

DATE CODE TO APPEAR ON VALVE (YEAR-MONTH-DATE)

CALIBRATION:

VACUUM CHECK FUNCTION:  
VALVE MUST BE 100% LEAK TESTED-

LEAK RATE NOT TO EXCEED 10 SCCM WITH 3 psi PRESSURE APPLIED TO VAC PORT & 15 psi APPLIED TO THE VAC PORT

OPENING CHARACTERISTICS:  
SOURCE VACUUM REQUIRED TO OPEN VALVE MUST NOT EXCEED THREE INCHES Hg

FLOW CHARACTERISTICS:  
FORWARD FLOW MUST BE MINIMUM OF 4.1 CFM WITH 14" Hg VACUUM APPLIED TO PORT A WITH PORT B OPEN TO ATMOSPHERE

VALVE MUST CONFORM TO ES-E2SC-2005-AA SECTION III.M ONLY, WITH THE EXCEPTION OF PARAGRAPH M.1.a.

ALTERNATE CALIBRATION METHODS MAY BE USED PROVIDING PERFORMANCE IS EQUIVALENT TO THAT OBTAINED ON THE MASTER TEST STANDS

MATERIAL  
BODY: ESF-M4D82-A  
DIAPHRAGM: EPICHLOROHYDRIN  
SAE J200-M2BG508 B14 E014 E034 F16 Z Z=45±5 DUROMETER

UNLESS OTHERWISE SPECIFIED:  
BURRS-SHARP EDGES AND FOREIGN MATERIAL RESULTING FROM GOOD MANUFACTURING PRACTICES ARE ACCEPTABLE PROVIDING THEY ARE NOT DETRIMENTAL TO ASSEMBLY-FUNCTION OR SAFE HANDLING AS DETERMINED BY ENG PRODUCT ENGINEERING

FOR ENGINEERING APPROVED SOURCE SEE ENGINEERING NOTICE

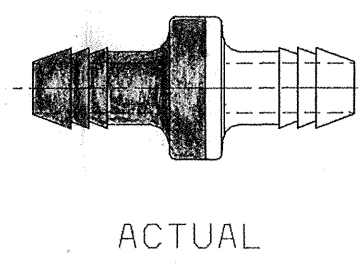
ENGINEERING APPROVAL OF SAMPLES FROM EACH SUPPLIER IS REQUIRED PRIOR TO AUTHORIZATION OF PART PRODUCTION

ENGINEERING APPROVAL OF FIRST PRODUCTION SHIPMENT FROM EACH SUPPLIER IS REQUIRED PRIOR TO AUTHORIZATION FOR USE ON ENGINE PRODUCTION

CHANGES IN DESIGN - COMPOSITION OR PROCESSING FROM THE PART PREVIOUSLY APPROVED FOR PRODUCTION REQUIRE PRIOR ENGINEERING APPROVAL AS DESCRIBED IN FORD MOTOR QUALITY CONTROL SPECIFICATION Q-101 - PARAGRAPH 7.5

RESTRICTIONS TO HELP SAFEGUARD HEALTH, SAFETY, AND THE ENVIRONMENT APPLY TO SUBSTANCES USED IN THE ITEM(S) ADDRESSED BY THIS DOCUMENT. ENGINEERING MATERIAL SPECIFICATION WSS-M99P9999-A1 APPLIES.

▽ CONTROL ITEM - THE ▽ SYMBOL ALSO IDENTIFIES PRODUCT ENGINEERING DESIGNATED CRITICAL CHARACTERISTIC. THESE AND ADDITIONAL CRITICAL CHARACTERISTICS IDENTIFIED BY PROCESS REVIEW, MUST APPEAR ON THE Q-101 CONTROL PLAN(S) WHICH REQUIRE PRODUCT ENGINEERING APPROVAL.



SCANNED

THIS DRAWING CONFORMS TO ANSI Y14.5M-1982

THIRD ANGLE PROJECTION

UNLESS OTHERWISE SPECIFIED

ALL LINEAR DIM. ± 0.5  
ALL ANGULAR DIM. ±  
ALL FILLET RADIUS  
ALL CORNER RADIUS  
MAX. DRAFT  
MAX. COMBINED PARTING LINE FLASH AND MISMATCH TO BE  
SURFACE FINISH  
EXTERIOR  
INTERIOR

(E)	ADDED CUSTOMER NO.	901023	GNL	GNL
(D)	ADDED 15 psi TEST	901023	GNL	GNL
(C)	WAS DEPRESSED	901023	GNL	GNL
(B)	WAS 2 HIGH	890222	DAB	MBL
(A)	REVISED SPEC'S	890222	DAB	MBL

SYM.	REVISION	DATE	DR	CHK'D
DO NOT SCALE				
SCALE	2X	MATERIAL		
DATE	890120	NOTED		
DRAWN BY	MJV			
CHECKED BY	DAB			
D. ENG.	MTV			
O. C.		MINIATURE PRECISION COMPONENTS INC. DRAWER L WALWORTH, WI. 53184		
MAN. ENG				
CUSTOMER NO.	E9DC-2K434-AA (E)	DATE	REV.	
TITLE	3/8" VACUUM CHECK VALVE ASSEMBLY	REV.	SHT.	
		E		
		PART NUMBER		
		A-455		

COMPUTER GRAPHICS  
CHANGE RESTRICTED  
NO MANUAL CHANGES

METRIC  
LINEAR  
DIMENSIONS ARE  
MM  
UNLESS NOTED

CATIA  
DRAWING