6335-VALVE GUIDE (INLET).
- 9D6336-VALVE GUIDE (EXHAUST).
- 9D7037-INLET VALVE INSERT.
- 9D6404-EXHAUST VALVE INSERT.
- 2K1345-PLUG FOR OIL HOLE.
- 9D6965-PUSH ROD HOUSING TUBE.
- 9D6966-SEAL FOR PUSH ROD HOUSING TUBE.
- 9D7122-TAPER PLUG FOR CORE HOLE.

FOR ALL OTHER PARTICULARS SEE DRWG N° 9D5568

GENERAL THICKNESS OF METAL 1/8" UNLESS OTHERWISE STATED.  
GENERAL INLET RADIUS 3/16"