

M20106  
REV. B

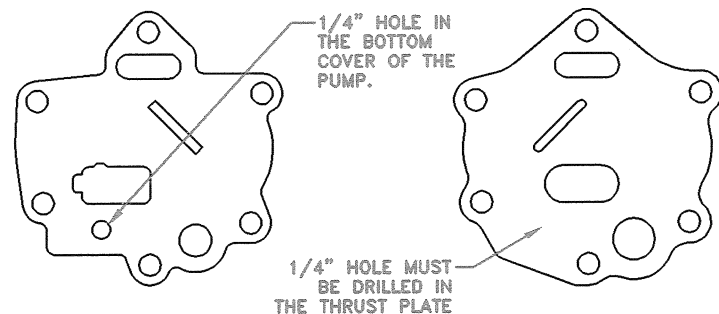
# ATTENTION

THESE INSTRUCTIONS MUST BE FOLLOWED IN ORDER FOR PROPER INSTALLATION OF THE P-20I KIT IN 1961-'63 BUICK AND OLDSMOBILE 215 ALUMINUM V-8 APPLICATIONS.

THE BOTTOM COVER OF THE OIL PUMP HAS A 1/4" HOLE THAT IS NOT IN THE THRUST PLATE OR THE GASKET. (SEE ILLUSTRATION)

DRILL A 1/4" HOLE IN THE GASKET AND THRUST PLATE USING THE TEMPLATE PROVIDED. ON THE BACK OF THIS SHEET.

5.50

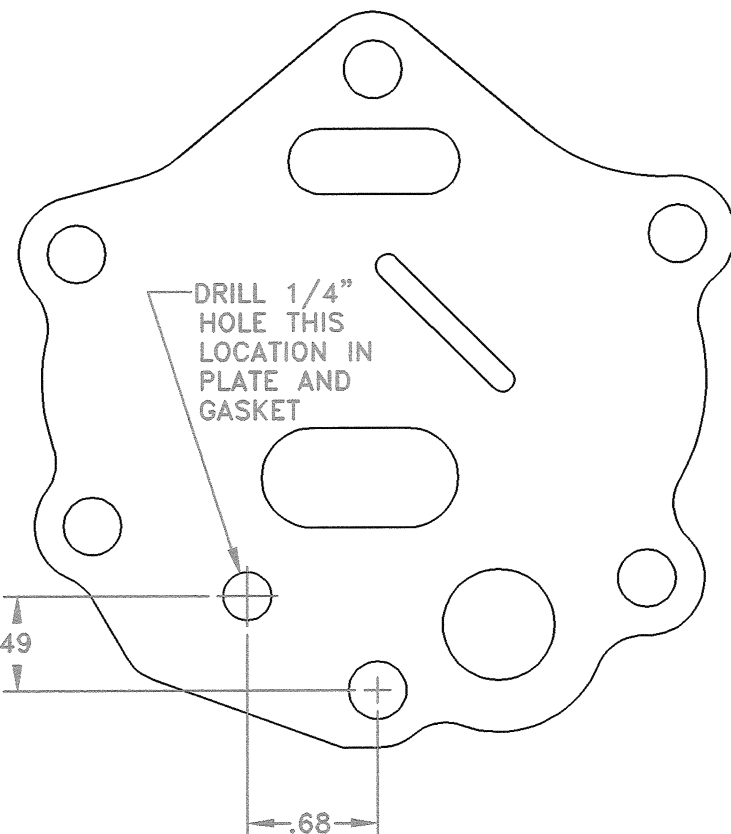


OVER

4.25

FRONT

# DRILL TEMPLATE



OVER

BACK

SUPERSCEDES ALL PRINTS PRIOR TO THIS DATE: \_\_\_\_\_

ENGINEERING APPROVAL OF FIRST PRODUCTION SHIPMENT FROM EACH SUPPLIER IS REQUIRED PRIOR TO AUTHORIZATION FOR USE ON MELLING PRODUCTION. NEW SAMPLES REQUIRED BEFORE ANY CHANGE IN PRODUCTION PROCESSING FOR ENGINEERING FUNCTIONAL TEST AND APPROVAL.

### DO NOT SCALE DRAWING

UNLESS OTHERWISE SPECIFIED THE FOLLOWING TOLERANCES APPLY:

#### METRIC DIMENSIONS

±.25 ALLOWED ON ONE PLACE DECIMALS  
±.13 ALLOWED ON TWO PLACE DECIMALS  
±.013 ALLOWED ON THREE PLACE DECIMALS  
±0°30' ON ANGULAR DIMENSIONS.

#### ENGLISH DIMENSIONS

±.015 ALLOWED ON ONE PLACE DECIMALS  
±.010 ALLOWED ON TWO PLACE DECIMALS.  
±.005 ALLOWED ON THREE PLACE DECIMALS.  
±.0005 ALLOWED ON FOUR PLACE DECIMALS  
±0°30' ON ANGULAR DIMENSIONS.

## MATERIAL:

White Paper: 4.25" Wide x 5.50" High

B	4/28/99	SPANISH VERSION ADDED	2122	--
A	4/12/99	WAS P-201	2119	--
-	9/5/97	RELEASED	--	--

LTR	DATE	REVISION	ECR	LOC
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THE FOLLOWING ITEMS APPLY UNLESS OTHERWISE SPECIFIED: FOR FEATURES OF SIZE, PERFECT STRAIGHTNESS NOT REQUIRED AT MMC. FOR DIAMETRAL FEATURES, ROUNDNESS, MUST BE WITHIN THE MMC. AND LMC(LEAST MATERIAL CONDITION) BOUNDARY. TRUE POSITION TOLERANCES, AND RELATED DATUMS(EXCEPT PLANE SURFACES), APPLY AT MMC. OTHER GEOMETRIC TOLERANCES, AND RELATED DATUMS, APPLY AT RFS. SEPARATE TRUE POSITION CALLOUTS MAY BE GAGED SEPARATELY, REGARDLESS OF DATUM REFERENCE.

### GEOMETRIC DRAWING SYMBOLS

— FLAT	⊕ TRUE POSITION	○ ROUND	∕ CYLINDRICAL
— STRAIGHT	∕ RUNOUT	∠ ANGULAR	⊙ CONCENTRIC
⊥ SQUARE	∅ DIAMETER	≡ SYMMETRICAL	— PROFILE OF A LINE
// PARALLEL	∆ PROFILE OF SURFACE	Ⓜ MAXIMUM MATERIAL CONDITION(MMC)	Ⓧ BASIC DIMENSION
Ⓜ MAXIMUM MATERIAL CONDITION(MMC)	Ⓧ BASIC DIMENSION	Ⓢ REGARDLESS OF FEATURE SIZE	(xxx) REFERENCE
Ⓟ PROJECTED TOLERANCE ZONE			

## MELLING TOOL COMPANY

P.O. BOX 1188, JACKSON, MICHIGAN 49204



ENGINE COMPONENTS  
PRODUCT ENGINEERING



REF. M20	SHT. 1 OF 2			
DRAWN BY MJO	COMPLETED 4/21/99	CHECKED KDS	APPROVED 4/21/99	SCALE FULL
DO NOT SCALE	TOLERANCES NOT OTHERWISE SPECIFIED MACHINED DIM. ± STAMPED DIM. ± ANGULAR DIM. ± DIM. ±			
MATERIAL SEE NOTE	APP. scm	DATE 4/28/99		
NAME SHEET-INSTALLATION				
PART NO. M20106				