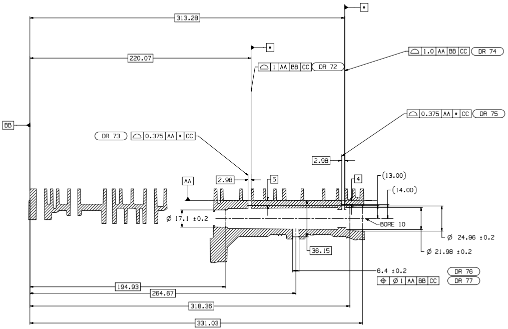
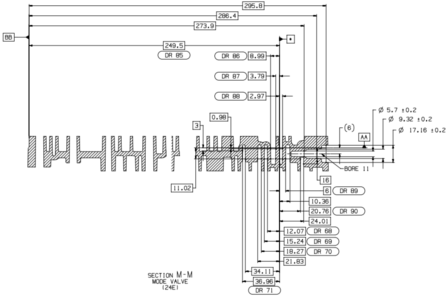
24062508

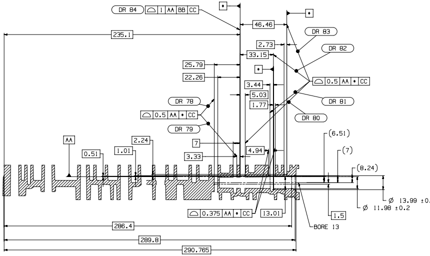
GENERAL MOTORS


313.28
220.07
1 AA BB CC DR 72
1.0 AA BB CC DR 74
0.375 AA • CC DR 75
DR 73 0.375 AA • CC
BB
2.98
2.98
5
4
AA
(13.00)
(14.00)
Ø 17.1 ±0.2
BORE 10
Ø 24.96 ±0.2
Ø 21.98 ±0.2
36.15
6.4 ±0.2
Ø 1 AA BB CC
DR 76
DR 77
194.93
264.67
318.36
331.03

SECTION P-P
PARK SERVO VALVE
(24F)

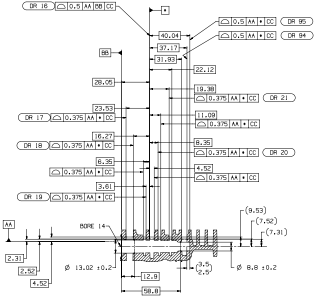

295.8
286.4
273.9
BB
249.5
DR 85
DR 86 8.99
DR 87 3.79
DR 88 2.97
0.98
3
(6)
AA
Ø 5.7 ±0.2
Ø 9.32 ±0.2
Ø 17.16 ±0.2
BORE 11
16
11.02
6 DR 89
10.36
20.76 DR 90
24.01
12.07 DR 68
15.24 DR 69
18.27 DR 70
21.83
34.11
36.96
DR 71

SECTION M-M
MODE VALVE
(24E)

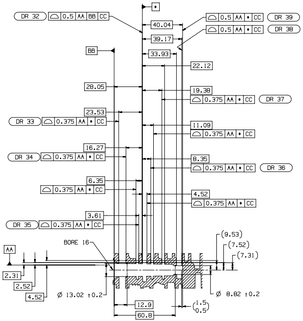

DR 84 1 AA BB CC
46.46
DR 83
235.1
2.73
DR 82
33.15
25.79
22.26
3.44
0.5 AA • CC
5.03
1.77
DR 81
DR 78
0.5 AA • CC
DR 80
DR 79
(6.51)
AA
2.24
7
(7)
0.51
1.01
3.33
4.94
(8.24)
Ø 13.99 ±0.
Ø 11.98 ±0.2
0.375 AA • CC
13.01
1.5
BORE 13
286.4
289.8
290.765

SECTION AB-AB
(ANTI BACKFLOW VALVE)
(24E)

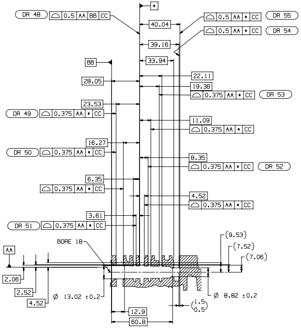
FRAME NUMBER	SHEET NUMBER	DRAWING NUMBER	DWG STATUS ST	REV	PDI
6 OF 6	1 OF 1	24062508	R	001	


DR 16
0.5 AA BB CC
40.04
37.17
31.93
0.5 AA • CC DR 95
0.5 AA • CC DR 94
BB
22.12
28.05
19.38
0.375 AA • CC DR 21
23.53
DR 17 0.375 AA • CC
11.09
0.375 AA • CC
16.27
DR 18 0.375 AA • CC
8.35
0.375 AA • CC DR 20
6.35
0.375 AA • CC
4.52
0.375 AA • CC
3.61
DR 19 0.375 AA • CC
AA
BORE 14
(9.53)
(7.52)
(7.31)
2.31
2.52
4.52
Ø 13.02 ±0.2
12.9
58.8
3.5
2.5
Ø 8.8 ±0.2

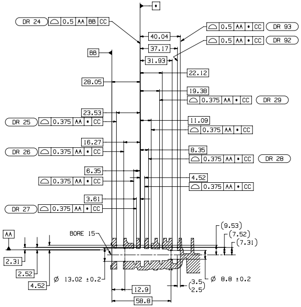
SECTION C-C
C CLUTCH REG VALVE
(28F)


DR 32
0.5 AA BB CC
40.04
39.17
33.93
0.5 AA • CC DR 39
0.5 AA • CC DR 38
BB
22.12
28.05
19.38
0.375 AA • CC DR 37
23.53
DR 33 0.375 AA • CC
11.09
0.375 AA • CC
16.27
DR 34 0.375 AA • CC
8.35
0.375 AA • CC DR 36
6.35
0.375 AA • CC
4.52
0.375 AA • CC
3.61
DR 35 0.375 AA • CC
AA
BORE 16
(9.53)
(7.52)
(7.31)
2.31
2.52
4.52
Ø 13.02 ±0.2
Ø 8.82 ±0.2
12.9
60.8
1.5
0.5

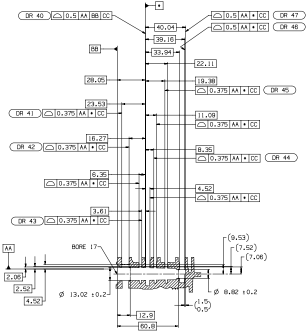
SECTION E-E
E CLUTCH REG VALVE
(28E)


DR 48
0.5 AA BB CC
40.04
39.16
33.94
0.5 AA • CC DR 55
0.5 AA • CC DR 54
BB
22.11
28.05
19.38
0.375 AA • CC DR 53
23.53
DR 49 0.375 AA • CC
11.09
0.375 AA • CC
16.27
DR 50 0.375 AA • CC
8.35
0.375 AA • CC DR 52
6.35
0.375 AA • CC
4.52
0.375 AA • CC
3.61
DR 51 0.375 AA • CC
BORE 18
AA
(9.53)
(7.52)
(7.06)
2.06
2.52
4.52
Ø 13.02 ±0.2
Ø 8.82 ±0.2
12.9
60.8
1.5
0.5

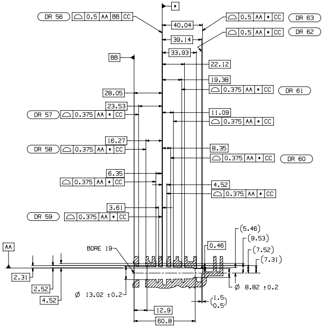
SECTION A-A
A CLUTCH REG VALVE
(28D)


DR 24
0.5 AA BB CC
40.04
37.17
31.93
0.5 AA • CC DR 93
0.5 AA • CC DR 92
BB
22.12
28.05
19.38
0.375 AA • CC DR 29
23.53
DR 25 0.375 AA • CC
11.09
0.375 AA • CC
16.27
DR 26 0.375 AA • CC
8.35
0.375 AA • CC DR 28
6.35
0.375 AA • CC
4.52
0.375 AA • CC
3.61
DR 27 0.375 AA • CC
AA
BORE 15
(9.53)
(7.52)
(7.31)
2.31
2.52
4.52
Ø 13.02 ±0.2
12.9
58.8
3.5
2.5
Ø 8.8 ±0.2

SECTION F-F
F CLUTCH REG VALVE
(28F)


DR 40
0.5 AA BB CC
40.04
39.16
33.94
0.5 AA • CC DR 47
0.5 AA • CC DR 46
BB
22.11
28.05
19.38
0.375 AA • CC DR 45
23.53
DR 41 0.375 AA • CC
11.09
0.375 AA • CC
16.27
DR 42 0.375 AA • CC
8.35
0.375 AA • CC DR 44
6.35
0.375 AA • CC
4.52
0.375 AA • CC
3.61
DR 43 0.375 AA • CC
AA
BORE 17
(9.53)
(7.52)
(7.06)
2.06
2.52
4.52
Ø 13.02 ±0.2
Ø 8.82 ±0.2
1.5
0.5
12.9
60.8

SECTION B-B
B CLUTCH REG VALVE
(28E)


DR 56
0.5 AA BB CC
40.04
39.14
33.93
0.5 AA • CC DR 63
0.5 AA • CC DR 62
BB
22.12
19.38
28.05
0.375 AA • CC DR 61
23.53
DR 57 0.375 AA • CC
11.09
0.375 AA • CC
16.27
DR 58 0.375 AA • CC
8.35
0.375 AA • CC DR 60
6.35
0.375 AA • CC
4.52
0.375 AA • CC
3.61
DR 59 0.375 AA • CC
(5.46)
(9.53)
(7.52)
(7.31)
0.46
AA
BORE 19
2.31
2.52
4.52
Ø 13.02 ±0.2
Ø 8.82 ±0.2
1.5
0.5
12.9
60.8

SECTION D-D
D CLUTCH REG VALVE
(28D)

FRAME NUMBER	SHEET NUMBER	DRAWING NUMBER	DWG STATUS ST	REV	PDI
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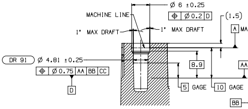
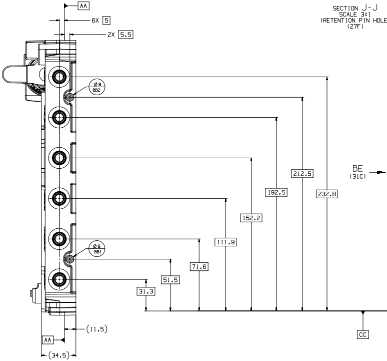
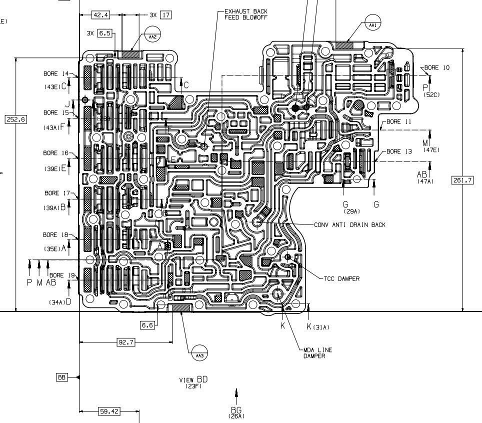

MACHINE LINE
Ø 6 ±0.25
⊕ Ø0.2 D
(1.5)
1° MAX DRAFT
1° MAX DRAFT
A MACHINED
DR 91 Ø 4.81 ±0.25
⊕ Ø0.75 AA BB CC
D
8.9
AA
5 GAGE
10 GAGE

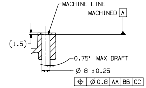
SECTION J-J
SCALE 3:1
(RETENTION PIN HOLE)
(27F)


AA
6X 5
2X 5.5
Ø8 BB2
Ø8 BB1
232.8
212.5
192.5
152.2
111.9
71.6
51.5
31.3
252.6
BE
(31C)
CC
(11.5)
AA
(34.5)

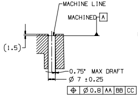
VIEW BE
(28E)


PARK BLOWOFF
BALL SHUTTLE HOLE (PARK)
255.4
BB
42.4
3X 17
3X 6.5
AA2
AA1
EXHAUST BACK FEED BLOWOFF
BORE 14
(43E) C
C
J
BORE 15
(43A) F
BORE 16
(39E) E
BORE 17
(39A) B
BORE 18
(35E) A
BORE 19
P M AB
(34A) D
BORE 10
P
(52C)
BORE 11
M
(47E)
BORE 13
AB
(47A)
261.7
G
(29A)
G
CONV ANTI DRAIN BACK
TCC DAMPER
6.6
K
K (31A)
MDA LINE DAMPER
92.7
AA3
BB
59.42
BG
(26A)

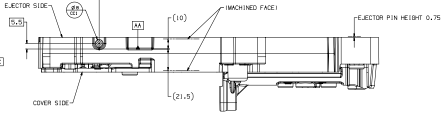
VIEW BD
(23F)


MACHINE LINE
MACHINED A
(1.5)
0.75° MAX DRAFT
Ø 8 ±0.25
⊕ Ø0.8 AA BB CC

SECTION K-K
FOR CAST BOLT HOLES: 1C - 21C, 23C - 38C
(25D)


MACHINE LINE
MACHINED A
(1.5)
0.75° MAX DRAFT
Ø 7 ±0.25
⊕ Ø0.8 AA BB CC

SECTION G-G
FOR CAST BOLT HOLES: 22C
(25E)


EJECTOR SIDE
Ø8 CC1
AA
(10)
(MACHINED FACE)
EJECTOR PIN HEIGHT 0.75
5.5
(21.5)
COVER SIDE

VIEW BG
(26C)

NUMBER	SHEET NUMBER	DRAWING NUMBER	DWG STATUS ST	REV	PDI
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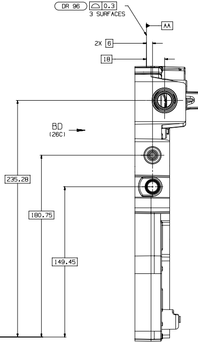
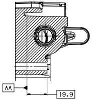
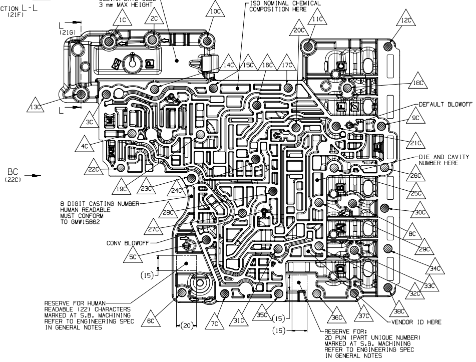

DR 96
0.3
3 SURFACES
AA
2X 6
18
BD
(26C)
235.28
180.75
149.45

VIEW BC
(21E)



SECTION L-L
(21F)


JULIAN DATE CODE
3 mm MAX HEIGHT
ISO NOMINAL CHEMICAL
COMPOSITION HERE
L
(21G)
L
1C
2C
10C
11C
12C
20C
14C
15C
16C
17C
18C
13C
3C
4C
22C
19C
23C
24C
9C
21C
26C
25C
30C
8C
29C
34C
33C
32C
38C
DEFAULT BLOWOFF
DIE AND CAVITY
NUMBER HERE
BC
(22C)
8 DIGIT CASTING NUMBER
HUMAN READABLE
MUST CONFORM
TO GMW15862
28C
27C
CONV BLOWOFF
5C
(15)
RESERVE FOR HUMAN
READABLE (22) CHARACTERS
MARKED AT S.B. MACHINING
REFER TO ENGINEERING SPEC
IN GENERAL NOTES
6C
(20)
7C
31C
35C
(15)
(15)
36C
37C
VENDOR ID HERE
RESERVE FOR:
2D PUN (PART UNIQUE NUMBER)
MARKED AT S.B. MACHINING
REFER TO ENGINEERING SPEC
IN GENERAL NOTES

COVER SIDE

MAX

UNLESS OTHERWISE SPECIFIED:

SCALE: FULL

WHERE DIMENSIONS ARE SPECIFIED ON THE DRAWING,
THE DRAWING IS THE AUTHORITY FOR DIMENSIONAL VALUES

WHERE DIMENSIONS ARE NOT SPECIFIED ON THE DRAWING,
THE DIGITAL MODEL IS THE AUTHORITY FOR DIMENSIONAL VALUES

DIMENSIONS OBTAINED FROM THE DIGITAL MODEL ARE BASIC:

1. FOR RELATIONSHIPS BETWEEN FEATURES WHEN ESTABLISHED BY GEOMETRIC TOLERANCES.
2. FOR THE FORM OF A FEATURE WHEN CONTROLLED BY A PROFILE TOLERANCE.
3. FOR THE SIZE, FORM, AND/OR RELATIONSHIP BETWEEN FIXED DATUM TARGETS.

DIMENSIONS OBTAINED FROM THE DIGITAL MODEL ARE ROUNDED TO TWO DECIMAL PLACES. (PER IEEE/ASTM SI 10-2016)

THE DIGITAL MODEL MUST CORRESPOND WITH THE RELEASE LEVEL SHOWN IN THE PART BLOCK ON THIS DOCUMENT

MINIMUM WALL IS THE MODELED THICKNESS MINUS 0.5

A WALL IS DEFINED AS THE PARALLEL DISTANCE BETWEEN ANY TWO DIE SEGMENTS

ALL DIMENSIONS ARE RELATED TO: |AA| PRIMARY
|BB| SECONDARY
|CC| TERTIARY

ALL FEATURES ARE MEASURED FROM THEIR RELATIVE DATUMS

|AA| IS ESTABLISHED BY (AA1) , (AA2) , (AA3) AND BASIC DIMENSIONS

|BB| IS ESTABLISHED BY (Ø8 BB1) , (Ø8 BB2) AND BASIC DIMENSIONS

|CC| IS ESTABLISHED BY (Ø8 CC1) AND BASIC DIMENSIONS

ALL DRAFT ANGLES |1°|

ALL CORNER RADII TANGENT TO EJECTOR AND COVER SURFACES R0.8 MAX

ALL SOLENOID/VALVE CORE PIN DIAMETERS ALONG LENGTH OF PIN TO BE
|⌖|Ø 0.75|AA|BB|CC|
|⌖|Ø 0.25|
CORE PIN DRAFT ANGLE 1° MAX

EXCLUDING DATUM TARGET LOCATIONS, FOR SURFACES LOCATED WITH BASIC DIMENSIONS SHOWN FROM |AA|, |BB| OR |CC|:

	< 50	⌓ 0.5 AA BB CC
50	- 100	⌓ 0.76 AA BB CC
	> 100	⌓ 1 AA BB CC

FOR SURFACES LOCATED WITH BASIC DIMENSIONS SHOWN FROM |•|:

	< 50	⌓ 0.5 AA • CC
50	- 100	⌓ 0.76 AA • CC
	> 100	⌓ 1 AA • CC

ALL CAST FEATURES NOT DIMENSIONED ARE BASIC IN THE CAD MODEL AND ARE TOLERANCED BY |⌓|1|AA|BB|CC|

ALL FEATURES ON COVER SIDE AS A COMPLETE UNIT TO INCLUDE |⌓|0.5|BB|CC| DIE SHIFT TOLERANCE

ALL FEATURES ON COVER SIDE PARALLEL TO DATUM |AA| TO INCLUDE |⌓|0.5Ⓤ0.5|AA| DIE BLOW TOLERANCE

PARTING LINES ARE ALLOWED TO VARY BETWEEN CASTING SUPPLIERS FROM EJECTOR FACE TO COVER FACE WITH APPROVAL FROM GM ENGINEERING

DIE SEGMENT/INSERT SEAMLINES ALLOWED.
NO LOOSE OR ROLLED FLASH, TRIMMED WITHIN 0.4mm MAX;
LOCATIONS MUST BE APPROVED BY GM ENGINEERING

PARTING LINE FLASH TO BE TRIMMED WITHIN 0.4 MAX

GATES AND OVERFLOWS TO BE TRIMMED WITHIN 0.8 MAX

▩	INDICATES FLASH TO BE REMOVED BY VENDOR. GEOMETRY AROUND TRIM WINDOW OPTIONAL. ENGINEERING APPROVAL REQUIRED. FILLETS ADJACENT TO TRIM WINDOWS R1.5 MAX.
▨	INDICATES FLASH TO BE REMOVED BY MACHINING OPERATION. FLASH MAY OR MAY NOT BE PRESENT. AMOUNT OF FLASH TO BE AGREED UPON BETWEEN SUPPLIER AND GM MANUFACTURING.
▨	INDICATES MACHINING LOCATING SURFACE. MUST BE CAST FLAT AND SMOOTH. CLAMP AND CAST DATUM TARGET SURFACES MUST BE A MAXIMUM OF 15√ AND |⏥|0.2| (DR 97) WITH ZERO DRAFT. FLASH TO BE REMOVED BY VENDOR.

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FRAME NUMBER	SHEET NUMBER	DRAWING NUMBER
2 OF 6	1 OF 1	2406

GM KCDS SHALL BE ADMINISTERED IN ACCORDANCE WITH THE
LATEST VERSIONS OF GMW15049 AND KCDS TEMPLATES.

KPC	PQC	AQC	DR		
0	0	0	97	LAST NUMBER USED	KPC (KEY PRODUCT CHARACTERISTIC) PQC (PRODUCT QUALITY CHARACTERISTIC) AQC (ATTRIBUTE QUALITY CHARACTERISTIC) DR (DOCUMENTATION REQUIRED)
0	0	0	74	TOTAL BY COLUMN	

KPC ◆ KPC NO.	PQC ◆ PQC NO.	AQC ◆ AQC NO.	DR ◆ DR NO.	CHARACTERISTIC	RATIONALE	ZONE	SH	PLCS
			16	PROFILE FOR 28.05	FUNCTION	44H	1	1
			17	PROFILE FOR 23.53	FUNCTION	44G	1	1
			18	PROFILE FOR 16.27	FUNCTION	44F	1	1
			19	PROFILE FOR 3.61	FUNCTION	44F	1	1
			20	PROFILE FOR 8.35	FUNCTION	42F	1	1
			21	PROFILE FOR 19.38	FUNCTION	42G	1	1
			24	PROFILE FOR 28.05	FUNCTION	44D	1	1
			25	PROFILE FOR 23.53	FUNCTION	44C	1	1
			26	PROFILE FOR 16.27	FUNCTION	44C	1	1
			27	PROFILE FOR 3.61	FUNCTION	44B	1	1
			28	PROFILE FOR 8.35	FUNCTION	42C	1	1
			29	PROFILE FOR 19.38	FUNCTION	42C	1	1
			32	PROFILE FOR 28.05	FUNCTION	40H	1	1
			33	PROFILE FOR 23.53	FUNCTION	40G	1	1
			34	PROFILE FOR 16.27	FUNCTION	40F	1	1
			35	PROFILE FOR 3.61	FUNCTION	40F	1	1
			36	PROFILE FOR 8.35	FUNCTION	38F	1	1
			37	PROFILE FOR 19.38	FUNCTION	38G	1	1
			38	PROFILE FOR 39.17	FUNCTION	38H	1	1
			39	PROFILE FOR 40.04	FUNCTION	38H	1	1
			40	PROFILE FOR 28.05	FUNCTION	40D	1	1
			41	PROFILE FOR 23.53	FUNCTION	40C	1	1
			42	PROFILE FOR 16.27	FUNCTION	40C	1	1
			43	PROFILE FOR 3.61	FUNCTION	40B	1	1
			44	PROFILE FOR 8.35	FUNCTION	38C	1	1
			45	PROFILE FOR 19.38	FUNCTION	38D	1	1
			46	PROFILE FOR 39.16	FUNCTION	37D	1	1
			47	PROFILE FOR 40.04	FUNCTION	37D	1	1
			48	PROFILE FOR 28.05	FUNCTION	36H	1	1
			49	PROFILE FOR 23.53	FUNCTION	36G	1	1
			50	PROFILE FOR 16.27	FUNCTION	36G	1	1
			51	PROFILE FOR 3.61	FUNCTION	36F	1	1
			52	PROFILE FOR 8.35	FUNCTION	34F	1	1
			53	PROFILE FOR 19.38	FUNCTION	34G	1	1
			54	PROFILE FOR 39.16	FUNCTION	33H	1	1
			55	PROFILE FOR 40.04	FUNCTION	33H	1	1
			56	PROFILE FOR 28.05	FUNCTION	36D	1	1
			57	PROFILE FOR 23.53	FUNCTION	36C	1	1
			58	PROFILE FOR 16.27	FUNCTION	36C	1	1
			59	PROFILE FOR 3.61	FUNCTION	36B	1	1
			60	PROFILE FOR 8.35	FUNCTION	33C	1	1
			61	PROFILE FOR 19.38	FUNCTION	33D	1	1
			62	PROFILE FOR 39.17	FUNCTION	33D	1	1
			63	PROFILE FOR 40.04	FUNCTION	33D	1	1
			68	DIMENSION OF 12.07	FUNCTION	46E	1	1
			69	DIMENSION OF 15.24	FUNCTION	46E	1	1
			70	DIMENSION OF 18.27	FUNCTION	46E	1	1
			71	DIMENSION OF 36.96	FUNCTION	46E	1	1
			72	DIMENSION OF 220.07	FUNCTION	51F	1	1
			73	DIMENSION OF 2.98	FUNCTION	53E	1	1
			74	DIMENSION OF 313.28	FUNCTION	49F	1	1
			75	DIMENSION OF 2.98	FUNCTION	49F	1	1
			76	DIMENSION OF 6.4	FUNCTION	50D	1	1
			77	TRUE POSITION FOR 6.4	FUNCTION	50D	1	1
			78	PROFILE FOR 25.79	FUNCTION	47C	1	1
			79	PROFILE FOR 3.33	FUNCTION	47C	1	1
			80	PROFILE FOR 5.03	FUNCTION	46C	1	1
			81	PROFILE FOR 3.44	FUNCTION	46C	1	1
			82	PROFILE FOR 33.15	FUNCTION	46C	1	1
			83	PROFILE FOR 46.46	FUNCTION	46D	1	1
			84	PROFILE FOR 235.1	FUNCTION	48D	1	1
			85	DIMENSION OF 249.5	FUNCTION	47G	1	1
			86	DIMENSION OF 8.99	FUNCTION	47G	1	1
			87	DIMENSION OF 3.79	FUNCTION	47G	1	1
			88	DIMENSION OF 2.97	FUNCTION	47F	1	1
			89	DIMENSION OF 6	FUNCTION	46E	1	1
			90	DIMENSION OF 20.76	FUNCTION	46E	1	1
			91	DIAMETER OF 4.81	FUNCTION	29G	1	1
			92	PROFILE FOR 37.17	FUNCTION	42D	1	1
			93	PROFILE FOR 40.04	FUNCTION	42D	1	1
			94	PROFILE FOR 37.17	FUNCTION	42G	1	1
			95	PROFILE FOR 40.04	FUNCTION	42H	1	1
			96	PROFILE FOR DATUM AA	FUNCTION	23G	1	1
			97	FLATNESS FOR CAST DATUMS	FUNCTION	13A	1	1

ZONE	DWG STATUS DATE	ST	REV	POS	PDI	REVISION HISTORY	AUTH	DR	APVD 1	APVD 2	APVD 3	APVD 4	APVD 5
	08AP24	R	001			RELEASED TO PRODUCTION AT DLS A DESIGN HISTORY REFERENCE: 24050237	BZ8BK	RK	DTV	PON	JF RT	JG BR	JVH

MATERIAL:
ASTM-B85 GRADE A383 / GLOBALLY EQUIVALENT
JIS-H5302-GRADE-ADC12Z

SHOT BLAST REQUIRED 100% OF SURFACE AREA OR THAT WHICH IS MUTUALLY AGREEABLE

MAX SHOT SIZE S550 (2.38)

PARTS MUST BE FREE FROM BURRS AND SHARP EDGES, WHICH MIGHT BE DETRIMENTAL TO SATISFACTORY ASSEMBLY, SAFE HANDLING OR FUNCTION OF PART

FOR SPECIFICATION AND INTERPRETATION OF KCDS BLOCK AND DRAWING SYMBOLS, SEE GM GLOBAL KCDS STANDARD GMW15049 AND GENERAL MOTORS PROCEDURE ETQ-114.

PARTS AS DELIVERED TO MACHINING/ASSEMBLY SHALL BE CLEAN AND FREE OF DEBRIS, RESIDUAL ABRASIVE MATERIAL, AND CORROSION PRODUCTS ADVERSELY AFFECTING FUNCTION OR APPEARANCE. CLEANLINESS IS VERIFIED BY VISUAL EVALUATION.

REFER TO 24050250 FOR POROSITY ACCEPTANCE STANDARDS AND 2D PUN MATRIX

HIERARCHY /QUANTITY	DWG ITM	ZONE	DWG RLTN SHIP	PART NUMBER	DLS	REV LVL	PDI	CALC MASS (kg)	PART NAME	COMMENT
	01		RD	24062508	A	001		3.3051	BODY-C/VLV SOL (CSTG)	

PARTS SHOWN ON DRAWING

ADDITIONAL GM APPROVERS		DATE:
APVD7	JEREMY V HORGAN	22FE24
APVD8	BLAKE RHYNARD	13MR24

VIEWS AND SECTIONS ON THIS DRAWING ARE IN ACCORDANCE WITH GM S1100-2

RESTRICTED AND REPORTABLE SUBSTANCES FOR PARTS PER GMW3059

THIS DOCUMENT IS IN ACCORDANCE WITH ASME Y14.5-2018 AS AMENDED BY THE GM GLOBAL DIMENSIONING AND TOLERANCING ADDENDUM-2020 (GMW16812)

CHANGE RESTRICTED
NO MANUAL CHANGES

FOR FURTHER DRAFTING STANDARDS SEE GM S1100

METRIC

DIMENSIONS SHOWN IN MILLIMETERS UNLESS OTHERWISE SPECIFIED

REFERENCE
AB1V ETRS
HL106148, HL107420
HL107299, HL107422
HL107297, HL107424
HL107418, HL107423
HL107421, HL107419

		DATE
DRAFTER	RAVIKRISHNA L G	29DE23
APVD1	DEEPAK T V	22FE24
APVD2	PONSEENI R KUMAR	14MR24
APVD3	JASON FISHER	23FE24
APVD4	ROBERT THOMAS	23FE24
APVD5	JOEL GUNDERSON	22FE24

DRAWING NAME
BODY-C/VLV SOL (CSTG)

FRAME NUMBER	SIZE	DRAWING NUMBER	DWG STATUS ST	REV	PDI	SHEET NUMBER
1 OF 6	R	24062508	R	001		1 OF 1