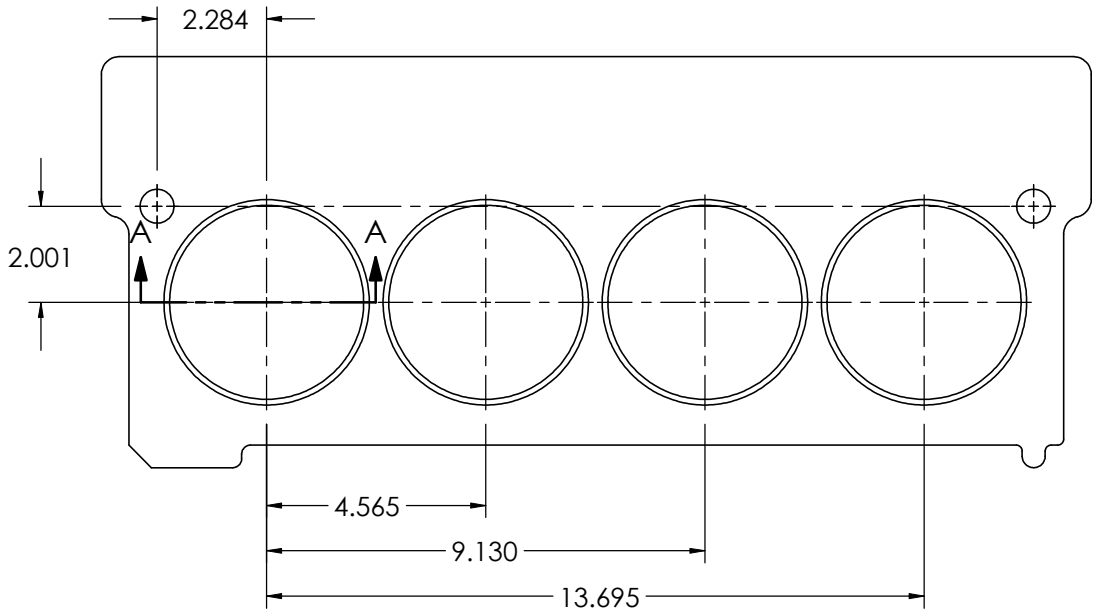
REV.	DESCRIPTION	BY	DATE	ECR
A	RING GROOVE REDESIGN	DAL	05/26/11	

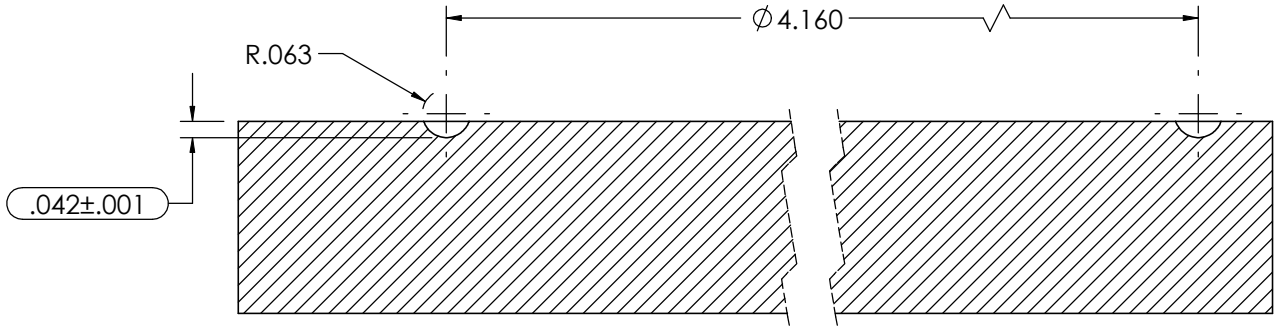


IDEAL CRUSH IS .011±.001
CUT DEPTH = RING DIA - GASKET THICKNESS - .011

EXAMPLE 1:
.105 RING, .052 GASKET
CUT DEPTH = .105-.052-.011
=.042 ±.001

EXAMPLE 2:
.105 RING, .049 GASKET
CUT DEPTH = .105-.049-.011
=.045 ±.001

NOTE: GASKET THICKNESS IS BASED OFF CRUSHED THICKNESS. TO MEASURE THIS, SQUEEZE THE GASKET AND MEASURE WITH CALIPERS.



SECTION A-A
FIRE RING GROOVE
4-PLACES, BOTH HEADS

NOTES:

1. MATERIAL: FIRE RING STEEL
2. FINISH: 32µIN FINISH IN MACHINED GROOVES
3. FOR USE WITH .052 THICK GASKETS, PLEASE MEASURE GASKET THICKNESS PRIOR TO MACHINING

Production P-codes	
Code	Process
P01	Cast
P02	Machining
P03	Paint / Plating
P04	Bending
P05	Treating
P06	2-D operations
P07	Joining / Assembly
P12	Secondary Mach.

USED ON: **FORD 6.0L**

DIMENSIONS ARE IN **INCHES** AFTER FINISH. DO NOT SCALE.

TOLERANCE UNLESS NOTED:
.X ..... ±0.050
.XX ..... ±0.010
.XXX ..... ±0.003
.XXXX ..... ±0.001
MACH ANGLES . ±0.5°
BEND ANGLES.... ±1.5°

ATS Diesel Performance
5293 Ward Rd.
Arvada, CO 80002
800-949-7973

TITLE:
FIRE RING MACH, .105 STEEL

DRAWN
CHECKED
APPROVED

DWG. NO. **103-105-3278**

REV. **A**

SHEET 1 OF 1