

Engineering Report

M A24-2500T/1

Masters with obsolete parts included

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M A24-2500T/1 - A24-2500T - SHORT BLOCK ASSY, A600	1.00			No Pri
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--60 EA-LEVEL-01 - ENGINE ASSEMBLY LEVEL 1	Type:	0.0 % Scra	
End Qty:	1.00	Start Qty:	1.00
Resource ID: EA-LEVEL-01	Setup:	0.0 Hrs	Fixed Scrap: 0.00
	Run:	20.0000 MIN/P	Min Move:
Service ID:	Transit:	0.0 Days	Capacity Min:
HONE LIFTER BORES.			

1. REMOVE LOWER COVER AND BOLTS.

2. SPLIT CASE.

3. AT HONE STATION. USE 120-GRIT FLEX-HONE AND GO-NOGO GAUGE FROM JOB BOX #_____. HONE USING RED DRILLSET AT 500 RPM. HONE UNTIL 0.7468 GUAGE FITS IN TO BORE THEN MATCH-FIT EACH LIFTER TO BORES. LIFTER BORES SHOULD BE HONED TO AN OIL CLEARANCE OF .001". KEEP LIFTERS IN ORDER.

4. CLEAN CASE HALVES AND LIFTERS. CHECK FOR SMOOTH LIFTER TRAVEL.

5. FINAL HONE IN SOLVENT TANK 5-10 STROKES TO CLEAR.

6. POLISH LIFTERS.

----A24-2006 BEARING PIN	4.00	
Qty Per:	4.0000	Unit of Measure EA
Fixed Qty:	0.00	Qty Per Basis: Starting Qty

----A24-2000 CRANKCASE ASSY	1.00	
Qty Per:	1.0000	Unit of Measure EA
Fixed Qty:	0.00	Qty Per Basis: Starting Qty

----A24-1013 MAIN BEARING SET, CRANK SHAFT SILVER	1.00	
Qty Per:	1.0000	Unit of Measure EA
Fixed Qty:	0.00	Qty Per Basis: Starting Qty

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ULTRASONICLY CLEAN CRANKSHAFT AND FLANGE WITH TIMING WHEEL (ASSEMBLED) USING HEAT AND AIR AGITATION FOR FIVE MINUTES. RINSE THOROUGHLY AND DRY WITH COMPRESSED AIR.

PLACE CRANKSHAFT IN TO VICE HOLDING FIXTURE AND REINSTALL FLANGE WITH TIMING WHEEL ON TO CRANKSHAFT.

INSPECT ALL OIL PASSAGES USING LONG-TIP LIGHT PEN.

REMOVE CRANKSHAFT FROM VICE HOLDING FIXTURE AND PLACE IN WOOD HOLDING FIXTURE ON ASSEMBLY BENCH.

INSTALL ALUMINUM PLUGS INTO OIL PASSAGE DRILLING POINTS WITH TIPS (REMAINS FROM MACHINE WORK) FACING OUT.

USE 3/16-INCH PUNCH TO CENTER OF PLUG TO PRESS-FIT IN TO PLACE. USE CHISEL TO STAMP 3-4 CORNERS OF CRANKSHAFT MATERIAL TO LOCK PLUGS IN TO CRANKSHAFT.

REMOVE ANY LOOSE MATERIALS FROM PUNCH AND CHISEL OPERATIONS.

RETURN CRANKSHAFT IN UPRIGHT POSITION TO VISE HOLDING FIXTURE.

HEAT THRUST FLANGE ON HOT PLATE OR OVEN. DETAILS...

REMOVE UPPER THRUST BEARING FROM CRANK CASE. ACETONE CLEAN UPPER BEARING JOURNAL ON CRANKSHAFT AND THRUST BEARING. INSTALL THRUST BEARING TO CRANKSHAFT USING ASSEMBLY LUBE.

ACETONE CLEAN THRUST FLANGE AREA OF CRANKSHAFT.

USE .005" SPECIAL SHIMS FROM JOB BOX #_____ TO SHIM END-PLAY BETWEEN LOWER SIDE OF THRUST BEARING AND CRANKSHAFT.

PREPARE FLANGE TIGHTING TOOL #_____ FROM JOB BOX #_____.

DROP HOT THRUST FLANGE ON TO CRANKSHAFT. ALLOW A FEW MINUTES TO COOL THEN REMOVE SPECIAL SHIMS.

TURN CRANKSHAFT TO RIGHTSIDE DOWN POSITION IN VISE HOLDING FIXTURE.

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MATCH-FIT CRANK GEAR AND KEY TO CRANKSHAFT USING CALIPERS. CORRECT KEY IF NECESSARY. REFERENCE PRINT.

HEAT CRANK TIMING GEAR ON HOT PLATE OR OVEN. DETAILS...

REMOVE LOWER THRUST BEARING FROM CRANK CASE. ACETONE CLEAN LOWER BEARING JOURNAL ON CRANKSHAFT AND THRUST BEARING. INSTALL THRUST BEARING TO CRANKSHAFT USING ASSEMBLY LUBE.

ACETONE CLEAN CRANK GEAR AREA OF CRANKSHAFT.

DROP HOT CRANK GEAR ON TO CRANKSHAFT. ALLOW A FEW MINUTES TO COOL THEN INSTALL SNAP RING.

----A24-1002 CRANKSHAFT ASSY, W/FLANGE & TIMING 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

----A24-1015 PLUG, CRANKSHAFT, ALUMINUM 4.00
Qty Per: 4.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

----A24-1009 THRUST FLANGE, CRANK SHAFT 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

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----A24-1007 KEY, CRANKSHAFT TIMING GEAR 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

----A24-1540 TIMING GEAR SET 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

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----A24-1011 CRANK GEAR SNAP RING 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

--120 EA-LEVEL-01 - ENGINE ASSEMBLY LEVEL 1 **Type:** 0.0 % Scra
End Qty: 1.00 **Start Qty:** 1.00
Resource ID: EA-LEVEL-01 **Setup:** 0.0 Hrs **Fixed Scrap:** 0.00
Run: 20.0000 MIN/P **Min Move:**
Service ID: **Transit:** 0.0 Days **Capacity Min:**
DEBURR CAMSHAFT LOBES. USE SCOTCH-BRITE WHEEL TO POLISH
EDGES OF LOBES, INSIDE EDGES OF OIL-PUMP SHAFT KEYWAY
SLOT AND OUTSIDE RADIUS OF CAM GEAR FLANGE.

POLISH LIFTERS ON LATHE.

----A24-1501 CAMSHAFT, FINISHED 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

--130 EA-LEVEL-01 - ENGINE ASSEMBLY LEVEL 1 **Type:** 0.0 % Scra
End Qty: 1.00 **Start Qty:** 1.00
Resource ID: EA-LEVEL-01 **Setup:** 0.0 Hrs **Fixed Scrap:** 0.00
Run: 45.0000 MIN/P **Min Move:**
Service ID: **Transit:** 0.0 Days **Capacity Min:**
SET CAM TIMING USING FIXTURE#_____. PLACE CAM IN TO
FIXTURE. ROTATE CAM TO SET DIAL INDICATORS TO ZERO ON
HEELS OF LOBES. CHECK LIFT OF EACH LOBE. LIFT SPECIFICTIONS
ARE _____. ROTATE THE CAM AND SPLIT THE LIFT ON CYLINDER
#3 LOBES. SPLIT USUALLY LANDS BETWEEN .063 - .067 ON
INDICATORS. LOCK CAM IN TO POSITION IN FIXTURE. RECHECK
READINGS AND MAKE ADJUSTMENTS IF NECESSARY.

PLACE CRANKSHAFT IN TO FIXTURE. USING SPECIAL TEMPLATE (AS
PART OF TIMING FIXTURE) FIND TOP-DEAD-CENTER OF #3 THROW.
LOCK CRANKSHAFT IN TO POSITION. INSTALL FLANGE AND TIMING
WHEEL (ASSEMBLED) TO CRANKSHAFT AND SECURE WITH
CRANKSHAFT NUT.

INSTALL 360-DEGREE WHEEL, FLANGE AND FLANGE BOLT FROM JOB
BOX #_____. POSITION WHEEL AT ZERO DEGREES AND TIGHTEN
FLANGE BOLT. LOOSEN CRANKSHAFT LOCK ON TIMING FIXTURE.
POSITION CRANKSHAFT 4-DEGREES RETARDED AND LOCK
CRANKSHAFT IN TO POSITION.

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MOUNT CAM GEAR TO CAMSHAFT. FIND POSITION THAT PUTS BOLT HOLES IN GEAR AND CAMSHAFT FLANGE IN ALIGNMENT. LOOSELY INSTALL BOLTS AND WASHERS. ROTATE CAM GEAR COUNTER-CLOCKWISE (DIRECTION OF THRUST) AND TIGHTEN BOLTS. LOOSEN LOCKS IN FIXTURE AND RECHECK TIMING.

MARK LOCATION ON CAM GEAR IN REFERENCE TO CRANK GEAR USING PUNCH TOOL.

REMOVE CRANKSHAFT AND CAMSHAFT. REMOVE BOLTS ONE AT A TIME AND REINSTALL WITH RED LOCTITE. TURQUE BOLTS TO 18 FT-LBS. SCRIBE CRANKSHAFT SERIAL NUMBER TO CAM GEAR FLANGE USING AIR SCRIBER.

REMOVE 360-DEGREE WHEEL, WHEEL FLANGE AND BOLT FROM CRANKSHAFT. REMOVE DRIVE FLANGE AND TIMING WHEEL (ASSEMBLED) FROM CRANKSHAFT. REMOVE CRANKSHAFT FROM TIMING FIXTURE.

----	E00-2526 BOLT 5/16-24 X 1/2 SOCKET HEAD	3.00							
	Qty Per:	3.0000	Unit of Measure	EA					
	Fixed Qty:	0.00	Qty Per Basis:	Starting Qty					
----	E00-4501 WASHER 5/16 REGULAR AN960-516	3.00							
	Qty Per:	3.0000	Unit of Measure	EA					
	Fixed Qty:	0.00	Qty Per Basis:	Starting Qty					
--140	EA-LEVEL-01 - ENGINE ASSEMBLY LEVEL 1	Type:	0.0 %	Scra					
	End Qty:	1.00	Start Qty:	1.00					
	Resource ID:	EA-LEVEL-01	Setup:	0.0 Hrs	Fixed Scrap:	0.00			
			Run:	45.0000 MIN/P	Min Move:				
	Service ID:		Transit:	0.0 Days	Capacity Min:				
	HANG RODS. DETAILS...	***							
	CRANKSHAFT JOURNAL FROM TOP-SIDE DOWN:	3-1-4-2							
	TORQUE RODS BOLTS WITH TORQUE LUBE (ARP OR OIL) TO 20 FT-LBS. RE-TOURQE TO 42 FT-LBS. CHECK ROD END CLEARANCE. SPECIFICATION DETAIL...	***							

----	A24-1820 CONNECTING ROD, TURBO, LONG 5.520	4.00							
	Qty Per:	4.0000	Unit of Measure						
	Fixed Qty:	0.00	Qty Per Basis:	Starting Qty					

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----A24-1005 ROD BEARING STD (8 PIECES-ONE ENGINE 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

--150 EA-LEVEL-01 - ENGINE ASSEMBLY LEVEL 1 **Type:** 0.0 % Scra
End Qty: 1.00 **Start Qty:** 1.00
Resource ID: EA-LEVEL-01 **Setup:** 0.0 Hrs **Fixed Scrap:** 0.00
Run: 30.0000 MIN/P **Min Move:**
Service ID: **Transit:** 0.0 Days **Capacity Min:**
ASSEMBLE SHORT BLOCK -

REMOVE CENTER JOURNAL BEARING HALVES. INSPECT ALL OIL PASSAGES IN CASE HALVES.

ACETONE CLEAN CASE HALVES. PAY SPECIAL ATTENTION TO JOURNALS AND MATING SURFACES FOR BURRS OR LOOSE MATERIAL.

INSTALL LIFTERS USING ASSEMBLY LUBE.

INSTALL CAM BEARING SET. DETAILS....***

INSTALL SET SCREWS (E00-9304) TO LIFTER GALLEYS USING SCOTCH-WELD.

PLACE CASE HALF ON TO WOOD BOX FIXTURE #_____.

INSTALL CRANKSHAFT IN TO (3-4 / OIL GALLEY SIDE) OF CASE HALF. PAY SPECIAL ATTENTION TO BEARING AND BEARING PIN ALIGNMENT. CHECK FOR FREE ROTATIONAL MOVEMENT AND VERIFY END-PLAY.

INSTALL CAM USING ASSEMBLY LUBE ON CAM BEARINGS. ALIGN TIMING MARKS.

RECLEAN CONTACT SURFACES OF CRANK CASE HALVES WITH ACETONE.

APPLY A 1/8-INCH BEAD OF SILICONE ALONG CONTACT SURFACE OF (3/4 / OIL GALLEY SIDE) CASE HALF. STAY TO INSIDE OF BOLT HOLES. PAY SPECIAL ATTENTION TO EDGES AND OIL PASSAGE AT TOP CAM BEARING.

ASSEMBLE CASE HALVES TOGETHER USING CASE DOWELS TO ALIGN. BE CERTAIN THAT THERE IS ADEQUATE ASSEMBLY LUBE ON

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LIFTERS SO THEY WILL NOT FALL OUT WHEN MATING CASE HALVES TOGETHER. TAP CASE HALVES TOGETHER USING SMALL DEAD-BLOW HAMMER.

USE MAIN STUDS FROM JOB BOX #_____.

NOTE: TIGHTENING SEQUENCE IS TWO CENTER STUDS FOLLOWED BY CROSS-PATTERN TO CORNER STUDS. TORQUE ALL STUDS 20 FT-LBS. RE-TORQUE ALL STUDS TO 40 FT-LBS.

----E00-9304 SET SCREW 5/16-18 X 3/8 SMOOTH 2.00
Qty Per: 2.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

----A24-1014 CAM BEARING SET, SILVERLINE 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

----E00-2518 BOLT AN5-21A (5/16 X 2-1/8) 8.00
Qty Per: 8.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

----E00-4501 WASHER 5/16 REGULAR AN960-516 16.00
Qty Per: 16.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

----E00-3500 NUT AN365-524A (5/16-24 FIBRLOCK) 8.00
Qty Per: 8.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

--160 EA-LEVEL-01 - ENGINE ASSEMBLY LEVEL 1 **Type:** 0.0 % Scra
End Qty: 1.00 **Start Qty:** 1.00
Resource ID: EA-LEVEL-01 **Setup:** 0.0 Hrs **Fixed Scrap:** 0.00
Run: 30.0000 MIN/P **Min Move:**
Service ID: **Transit:** 0.0 Days **Capacity Min:**
INSTALL LOWER COVER -

ACETONE CLEAN CONTACT SURFACES OF LOWER COVER AND LOWER SIDE OF SHORT BLOCK.

APPLY ASSEMBLY LUBE TO CAM AND CRANK GEARS.

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INSTALL MAIN GALLEY O-RING USING A LIGHT FILM OF SILICONE.

APPLY A 1/8-INCH BEAD OF SILICONE ALONG CONTACT SURFACE OF LOWER COVER. STAY TO INSIDE OF BOLT HOLES. PAY SPECIAL ATTENTION TO NOT GET SILICONE IN MAIN GALLEY PORT. INSTALL LOWER COVER USING CASE DOWELS TO ALIGN. TAPE TOGETHER USING SMALL DEAD-BLOW HAMMER.

INSTALL HARDWARE. TORQUE BOLTS TO 15 FT-LBS USING CROSS-PATTERN TIGHTENING SEQUENCE.

INSTALL LOWER COVER FITTINGS AND PLUG.

INSTALL PLUGS AND FITTINGS USING TEFLON TAPE. REFERENCE PRINT OR ILLUSTRATION FOR DIRECTION OF FITTINGS.

----A24-2010 OIL EXIT FITTING 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

----A24-2230 90 DEGREE OIL HOSE FITTING 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

----E30-6150 PLUG 1/4 NPT 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

----A24-2016 O-RING #17 VITON 70A 1.00
Qty Per: 1.0000 **Unit of Measure** EA
Fixed Qty: 0.00 **Qty Per Basis:** Starting Qty

--220 EA-LEVEL-01 - ENGINE ASSEMBLY LEVEL 1 **Type:** 0.0 % Scra
End Qty: 1.00 **Start Qty:** 1.00
Resource ID: EA-LEVEL-01 **Setup:** 0.0 Hrs **Fixed Scrap:** 0.00
Run: 15.0000 MIN/P **Min Move:**
Service ID: **Transit:** 0.0 Days **Capacity Min:**
INSTALL OIL PUMP ROTORS AND REGULATOR COVER -

INSTALL OIL PUMP ROTORS AND INSPECT FOR OIL CLEARANCE.
REFERENCE DOCS.

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ROTATE CRANKSHAFT AND CHECK FOR FREE MOVEMENT.

APPLY ASSEMBLY LUBE TO ROTORS.

INSTALL LARGE AND SMALL O-RINGS TO LOWER COVER AND
INSTALL REGULATOR ASSEMBLY. PAY SPECIAL ATTENTION NOT TO
MOVE O-RINGS DURING INSTALLATION.

INSTALL HARDWARE. TORQUE BOLTS TO 15 FT-LBS IN A
CROSS-PATTERN TIGHTENING SEQUENCE.

INSPECT OIL PUMP ROTOR KIT. REFERENCE PRINT. REINSPECT
ROTORS IN LOWER COVER FOR ADEQUATE OIL CLEARANCE.

SCOTCH-BRITE OIL PUMP KIT.

PRESS-FIT PUMP SHAFT IN TO INNER OIL PUMP ROTOR PER DESIGN
SPECIFICATIONS. REFERENCE PRINT.

ASSEMBLE OIL PUMP SHAFT IN TO INNER ROTOR. KEEP DOWEL
CUT-OUT IN ROTOR TO THE OUTSIDE. USE A .055"-.060" SPACER TO
LIMIT SHAFT PRESS IN TO INNER ROTOR. PLACE A PIECE OF
ALUMINUM BETWEEN SHAFT AND PRESS RAM TO PREVENT
MUSHROOMING OF SHAFT DURING PRESS.

THIS PRESS WITH SPACER PROVIDES APPROX. .045" OF CLEARANCE
BETWEEN SHAFT AND CAM SLOT.

----A24-2460 OIL PUMP COVER, REGULATOR ASSEMBLY	1.00
Qty Per:	1.0000 Unit of Measure EA
Fixed Qty:	0.00 Qty Per Basis: Starting Qty

----A24-2402 O-RING #20 VITON 70A	1.00
Qty Per:	1.0000 Unit of Measure EA
Fixed Qty:	0.00 Qty Per Basis: Starting Qty

----A24-2403 O-RING #39 VITON 70A	1.00
Qty Per:	1.0000 Unit of Measure EA
Fixed Qty:	0.00 Qty Per Basis: Starting Qty

----E00-2527 BOLT GRADE 8 (5/16-18 X 1-1/2)	4.00
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Qty Per: 4.0000 Unit of Measure EA Fixed Qty: 0.00 Qty Per Basis: Starting Qty				
----E00-4501 WASHER 5/16 REGULAR AN960-516	4.00			
Qty Per: 4.0000 Unit of Measure EA Fixed Qty: 0.00 Qty Per Basis: Starting Qty				
----A24-2411 OIL PUMP ASSY, MACHINED IN & OUT ROT	1.00			
Qty Per: 1.0000 Unit of Measure EA Fixed Qty: 0.00 Qty Per Basis: Starting Qty				
----A24-2413 OIL PUMP SHAFT	1.00			
Qty Per: 1.0000 Unit of Measure EA Fixed Qty: 0.00 Qty Per Basis: Starting Qty				
--230 EA-LEVEL-01 - ENGINE ASSEMBLY LEVEL 1 Type:	0.0 % Scra			
End Qty: 1.00 Start Qty: 1.00 Resource ID: EA-LEVEL-01 Setup: 0.0 Hrs Fixed Scrap: 0.00 Run: 15.0000 MIN/P Min Move: Service ID: Transit: 0.0 Days Capacity Min: MOVE ENGINE TO ENGINE STAND.				
INSTALL CAM END PLATE. INSTALL PLUG TO OIL GALLEY USING 3M DP190.				
----A24-2013 CAM END PLATE	1.00			
Qty Per: 1.0000 Unit of Measure EA Fixed Qty: 0.00 Qty Per Basis: Starting Qty				
----E00-2300 BOLT AN3-4A (3/16 X 1/2)	4.00			
Qty Per: 4.0000 Unit of Measure EA Fixed Qty: 0.00 Qty Per Basis: Starting Qty				
----E00-4301 WASHER AN960-10 (3/16 REGULAR)	4.00			
Qty Per: 4.0000 Unit of Measure EA Fixed Qty: 0.00 Qty Per Basis: Starting Qty				
----A24-4353 PLUG-6, 3/8 NPT ALUM.	1.00			
Qty Per: 1.0000 Unit of Measure EA				

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Fixed Qty:		0.00	Qty Per Basis: Starting Qty		