

A1 MANUFACTURING DRAWING
PART NUMBER(S) / DRAWING NUMBER
CP2589-138

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

DO NOT SCALE
IF IN DOUBT ASK



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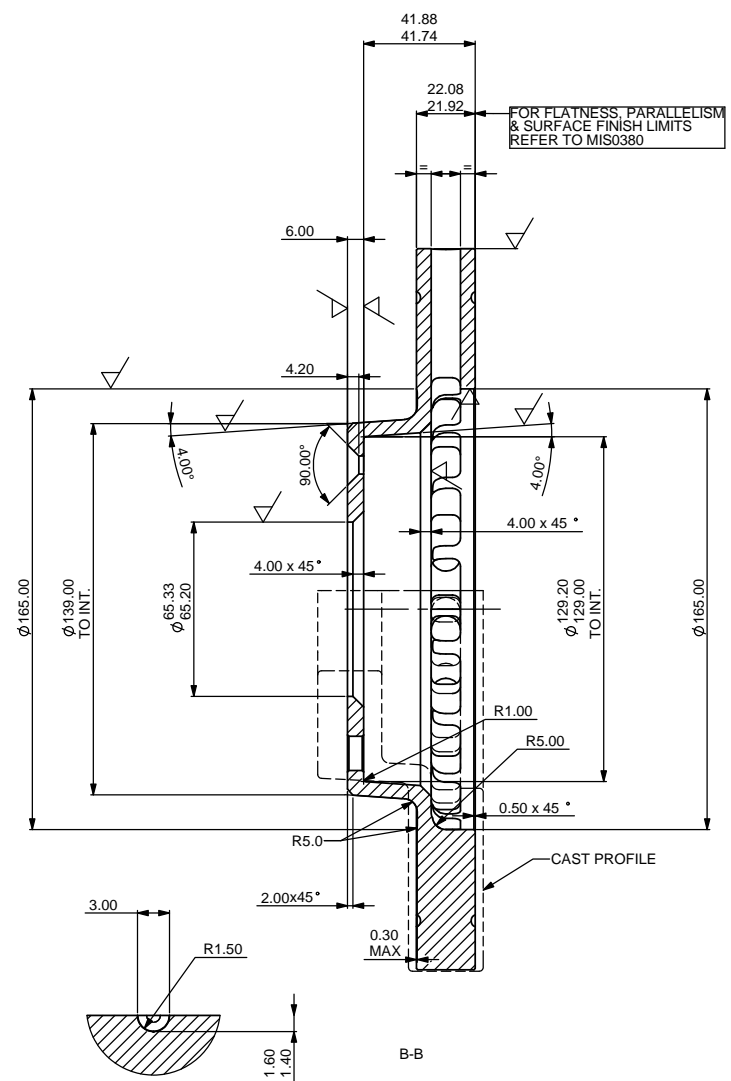
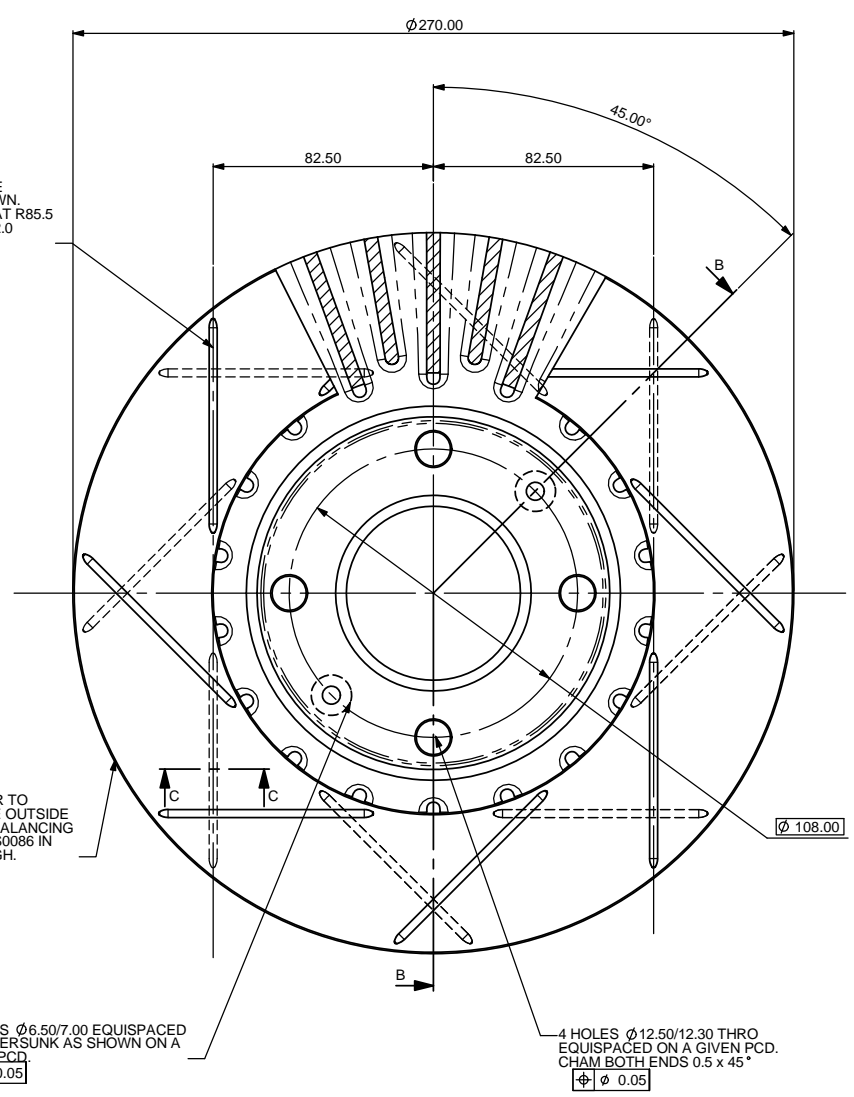
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THIS DISC HAS BEEN SPECIFICALLY DESIGNED TO BE TWIN TURNED, AND MUST NOT BE MANUFACTURED BY ANY OTHER METHOD.

ISSUE HISTORY				ZONE	INITIALS
No.	DATE & PCO No.	PARTICULARS			
1	02/10/1998 B2157	FIRST ISSUE	#	???	
2	14/10/1998 RAC07548	85.5 WAS 79.0, 132.00 WAS 130.5.	#	CDA	
3	17/05/1999 B2399	SUFFIX TABLE ADDED TO DRAWING, TO ALLOW G4/G8.	#	CDA	
4	19/09/2002 B3453	PACKAGING CHANGED IN BOM NO DRAWING CHANGES.	#	NM	
5	06/02/2004 B2154	CASTING SOURCE CP2589-106C WAS CP2589-105C.	#	GM	
6	23/05/2006 RAC21384	REDRAWN ON SOLIDWORKS. CASTING CHANGED BACK TO CP2589-105C. TREATMENT MIS0075 ADDED, Ø165.00 ADDED, 0.30 MAX ADDED.	#	CDA	
7	27/09/06 RAC21443	PICTORIALLY UPDATED TO SHOW G8 GROOVE LAYOUT		SAT	
8	24/05/07 B4460:ID54	TWIN TURNING NOTE ADDED REFERENCE TO MIS0380 ADDED. PART No. MARKING NOTE ADDED.		DRA	



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

MASS (grams) **4662.22**
VOLUME (mm³) **666031.52**
SCALE **1:1**

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

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

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

SURFACE TREATMENT / HEAT TREATMENT
REFER TO MIS0075

MADE FROM
DRAWN **CDA** APPROVED
IDENTIFIED FROM SHEETS **1 OF 1**

DRAWING TITLE
TOP HAT VENTILATED DISC
Ø270.0 x 22.0
PART NUMBER(S) / DRAWING NUMBER
CP2589-138
DRAWING FILE NAME
cp2589-138 DRAWING ISSUE
8

SUFFIX TO DISC PART NUMBERS:-

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

NOTE:
TO BE MADE FROM CP2589-105C.
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/CING
TO BE SMOOTH WITH NO RIDGES OR GROOVES.
DIP IN DE-WATERING OIL AFTER FINAL OP.