

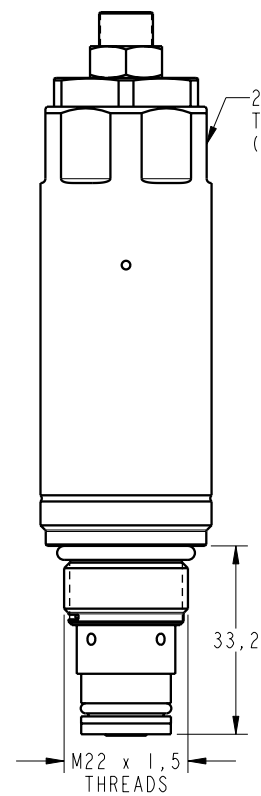
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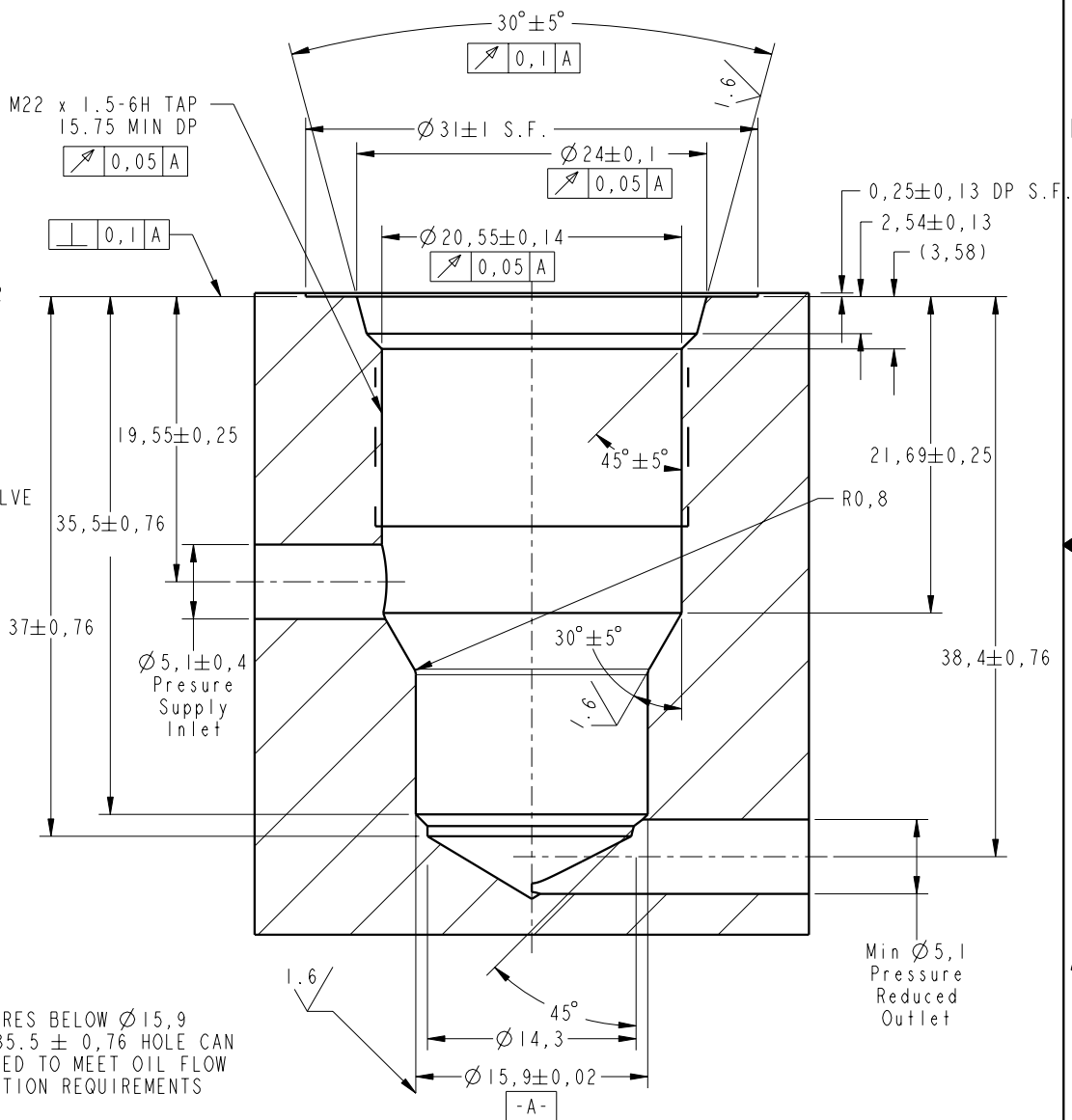
NOTE: THERE IS NO STANDARD PORTING TOOL AVAILABLE FOR THIS CAVITY

OPTIONAL TOOLING SEQUENCE

1. SPOT DRILL TO  $\varnothing 12 \pm 0,8$  DEEP
2. SPOT FACE  $\varnothing 31 \pm 1$  TO  $0,25 \pm 0,13$  DEEP  
(THE FOLLOWING DEPTHS ARE DIMENSIONED FROM THE  $\varnothing 31$  SPOTFACE SURFACE)
3. FORM  $\varnothing 20,55 \pm 0,14$  TO  $21,69 \pm 0,25$  DEEP AND  $30^\circ \pm 5^\circ$
4. DRILL  $\varnothing 14,3$  TO  $37 \pm 0,76$  DEEP
5. BORE OR REAM  $\varnothing 15,9 \pm 0,025$  TO  $35,5 \pm 0,76$  DEEP
6. FORM  $30^\circ \pm 5^\circ$  ANGLE AT  $\varnothing 24 \pm 0,1$  TO  $2,54 \pm 0,13$
7. FORM  $45^\circ \pm 5^\circ$  ANGLE FROM TO  $30^\circ$  UNTIL MINOR DIAMETER IS INTERSECTED  
(3,58 DEEP REFERENCE)
8. THREAD M22 x 1,5-6H TO 15,75 MINIMUM FULL THREAD DEPTH



47-0540-00 PRESSURE REDUCING VALVE CARTRIDGE



NOTE: ALL FEATURES BELOW  $\varnothing 15,9 \pm 0,02 \nabla 35,5 \pm 0,76$  HOLE CAN BE MODIFIED TO MEET OIL FLOW AND DIRECTION REQUIREMENTS

PRESSURE LIMITING AND PRESSURE REDUCING VALVE CARTRIDGE CAVITY DIMENSIONS FOR MACHINING WITHOUT PORT TOOL

INSTALLATION INSTRUCTIONS



VEKTEK, INC.  
1334 E. SIXTH AVE. P.O. BOX 625  
EMPORIA, KS. 66801 U.S.A.

ASSEMBLIES AFFECTED

VALVE, PLV/PRV, CAVITY, METRIC

C	2567	RELEASE	JDW	09/12/13
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	ROMINE	<b>DRAWING STATUS: Released</b>		
DATE:	03/23/07	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		

47-0440-00  
47-0540-00

SIZE A IS7004

REV C

FORM FEG041-IS.ASIZ, REV. A

SHEET 1 OF 1

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