

T-31A CAVITY DETAILS

(ALL DIMENSIONS ARE IN MILLIMETERS)
ΔM20X1.5-6H ISO (METRIC) THREAD
19,026/19,216 PITCH DIA.

0,79 DRILL/REAMER
RELATIONSHIP

FORM DRILL
994-031-***

FORM REAMER
995-031-***

*NOTE: PLEASE SEE BELOW
REGARDING "TWO" DIFFERENT
CLEARANCE DRILLS NEEDED
WHEN SINKING CAVITY DEEPER
THAN STANDARD DEPTH.

0,80 REC.MIN.
FROM MILLED
SURFACE 1,60
REC. MIN. FROM
UNMILLED
SURFACE.

17,45
MINIMUM HEX
EXTENSION

LOCATING
SHOULDER

PORT
#4

PORT
#3

PORT
#2

CARTRIDGE NOSE
SUPPORT

102,4 MIN. DEPTH OF
11,91 Ø SECONDARY DRILL
FOR WORKING PARTS
CLEARANCE.

PORT
#1

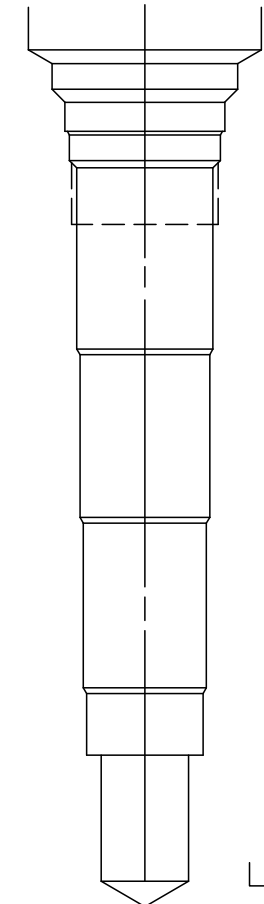
THREAD AND
ALL DIAMETERS

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* FIRST CLEARANCE DRILL: WHEN SINKING CAVITY MORE THAN 5,56 DEEP
A 25,40 Ø DRILL MUST BE ADDED FOR CARTRIDGE HEX CLEARANCE.
SECOND CLEARANCE DRILL: WHEN SINKING CAVITY MORE THAN 11,13 DEEP
A 31,75 Ø DRILL ALONG WITH THE 25,40 Ø DRILL MUST BE ADDED FOR
SOCKET WRENCH CLEARANCE.

MINIMUM CENTERLINE-TO-EDGE DISTANCE: 14,28
MINIMUM CENTERLINE-TO-CENTERLINE DISTANCE: 26,98
NBOM CALLOUT: SUN STD T-31A CAVITY
NBOM CODE: T31A

**ALL O-RING "LEAD IN's" TO BE SMOOTH AND FREE OF NICKS & SHARP EDGES



FULL SCALE

LET	REVISION	DATE	DRN	CHK	REL	UNLESS OTHERWISE SPECIFIED DIM. TOLERANCE UNLESS SPECIFIED FINISH 20 V REMOVE ALL BURRS	TITLE T-31A CAVITY DIMENSIONS, TOOLING, PORTING	REVISION	PART NO. T-31A METRIC
1	REVISED TOOLING P/N. REVISED DIMS FOR CAVITY / TOOLING CONSISTENCY.	06MAY11	JRS	RCL	10164	DIM. TOLERANCE UNLESS SPECIFIED FINISH 20 V REMOVE ALL BURRS	T-31A CAVITY DIMENSIONS, TOOLING, PORTING	J	SHEET 2 of 3
2	ADDED PAGE 3 OF 3	30DEC02				SCALE REF. SERIES 1			
3	75,95 DIM WAS 79,95-METRIC DWG ONLY	07OCT99	DAS			DRAWN			
4	TOLERANCE CORRECTIONS ON METRIC DWG	05AUG99	DAS			CHECK			
5	REVISED AND REDRAWN TO BE CONSISTENT W/ CAVITIES W/ SIMILAR DIMENSIONS. ADDED TIR	21JAN98	RJB		8372	RG			
6	METRIC VERSION CONCERNED WITH WAS .001 TIR					DATE			
7						DATE			
8						DATE			
9						DATE			
10						DATE			



REVISION	PART NO. T-31A METRIC
J	SHEET 2 of 3