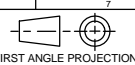


A1 MANUFACTURING DRAWING

DRAWN TO B.S. 8888
THREADS TO B.S.3643 PT2

DO NOT SCALE
IF IN DOUBT ASK



FOR ISIR REQUIREMENTS PLEASE REFER TO THE APRACING SUPPLIER MANUAL

IF THIS DOCUMENT IS PRINTED IN HARD COPY, IT IS FOR INFORMATION ONLY AND THEREFORE IS NOT SUBJECT TO UPDATING CONTROLS. ALWAYS REFER TO VIEWER FOR LATEST ISSUE.

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THIS DISC HAS BEEN SPECIFICALLY DESIGNED TO BE TWIN TURNED, AND MUST NOT BE MANUFACTURED BY ANY OTHER METHOD.

ISSUE HISTORY				ZONE	INITIALS
No.	DATE & PCO No.	PARTICULARS			
4	10/02/2004 B2154	RE-DRAWN ON SW. CASTING SOURCE CP2589-106C WAS CP2589-101C			GM
5	16/09/08 RAC21723	DISC CONVERTED TO TWIN TURNING NOTE ADDED 0.2/0.00 STEP OUT ADDED MIS0380 NOTE ADDED PART NUMBER MARKING ADDED GENERAL NOTE ADDED CASTING CP2589-105C WAS CP2589-106C TREATMENT TO MIS0075 WAS STD SHEET CP2719	1L	SAT	
			10K		
			13K		
			1H		
			B1		
			15B		
6	17/09/08 RAC21723	COUNTERSINK ANGLE 90° WAS 80°	10G	SAT	

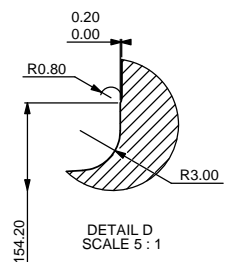
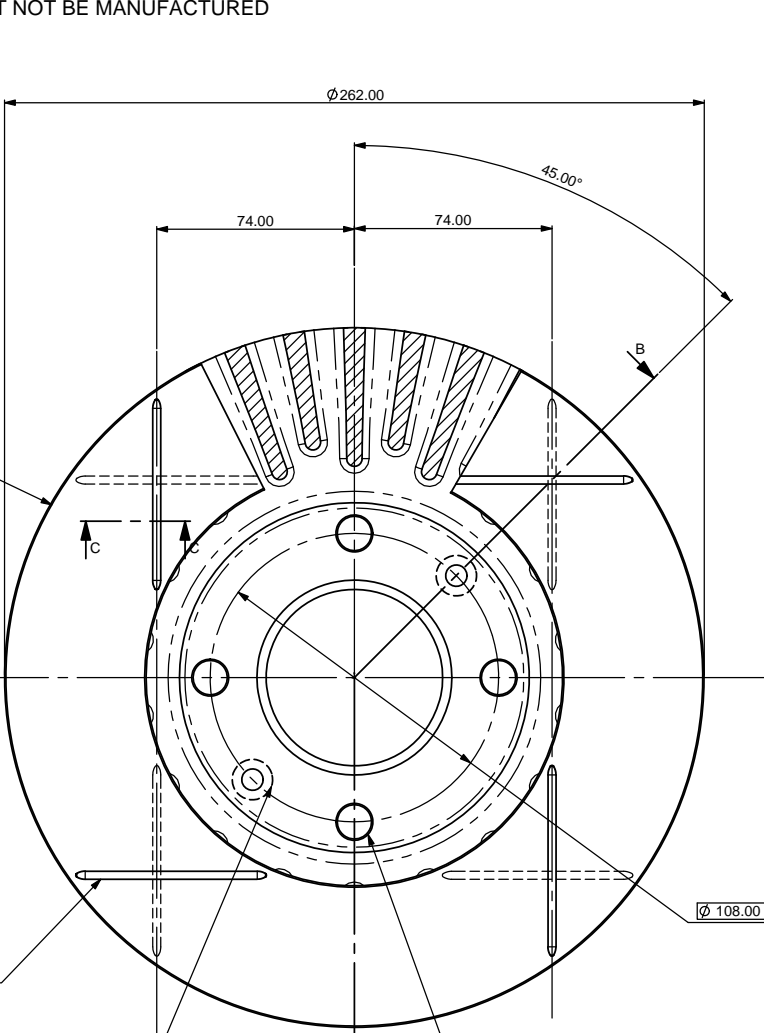
DISC PART NUMBER TO BE ETCHED ON OD AFTER M/C BALANCING ACCORDING TO MIS0086 IN LETTERS 2.5mm HIGH

V GROOVES PER FACE EQUISPACED AS SHOWN. GROOVES TO START AT R81.0 AND RUN-OUT AT R128.0 DO NOT END MILL.

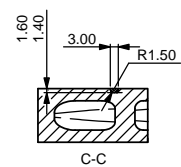
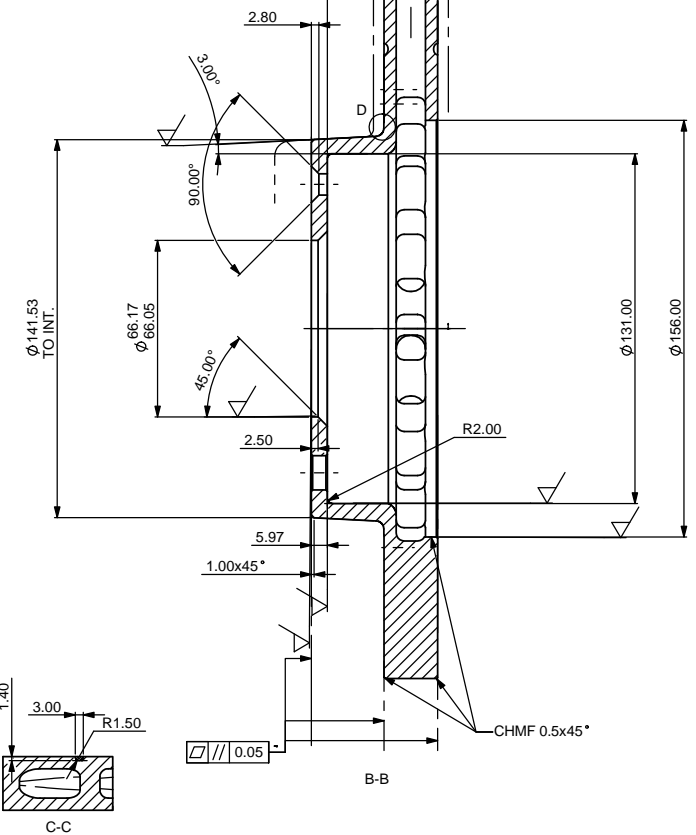
2 HOLES Ø8.00 EQUISPACED COUNTERSUNK AS SHOWN ON A GIVEN PCD.
Ø 0.1

4 HOLES Ø12.90/12.80 THRO EQUISPACED ON A GIVEN PCD. CHAM BOTH ENDS 0.5 x 45°
Ø 0.05

NOTE:-
UNLESS OTHERWISE STATED REMOVE ALL SHARP CORNERS
CASTING TO BE CLEAN, CLOSE GRAINED AND FREE FROM BLOW HOLES AND HARD SPOTS. SURFACE OF DISC TO BE FREE FROM POROSITY, FLANGE M/C'ING TO BE SMOOTH WITH NO RIDGES OR GROOVES.
DIP IN DE-WATERING OIL AFTER FINAL OP.
DISC TO BE BALANCED AS SPECIFIED ON MIS0559



FOR FLATNESS, PARALLELISM & SURFACE FINISH LIMITS REFER TO MIS0380



SUFFIX	DETAILS
P	PLAIN, NO GROOVES
G (VALUE 'V')	GROOVES ONLY, VALUE 'V' PER FACE e.g. G8 GROOVES 8 PER FACE

UNLESS OTHERWISE STATED: DIMENSIONS IN MILLIMETRES. REMOVE ALL BURRS. DIMENSIONS ARE BEFORE TREATMENT.

SURFACE AREA (mm²)	214790.06
MASS (grams)	4060.16
VOLUME (mm³)	580023.57

DIMENSIONAL TOLERANCE = ± 0.25
ANGULAR TOLERANCE = ± 0°30'

MAX SURFACE FINISH:
BY ANY METHOD ON MACHINED SURFACES = √ 3.2 µm (Ra)

SCALE: 1:1

CAST IRON
MATERIAL SPECIFICATION(S):
APRM0001
ALT MATERIAL SPECIFICATION(S) or ADDITIONAL MATERIAL NOTES:

SURFACE TREATMENT / HEAT TREATMENT:
REFER TO MIS0075

MADE FROM:
CP2589-105C

DRAWN BY: Steve Thomas APPROVED:

IDENTIFIED FROM: SHEETS: 1 OF 1

DRAWING TITLE:
Ø262 x 20.05 TOP HAT VENT DISC

PART NUMBER/DRAWING NUMBER:
CP2589-115

DRAWING FILE NAME: cp2589-115 DRAWING ISSUE: 6