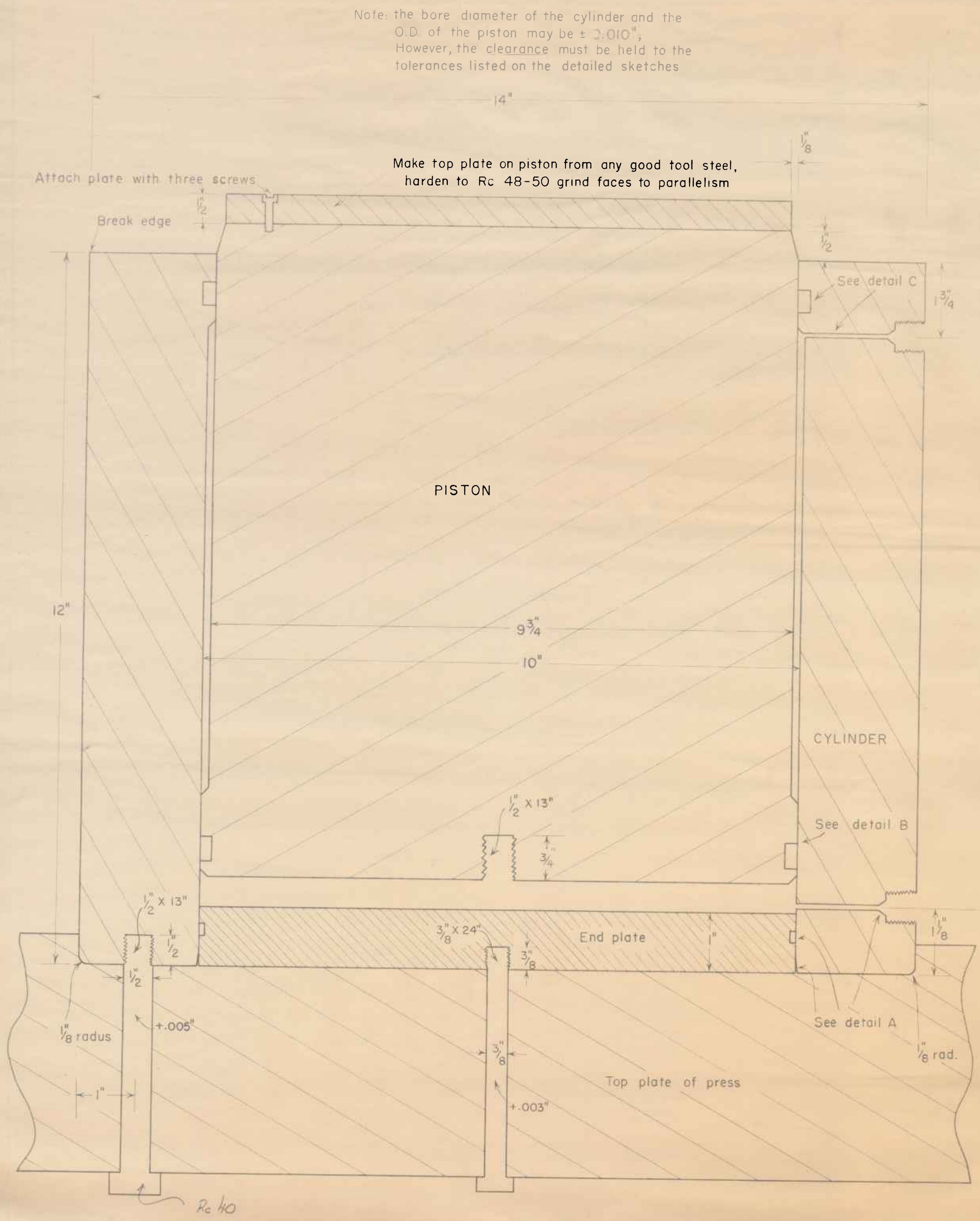
Note: the bore diameter of the cylinder and the O.D. of the piston may be ± .010", However, the clearance must be held to the tolerances listed on the detailed sketches
14"
1/8"
Make top plate on piston from any good tool steel, harden to Rc 48-50 grind faces to parallelism
Attach plate with three screws
1/2"
Break edge
See detail C
1 3/4"
PISTON
12"
9 3/4"
10"
CYLINDER
1/2" X 13"
See detail B
3/4"
1/2" X 13"
1/2"
3/8" X 24"
End plate
1"
1 1/8"
3/8"
1/2"
1/8" radus
+.005"
See detail A
1/8" rad.
3/8"
1"
Top plate of press
+.003"
Rc 40