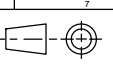


# A1 MANUFACTURING DRAWING

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

DO NOT SCALE

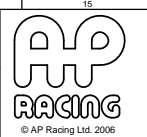
IF IN DOUBT ASK



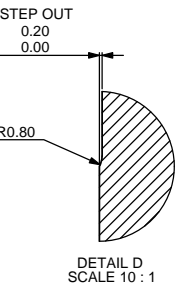
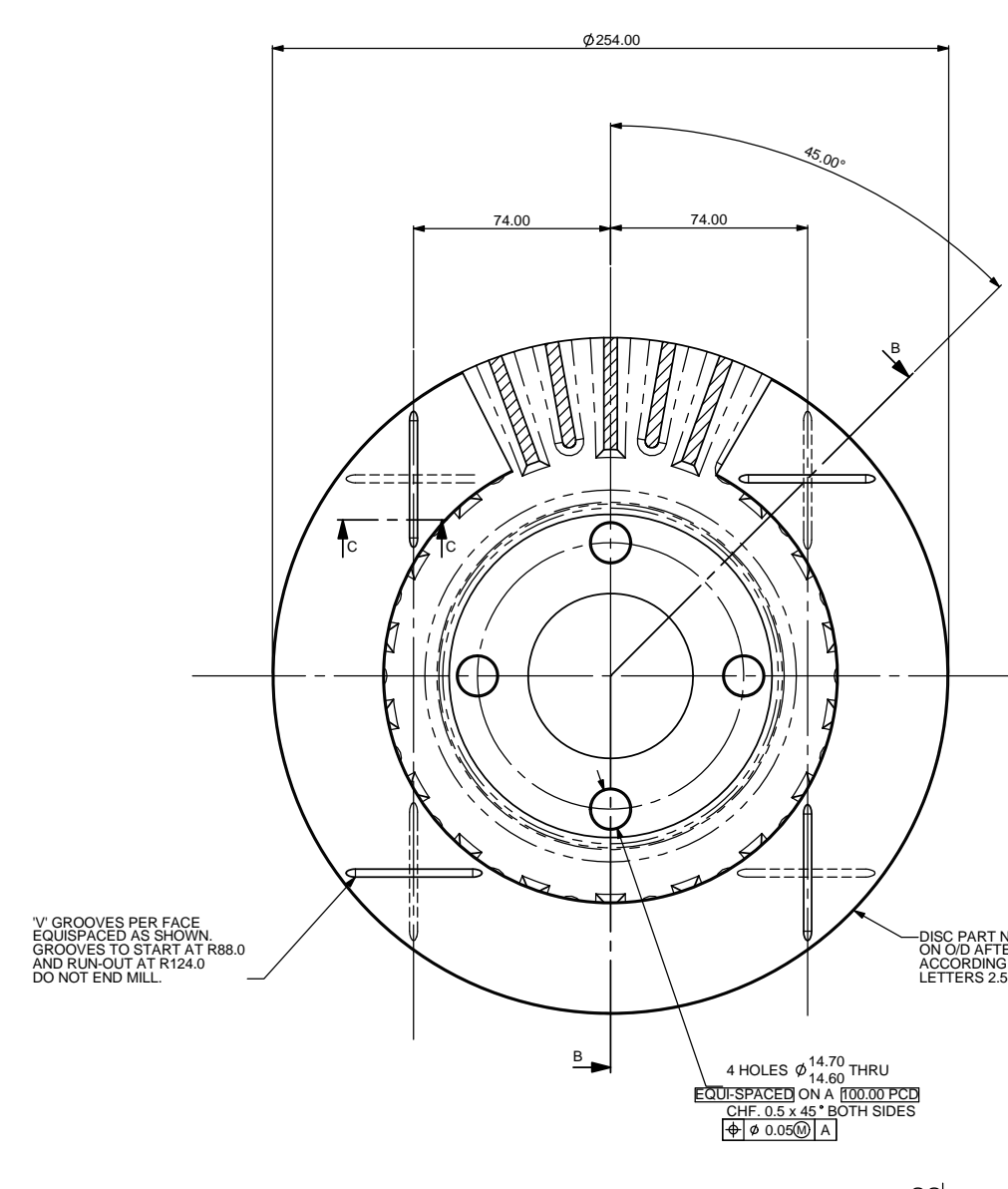
FIRST ANGLE PROJECTION

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

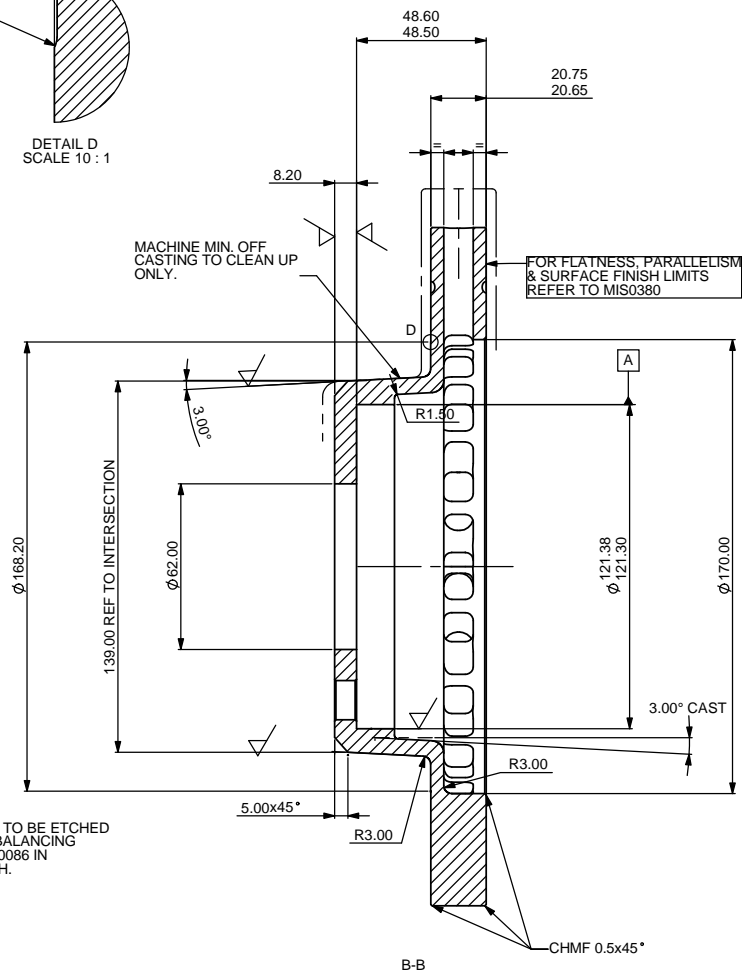
THIS DRAWING IS CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT SHALL NOT BE LOANED OR COPIED OR DISCLOSED TO ANY OTHER PERSON OR USED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN CONSENT OF AP RACING LTD.



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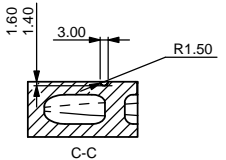
THIS DISC HAS BEEN SPECIFICALLY DESIGNED TO BE TWIN TURNED, AND MUST NOT BE MANUFACTURED BY ANY OTHER METHOD.



'V' GROOVES PER FACE EQUISPACED AS SHOWN. GROOVES TO START AT R88.0 AND RUN-OUT AT R124.0 DO NOT END MILL.

DISC PART NUMBER TO BE ETCHED ON O/D AFTER MIC BALANCING ACCORDING TO MIS0086 IN LETTERS 2.5mm HIGH.

4 HOLES  $\phi$  14.70 THRU  
EQUI-SPACED ON A 100.00 PCD  
CHF. 0.5 x 45° BOTH SIDES  
 $\phi$  0.05 (M) A



NOTE:- TO BE MADE FROM CP2789-105C.

UNLESS OTHERWISE STATED REMOVE ALL SHARP CORNERS 0.3 X 45°.

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

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

ISSUE HISTORY				
No.	DATE & PCO No.	PARTICULARS	ZONE	INITIALS
4	10/02/2004 B2154	RE-DRAWN ON SW. CASTING COURSE CP2589-105C WAS CP2589-101C	# GM	
5	12/11/07 B4460:ID82	DISC CONVERTED TO TWIN TURNING. NOTE ADDED. MIS0380 NOTE ADDED. 0.20/0.00 STEP & R0.80 ADDED. 0.168.20 ADDED. PART MARKING NOTE ADDED. GENERAL NOTES ADDED. CASTING WAS -106C	L11 J13 L8 G9 D8	DRA
6	04/12/2007 RAC21624	DIM 141.50 TO INTERSECTION REMOVED	# GM	
7	06/12/07 RAC21624	139.00 REF TO INT'N ADDED. 6.00 REMOVED: INT'N TO CAST FACE. 254.00 WAS 254.00/253.85	F8 G11 L5	GM
8	11/12/07 RAC21629	DATUM A ADDED. MAX MAT'L CONDITION ADDED TO HOLE POSN TOLERANCE	H13 C6	DRA

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

MASS (grams) **4149.82**  
VOLUME (mm<sup>3</sup>) **592831.64**

DIMENSIONAL TOLERANCE =  $\pm 0.25$   
ANGULAR TOLERANCE =  $\pm 0.30^\circ$

MAX SURFACE FINISH BY ANY METHOD ON MACHINED SURFACES =  $\sqrt{3.2}$   $\mu$ m (Ra)

MATERIAL SPECIFICATION(S) **CAST IRON**  
APRM0001

ALL MATERIAL SPECIFICATION(S) OR ADDITIONAL MATERIAL NOTES

SURFACE TREATMENT / HEAT TREATMENT  
REFER TO MIS0075

MADE FROM **CP2589-105C**  
DRAWN BY **Gael Mace** APPROVED

IDENTIFIED FROM SHEETS **1 OF 1**

DRAWING TITLE  **$\phi$ 254 x 20.7 TOP HAT VENTILATED DISC**  
PART NUMBER/DRAWING NUMBER **CP2589-120**  
DRAWING FILE NAME **cp2589-120** DRAWING ISSUE **8**