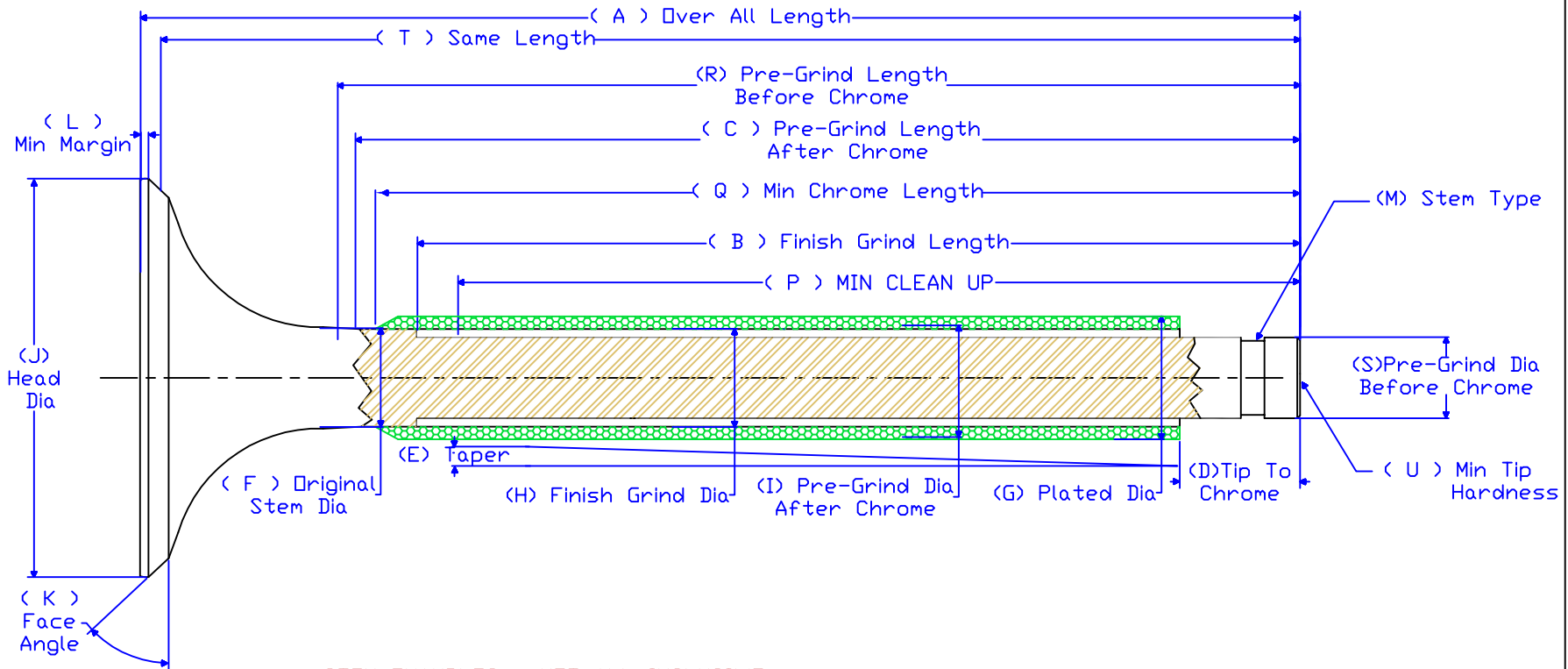


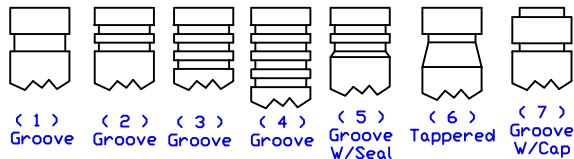
CAL GRINDING, INC. TYPICAL TOLERANCES FOR VALVE REMANUFACTURING

B + 0 / - 1/16 IN.
 C + 1/16 / - 0 IN.
 D +/- 1/32 IN.
 E 0.0007 IN. (WHEN REQUIRED)
 H +/- 0.00035 IN.
 I +/- 0.001 IN.
 K +/- 0° 15'
 R +/- 1/32 IN.
 S +/- 0.0005 IN.
 T +/- 0.005 IN.

STEM LOBING FINISH GROUND: 0.0002 IN. MAX
 STEM FINISH: 18 RA MAX
 FACE RUNOUT: 0.0015 IN.
 FACE FINISH: 32 RA MAX
 TIP HARDNESS: 48 HRC MIN.



STEM EXAMPLES - NOT ALL INCLUSIVE



	DRAWING/PART NO.	DESCRIPTION
BILL OF MATERIALS		
UNLESS OTHERWISE SPECIFIED: 1. ALL DIMS ARE IN INCHES. 2. ALL DIMENSIONS AND TOLERANCING IS IN ACCORDANCE WITH ANSI Y14.5M-1995. 3. BREAK ALL SHARP EDGES AND REMOVE ALL BURRS. 4. ALL MACHINED SURFACE FINISHES = $\sqrt{16}$ 5. DIMENSIONAL TOLERANCES ARE AS FOLLOWS: TWO PLACE DECIMALS = ± 0.010 THREE PLACE DECIMALS = ± 0.005 FOUR PLACE DECIMALS = ± 0.0025 ANGLES = $\pm 30'$		
DRAWN BY: NAK CHECKED BY: MC APD BY: MC DATE: 2/22/00 DATE: DATE:		THIS DRAWING AND ALL INFORMATION CONTAINED HEREIN IS THE PROPERTY OF CAL VALVES. REPRODUCTION OF THIS DRAWING IS STRICTLY PROHIBITED WITHOUT PERMISSION.
DESCRIPTION: Reference Floor Spec		
SCALE: None	DRAWING NO.:	REV: 4