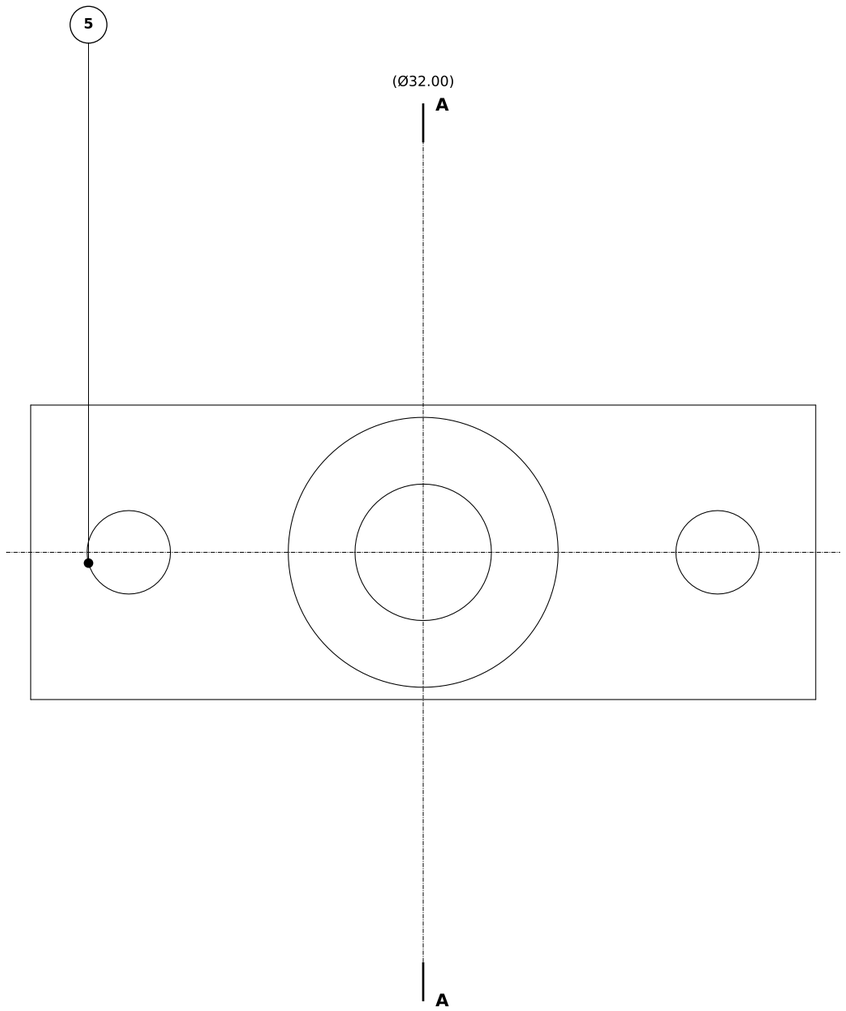
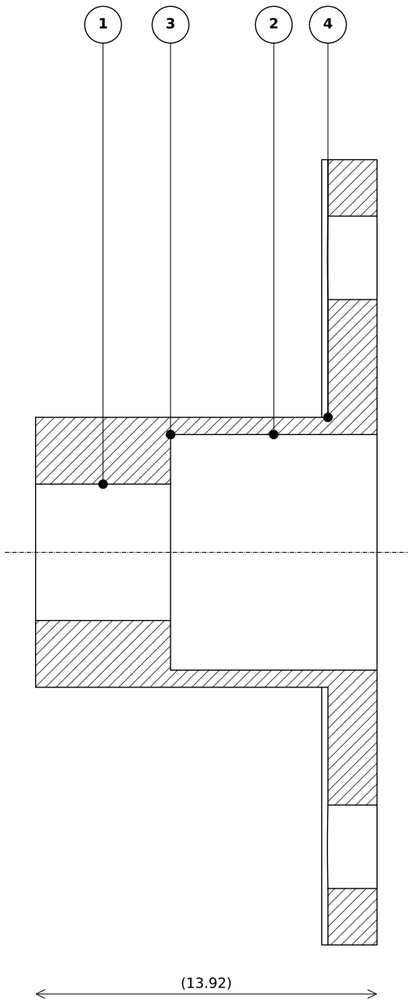


VIEW FROM THE INNER END



SECTION A-A

REQUIREMENTS

1 1/4-32 UNEF-2B, 5.5 long from the inner end (tap drill Ø5.56): the glow plug screws in from this end

2 Bore Ø9.6 +0.1/0 from the outer end, clears the plug's hex

3 Tube Ø11.00 −0.05/−0.10 (10.90–10.95), through the case's Ø11.2 hole

4 Flange underside: concave R71.50 +0.1/0, sits on the case

5 2× Ø3.4 through for the case's M3 studs, 24.0 apart along the axis ±0.1

NOTES

1. Model is master: sizes not called out come from igniter_holder.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. The glow plug is bought: 1/4-32 UNEF, the turbine kind. It lasts about 40 to 50 starts and changes from outside.
5. Inspection report, CMM and material certificates are add-ons on the quote.

HIGHLAND Turbojet, 170 N class

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PART Igniter holder	PART NUMBER HL-TJ-20		REVISION A
MATERIAL Stainless 304 (ASTM A276 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 9.1 g		SCALE 4:1
UNITS mm	PROJECTION Third angle	DATE 2026-11-20	SHEET A3, 1 of 1