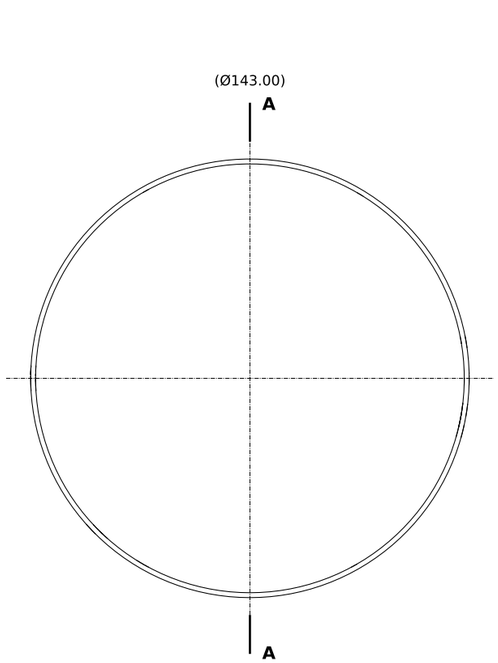
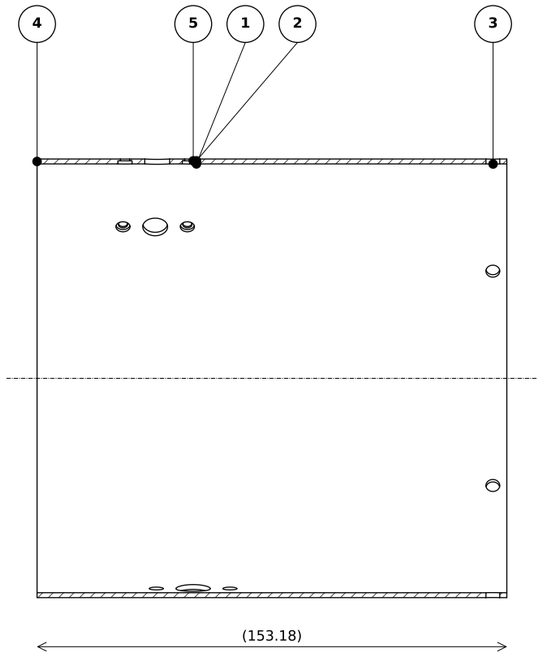


VIEW FROM THE INLET



SECTION A-A

REQUIREMENTS

1. A: bore Ø139.80 +0.05/0
2. OD Ø143.0 ±0.1; wall 1.6 ±0.05
3. 6× Ø4.5 radial, equally spaced, 148.62 ±0.1 from the front end
4. Ends: perpendicular 0.05 to A; length 153.18 ±0.05
5. Start system, radial, from the front end: Ø11.2 for the igniter holder at 191.25°, 50.90; Ø8.1 for the fuel gland at 0°, 39.17; Ø8.1 for the gas gland at 168.75°, 50.90; Ø8.1 for the lube gland at 315°, 38.52. Each with 2× Ø3 +0.08/0 along the axis (±10.5 at the glands, ±12 at the igniter) for PEM FHS-M3-6 studs pressed in from inside, flush in the bore; ±0.1

NOTES

1. Model is master: sizes not called out come from case.step, at the general tolerance.
2. Break sharp edges 0.1–0.3 unless noted. No burrs. No tool marks across sealing or seating faces.
3. Surface finish Ra 1.6 µm unless noted. Threads to ISO 965 (metric fine).
4. Inspection report, CMM and material certificates are add-ons on the quote.

HIGHLAND Turbojet, 170 N class

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PART Outer case	PART NUMBER HL-TJ-17		REVISION A
MATERIAL Aluminum 6061-T6 (ASTM B211 bar)			
FINISH None, as machined		HEAT TREAT None	
TOLERANCE UNLESS NOTED ±0.13 mm (±0.005 in) unless noted; angles ±0.5°			
QUANTITY 1 per engine	MASS 292.1 g		SCALE 1:2
UNITS mm	PROJECTION Third angle	DATE 2026-11-20	SHEET A3, 1 of 1