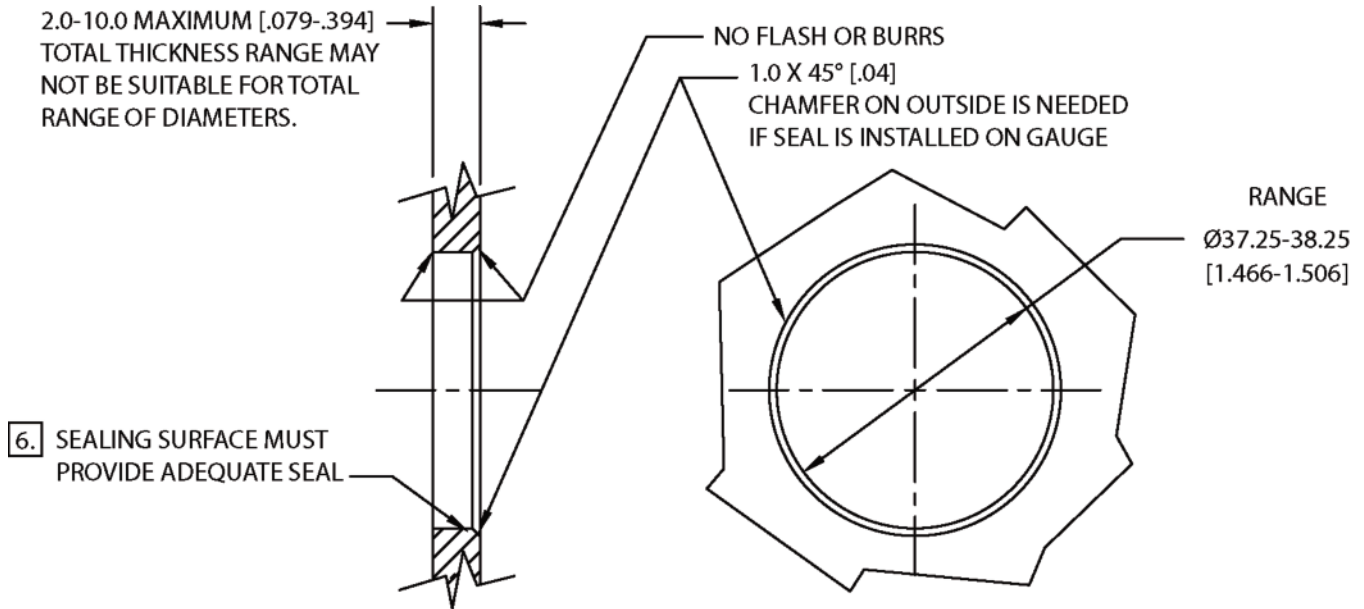




Machining Standards for 8681



NOTES:

1. DIMENSIONS IN BRACKETS ARE IN INCHES.
2. TOLERANCES ARE IN MILLIMETERS.
3. FOR 37.25 DIA. OPENING, SEAL SHOULD BE INSTALLED INTO TANK PRIOR TO THE GAUGE'S INSTALLATION INTO THE SEAL/TANK.
4. CHAMFER IS OPTIONAL IF SEAL IS INSTALLED IN TANK OPENING PRIOR TO GAUGE INSTALLATION.
5. TOP MOUNTING USE ONLY.
6. ALL ASSEMBLIES SHOULD BE LEAK TESTED TO ASSURE ADEQUATE SEAL.
7. COMBINATION OF SHARP INTERIOR CORNER AND SMALLER THAN NORMAL TANK OPENING COULD CUT GROMMET. CORNER BREAK OR EVEN A SMALL ROLL BURR ARE PREFERRED OVER SHARP CORNER.
8. THE FIT OF THE GAUGE IN THE OPENING IS SOMEWHAT SUBJECTIVE. TRY SEVERAL TANK OPENING DIAMETERS FOR BOTH EASE OF ASSEMBLY AND GAUGE RETENTION. AS A GENERAL RULE, THE SMALLER END OF HOLE DIAMETER RANGE WORKS BETTER AS TANK THICKNESS APPROACHES A MINIMUM. A TEMPORARY RUBBER LUBRICANT SUCH AS INTERNATIONAL PRODUCTS CORP. P-80 MAY BE HELPFUL.
- 8A. WETTED PORTION OF NITRILE RUBBER GROMMET WILL SWELL AFTER TANK IS FILLED WITH FUEL. TYPICAL TEST RESULTS FOR 0015-00985 ARE:
 FUEL A, +1%; FUEL B, +19%; OIL NO. 3, +2%; FUEL C, +35%;
 FUEL C WITH 10% ETHANOL, +48%; REF. ASTM D471-06
- 8B. TAKE INTO ACCOUNT GROMMET SWELL WHEN CONSIDERING GROMMET MATERIAL STRESS.
9. USE VITON GROMMET 0015-001007 FOR E85.

