



1. Drill and ream two 0.500" holes
2. Drill and ream 10 0.125" holes
3. Using 0.125" pins and a straight edge, indicate holes A-D to mill slot at pressure port. Repeat for slot at scavenge port.
4. Using 0.125" pins and a straight edge, indicate holes C-D to mill 30° scavenge transfer slot.
5. Saw cut waste
6. Using 0.125" pins and holes A-E, machine surface #1. Surface finishes 0.005" after hole B cleans up, and surface is tangent with 0.500" hole. Repeat for opposite side.
7. Using 0.125" pins and holes A-D, machine 260° pressure port. Repeat for 100° scavenge port.
8. Using 0.125" pins and holes C, machine drain port.
9. Machine 0.082" x 0.25" steps, both sides, using 0.60R end mill.
10. Machine surface #2, both sides, 0.005" after hole A cleans up and tangent with 0.500" hole.
11. Still using holes C, flip part and machine surface #3. Surface finished 0.005" after holes E clean up.
12. Using 0.125" pins and holes C-D, machine surface #4. Surface finished 0.005" after holes C-D clean up.