LIST OF SCHEDULES

APPLICATION OF SCHEDULES

Introduction

1 The fits and clearance data are given under the following headings :—

Dimension, new

Permissible worn dimension

Clearance, new

Permissible worn clearance

2. Dimensions are given in inches and decimals of an inch.

3. A key diagram of the component is given with each schedule, and the points at which wear is likely to occur are numbered on the diagram; the numbers also appear in the first column of the schedule against the data appropriate to the point of wear.

Dimension, new

4. The figures given in this coloumn are the maximum and minimum drawing sizes to which new parts are made. The difference between the two dimensions is the manufacturing tolerance and is an expression of the accuracy and quality of workmanship required by the design.

Clearance, new

5. The figures given in this colunm are the maximum and minimum clearances which result from mating two new parts. Normally an interference fit is indicated by a minus (−) sign, but sometimes it may be indicated by the word TIGHT, in which case a clearance is indicated by the word CLEAR or SLACK. Where used, the word SIZE indicates zero clearance.

Permissible worn clearance

6. This is the maximum clearance permitted between two mating parts which are assembled to undergo a further full period of service.

Permissible worn dimension

7. This is the limiting dimension to which the part may wear and still be refitted for a further full period of service, provided that its mating part is selected so that the PERMISSIBLE WORN CLEARENCE is not exceeded.

8. A part worn to the PERMISSIBLE WORN DIMENSION quoted will necessitate the use of a new mating part. This new part will, in the extreme, have to be the limiting DIMENSION, NEW, i.e., a low limit hole for a worn pin, and a high limit pin for a worn hole.

9. Sometimes technical considerations, e.g. depth of nitriding, thickness of cylinder walls, will considerably reduce the amount of wear that can be allowed.

10. A part worn beyond the PERMISSIBLE WORN DIMENSION quoted, must be classified as unserviceable unless it can be restored to a serviceable condition by an approved repair scheme.

Schedule 1 **ROTATING PARTS ASSEMBLY**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	HIGH SPEED BALL BEARING					
	Diametral clearance			0·001		
	Endfloat			0·002 / 0·005	0·007	
	Housing—bore	1·84995 / 1·8497				
	Bearing—dia.	1·85041 / 1·85021		−0·00026 / −0·00071		
2	HIGH SPEED PINION					
	Variation from true involute profile	0·0002	0·0005			
3	OIL SEAL COMPRESSOR SHAFT LOCATION BEARING					
	Oil seal—bore	1·065 / 1·064	1·0665			
	Compressor shaft—dia.	1·062 / 1·061		0·004 / 0·002	0·0055	
	Compressor housing—bore	1·5315 / 1·5310				
	Oil seal—dia.	1·5320 / 1·5315		Size −0·001		
4	ROTATING GUIDE VANES					
	Bore of rotating guide vane inner end	1·12375 / 1·12350				
	Compressor shaft—dia.	1·12850 / 1·12825		−0·0045 / −0·0050		
	Bore of rotating guide vane outer end	1·09245 / 1·09220				
	Compressor shaft—dia.	1·09720 / 1·09695		−0·0045 / −0·0050		
5	COMPRESSOR ROTOR					
	Rotor—bore	1·62525 / 1·62500				
	Compressor shaft—dia.	1·63100 / 1·63075		−0·0055 / −0·0060		
	Rotor—bore	1·15625 / 1·15600				
	Compressor shaft	1·16050 / 1·16025		−0·0040 / −0·0045		

Schedule 1—(continued) **ROTATING PARTS ASSEMBLY**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
6	CLEARANCE BETWEEN COMPRESSOR ROTOR VANES AND COMPRESSOR HOUSING			0·015 / 0·018		
7	COMPRESSOR SHAFT SEAL ASSEMBLY					
	Seal—bore	1·627 / 1·626	1·6285	0·003 / 0·001	0·0045	
	Compressor shaft—dia.	1·625 / 1·624				

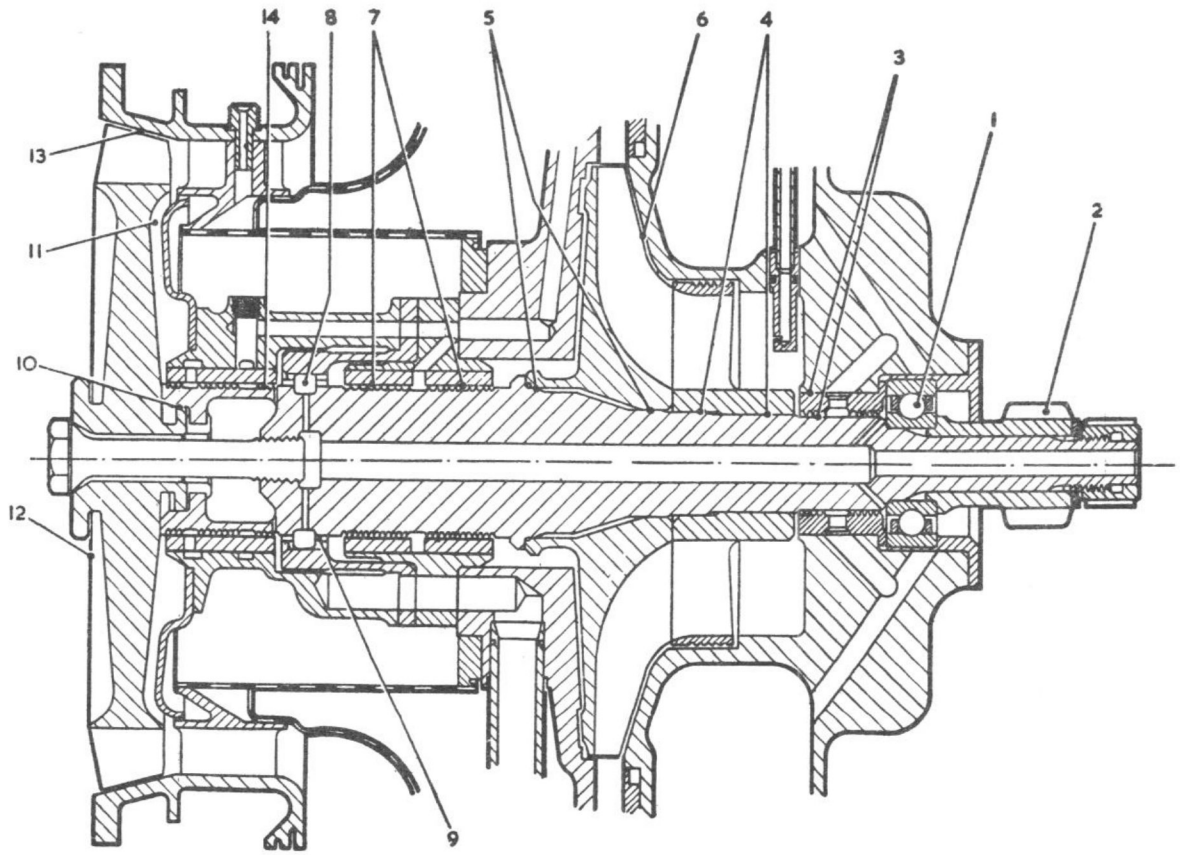

Fig. 1. Rotating parts assembly

Schedule 1—(continued) **ROTATING PARTS ASSEMBLY**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
8	ROLLER BEARING FLEXIBLE SUPPORT					
	Oil seal housing—bore	2·438 / 2·437		0·006 / 0·004		
	Outer race outside diameter	2·433 / 2·432				
	Outer race track diameter	1·92475 / 1·9245				
	Shaft track—dia.	1·4240 / 1·42375	1·4235	0·0005 / 0·0014	0·00165	
	Roller—dia.	0·2500 / 0·2498				Rollers as a set not to vary by more than 0·00005 on dia.
	Roller width	0·2500 / 0·2496		0·002 / 0·0034	0·00365	
	Track width	0·252 / 0·253	0·25325			
9	ROLLER CAGE					
	Inner—dia.	1·6310 / 1·6300				
	Roller pocket width	0·262 / 0·260	0·264	0·0124 / 0·010	0·0144	
	Roller pocket length	0·262 / 0·260	0·264			
10	TURBINE ROTOR					
	Compressor shaft—bore	1·1560 / 1·1555	1·1580	−0·0005 / −0·0015	0·0015	
	Rotor hub—dia.	1·1570 / 1·1565				
11	CLEARANCE BETWEEN TURBINE ROTOR AND COOLING RING			0·070 min		
12	TURBINE ROTOR PERMISSIBLE SWASH	0·015 max				Measured at 2·250 rad.
13	TURBINE ROTOR RADIAL TIP CLEARANCE			0·015 min		
14	TURBINE ROTOR OIL SEAL					
	Oil seal—bore	1·6270 / 1·6260	1·6285	0·0030 / 0·0010	0·0035	
	Compressor shaft—dia.	1·6250 / 1·6240	1·6270			

Schedule 2 **EXHAUST CONE**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	CLEARANCE BETWEEN TURBINE AND COOLING RING			0·136 0·120		
2	ENGAGEMENT OF EXHAUST CONE IN BELLOWS FLANGE			0·100 0·030		

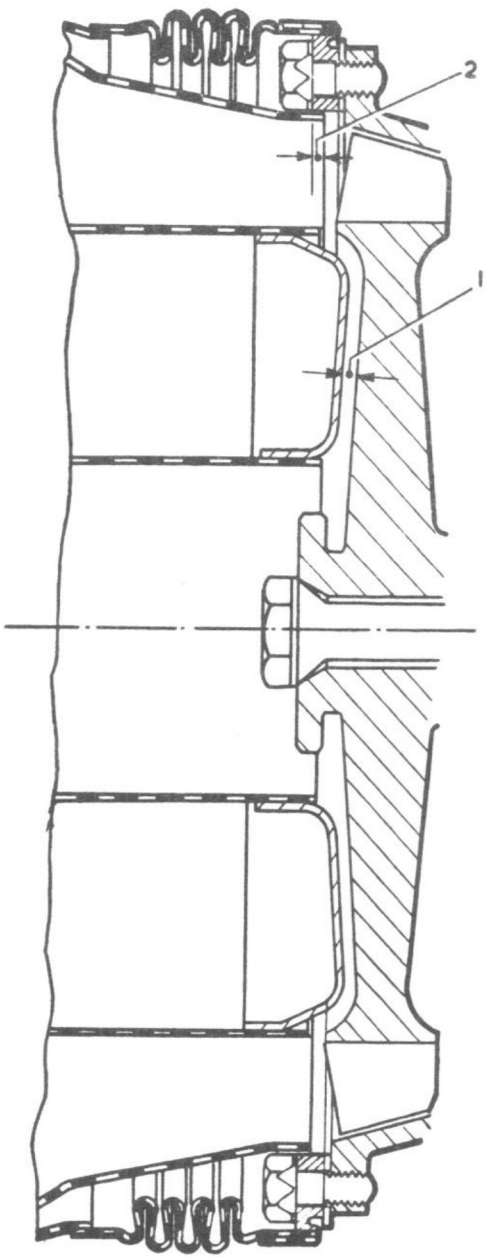

Fig. 1. Exhaust cone

Schedule 3 **INTERMEDIATE DRIVE GEAR**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	INTERMEDIATE WHEEL AND SHAFT Gear variation from true involute profile	0·0002	0·0005			
2	INTERMEDIATE WHEEL AND SHAFT OUTPUT DRIVE PINION SPLINES Shaft over pins	0·972 / 0·970	0·9697	−0·0003 / −0·0029	−0·0001	0·1920 pin dia.
	Pinion between pins	0·5243 / 0·5223				0·144 pin dia.
3	OUTPUT DRIVE PINION Variation from true involute profile	0·0002	0·0005			
4	INTERMEDIATE BEARING AND HOUSING Permissible end float			0·002 / 0·005		

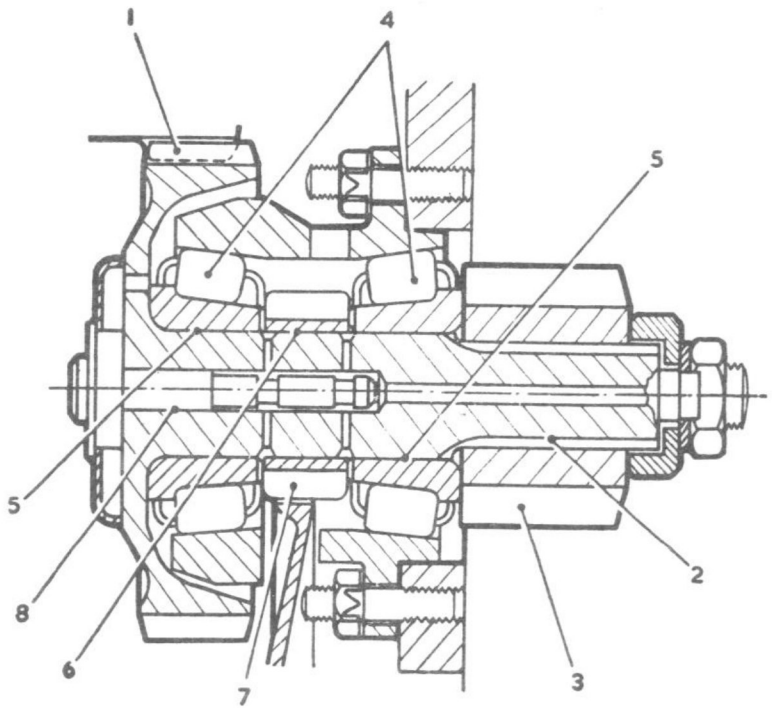

Fig. 1. Intermediate drive gear

Schedule 3—continued **INTERMEDIATE DRIVE GEAR**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
5	INTERMEDIATE BEARING AND SHAFT					
	Bearing—bore	0·8750 / 0·8755		−0·00130 / −0·00055	−0·00035	
	Shaft—dia.	0·87630 / 0·87605	0·87585			
6	INTERMEDIATE PUMP PINION AND SHAFT					
	Pinion—bore	0·8740 / 0·8745		−0·0023 / −0·00155	−0·00135	
	Shaft—dia.	0·87630 / 0·87605	0·87585			
7	INTERMEDIATE PUMP PINION					
	Variation from true involute profile	0·0002	0·0005			
8	OIL THROWER					
	Shaft—bore	0·3295 / 0·3285	0·3284	−0·0017 / −0·0002	−0·0001	
	Thrower stem—dia.	0·3302 / 0·3297				

Schedule 4 **FIRST GENERATOR DRIVE GEAR**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	BEARING ASSEMBLY Permissible end float			0·004 0·002		
2	BEARING FIT Bearing—bore	1·0006 1·0000		0·0012 0·0001		
	Shaft—dia.	0·9999 0·9994				
3	SPLINE BETWEEN PINS	0·6798 0·6758	0·6838			0·086 pin dia.
4	IDLER GEAR Variation from true involute profile	0·0002	0·0005			
5	DRIVE GEAR Variation from true involute profile	0·0002	0·0005			

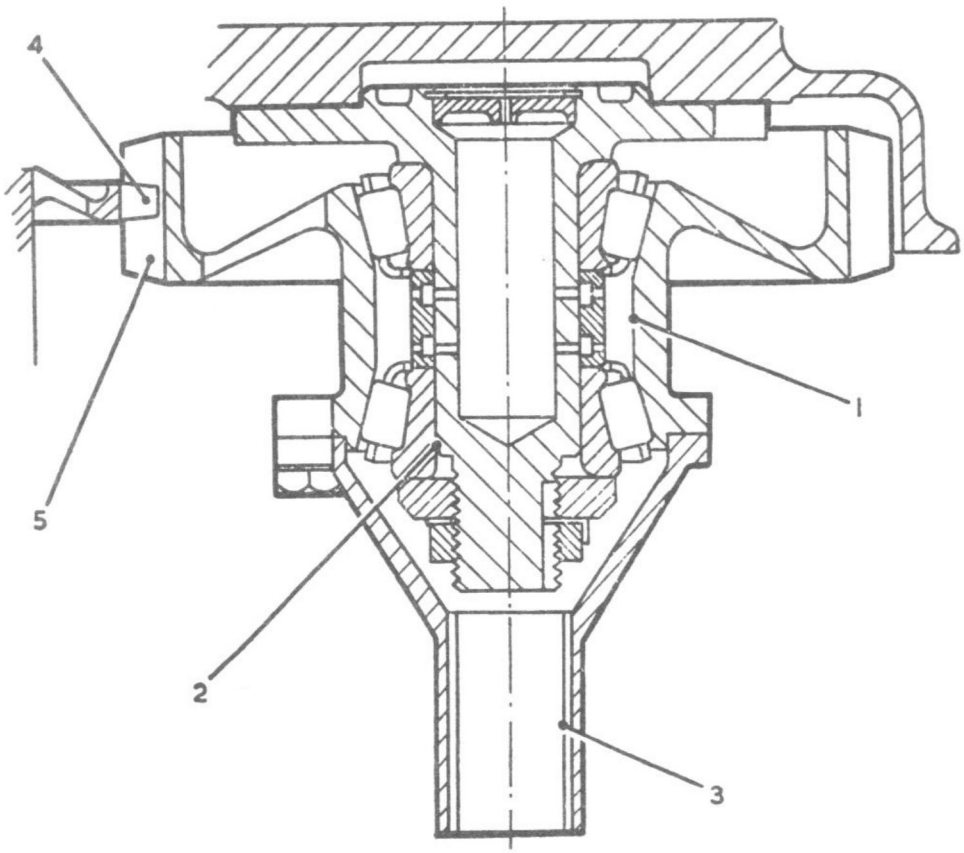

Fig. 1. First generator drive gear

Schedule 5 **IDLER GEAR**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	BEARING ASSEMBLY Permissible end float			0·004 0·002		
2	BEARING FIT Bearing—bore	0·5006 0·5000		0·0012 0·0001		
	Shaft—dia	0·4999 0·4994				
3	IDLER GEAR Variation from true involute profile	0·0002	0·0005			

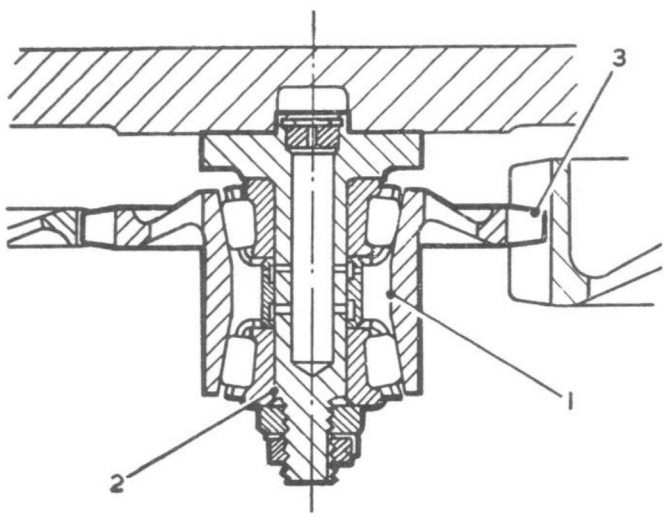

Fig. 1. Idler gear

Schedule 6 **SECOND GENERATOR DRIVE GEAR**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	BEARING ASSEMBLY Permissible end float			0·004 0·002		
2	DRIVE GEAR Variation from true involute profile	0·0002	0·0005			
3	BEARING FIT Bearing—bore	0·4726 0·4720		0·0012 0·0001		
	Shaft—dia	0·4719 0·4714				

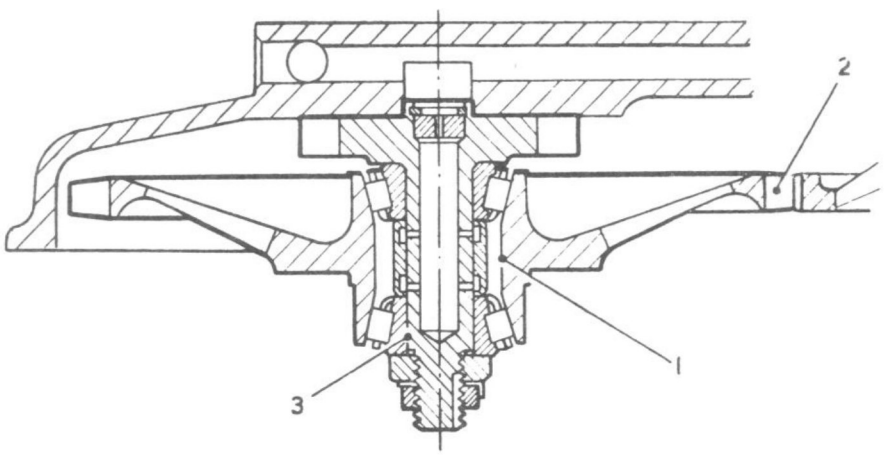

Fig. 1. Second generator drive gear

Schedule 7 **BLOWER DRIVE GEAR**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	BEARING ASSEMBLY Permissible end float			0·004 0·002		
2	BEARING FIT Bearing—bore	0·4726 0·4720		0·0012 0·0001		
	Shaft—dia.	0·4719 0·4714				
3	IDLER GEAR Variation from true involute profile	0·0002	0·0005			

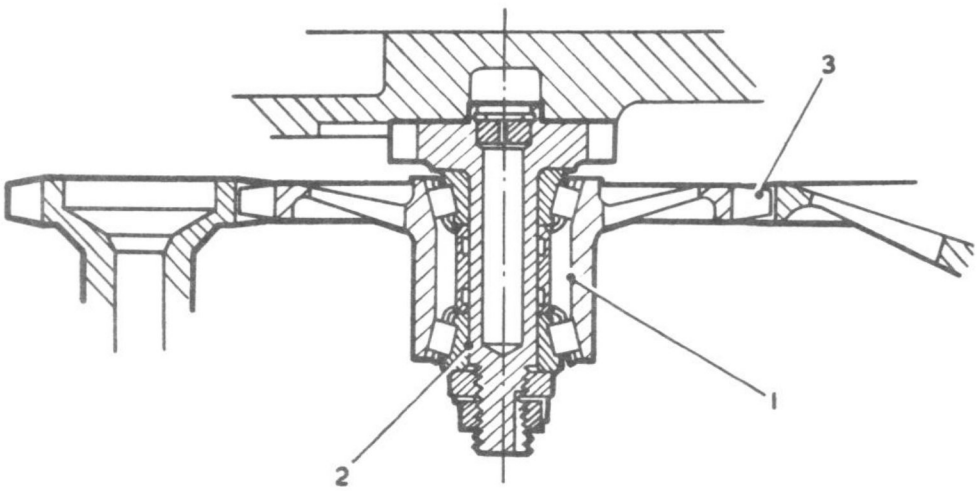

Fig. 1. Blower drive gear

Schedule 8 **HYDRAULIC PUMP DRIVE GEAR**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	BEARING ASSEMBLY Permissible end float			0·004 0·002		
2	BEARING FIT Bearing—bore	0·4726 0·4720		0·0012 0·0001		
	Shaft—dia.	0·4719 0·4714				
3	DRIVE COUPLING Involute spline between pins	1·2767 1·2749	1·2791			0·090 dia. pins
4	DRIVE COUPLING Serations between pins	0·5056 0·5035	0·5091			0·054 dia. pins
5	HYDRAULIC PUMP GEAR Variation from true involute profile	0·0002	0·0005			
6	HYDRAULIC PUMP GEAR Involute spline over pins	1·5592 1·5569	1·5539			0·120 dia. pins

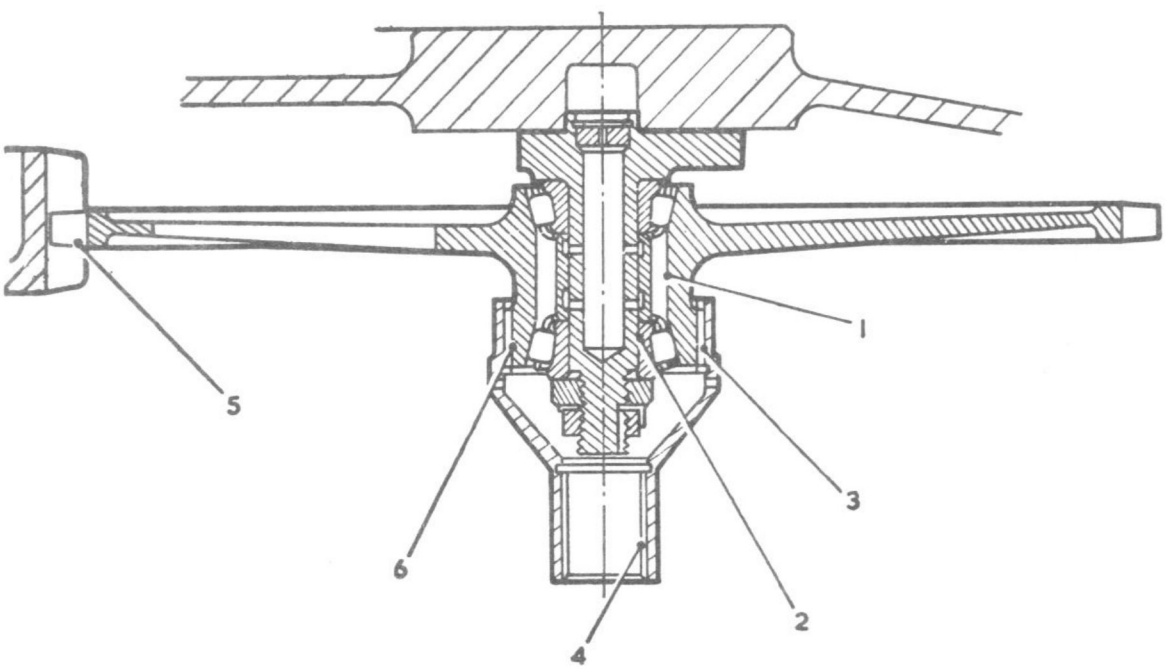

Fig. 1. Hydraulic pump drive gear

Schedule 9 **OIL PUMP AND DRIVE COUPLING**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	OIL PUMP GEARS Variation from true involute profile	0·0002	0·0005			
2	OIL PUMP GEARS ENDFLOAT Oil pump body depth	0·752 / 0·751	0·753	0·003 / 0·001	0·004	
	Gears, width	0·750 / 0·749	Nil			
3	OIL PUMP GEARS RADIAL CLEARANCE Body—bore	0·686 / 0·685	0·687	0·003 / 0·001	0·004	
	Gear—diameter	0·684 / 0·683	Nil			
4	OIL PUMP GEAR SHAFTS, CLEARANCE Body—bore	0·3755 / 0·3750	0·3765	0·002 / 0·001	0·003	
	Shaft—dia.	0·3740 / 0·3735	Nil			

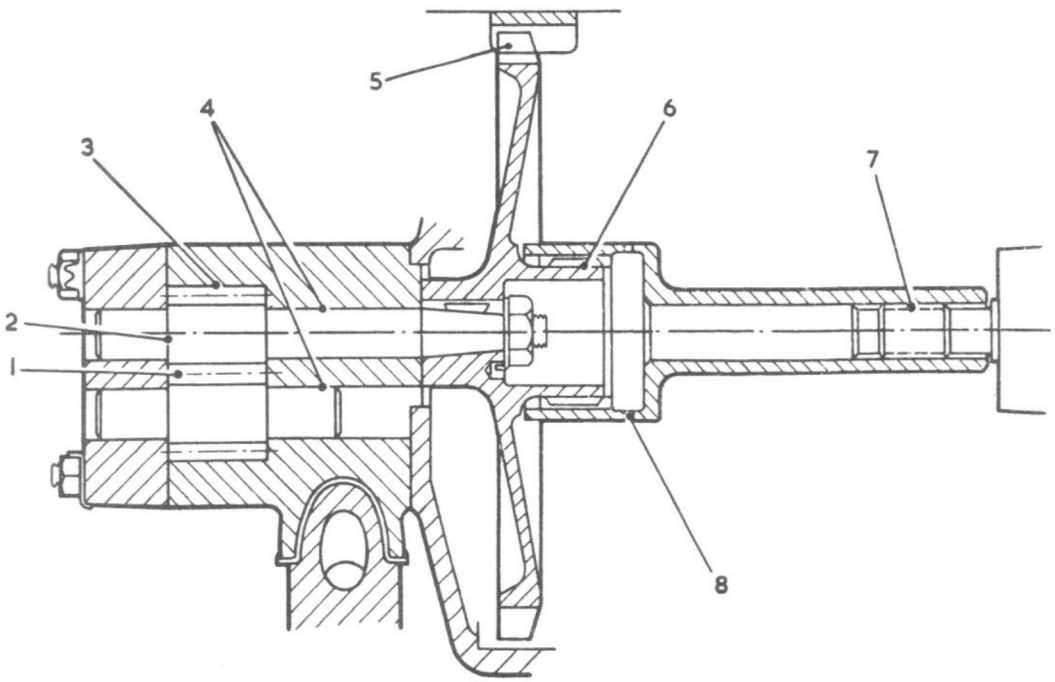

Fig. 1. Oil pump and drive coupling

Schedule 9—(continued) **OIL PUMP AND DRIVE COUPLING**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
5	OIL PUMP DRIVING GEAR Variation from true involute profile	0·0002	0·0005			
6	OIL PUMP DRIVING GEAR Involute splines over pins	1·1829 1·1807	1·1777			0·120 dia pins
7	FUEL PUMP DRIVE COUPLING Serrations between pins	0·2904 0·2888	0·2936			0·0388 dia. pins
8	FUEL PUMP DRIVE COUPLING Involute splines between pins	0·9037 0·9017	0·9077			0·090 dia pins

Schedule 10

OIL FILTER

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	VALVE SPRING Fitted length Fitted load	0·875 5 lb				

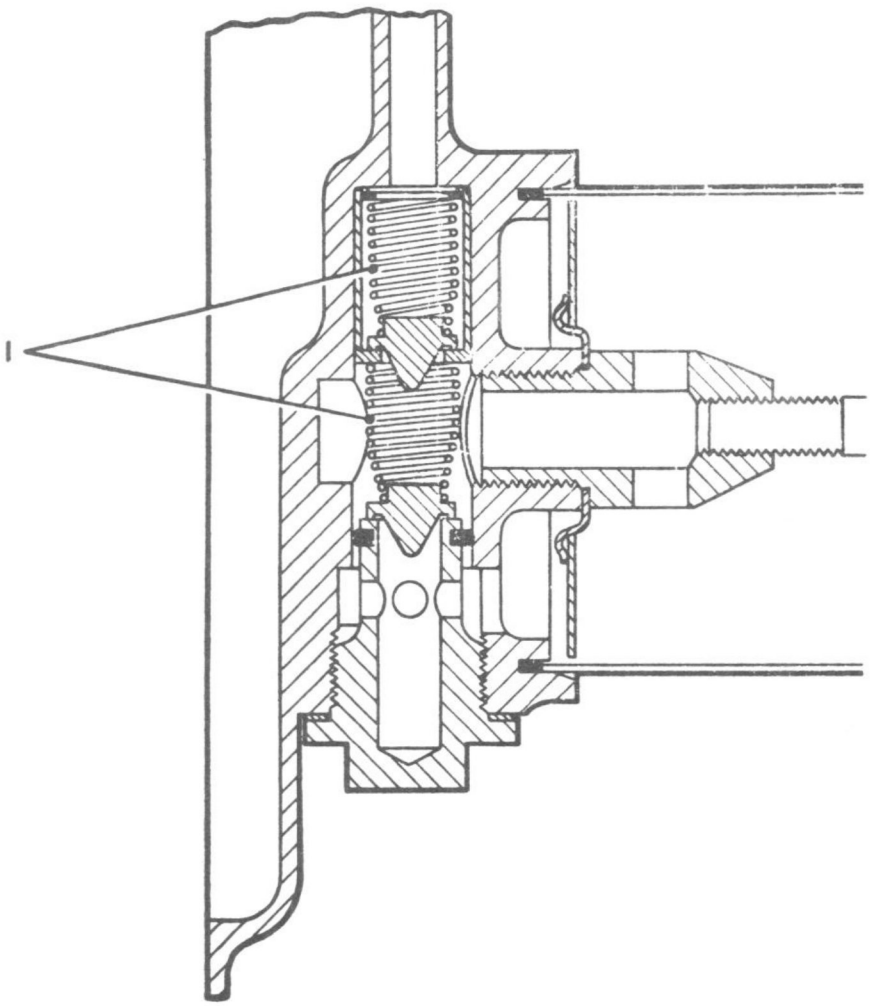

Fig. 1. Oil filter

Schedule 11 **BREATHER SHUT-OFF VALVE**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	VALVE SPRING					
	Fitted length	2·499				
	Fitted load	0·308 lb				
2	VALVE HOUSING AND PISTON					
	Housing—bore	0·751 / 0·750	0·752	0·007 / 0·005	0·009	
	Piston—dia.	0·745 / 0·744	0·743			

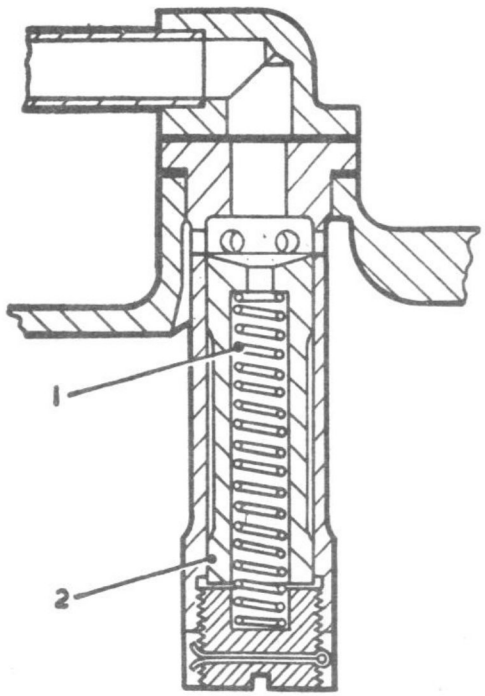

Fig. 1. Breather shut-off valve

Schedule 12 **PRESSURE RE-OIL VALVE**

Fig. Ref No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	VALVE SPRING					
	Fitted length	0·7880 / 0·7080				Free Length 0.875
	Fitted load	3·5 lb / 6·7 lb	3 lb. min			Rate 40 lb/in.
2	VALVE AND BODY CLEARANCE					
	Body hole—dia.	0·2560 / 0·2500		0·008 / 0·001		
	Valve stem—dia.	0·2490 / 0·2480				
3	VALVE TIP AND QUICK RELEASE VALVE FACE					
	Permissible clearance			0·025 / 0·045	0·010 / 0·060	

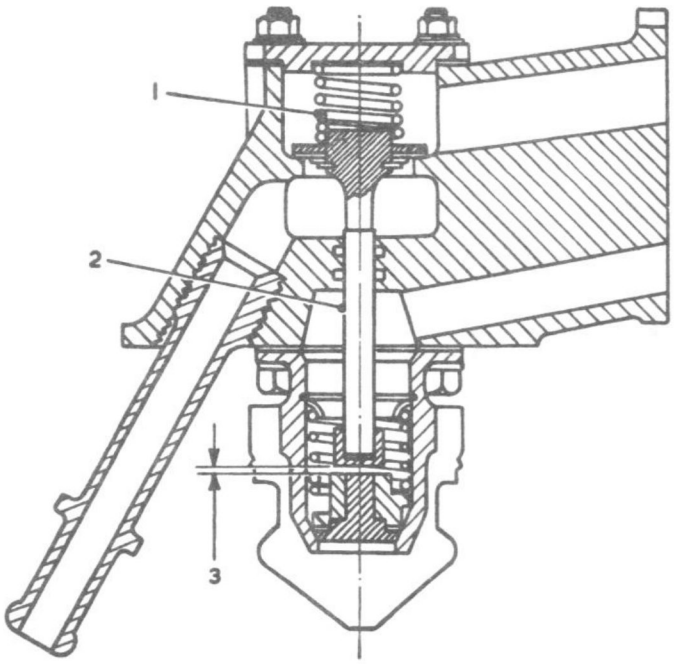

Fig. 1. Pressure re-oil valve

Schedule 13 **AIR ASSISTANCE NON-RETURN VALVE**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	VALVE SPRING Fitted length	0·428 0·400				
	Fitted load	0·0087 lb 0·0063 lb				
2	VALVE PLATE THICKNESS	0·031 0·027	0·020			

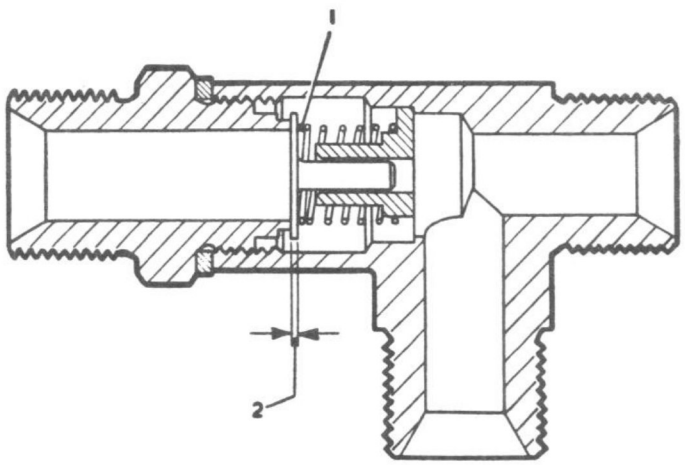

Fig. 1. Air assistance non-return valve

Schedule 14 **FUEL PUMP**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	PUMP ROTOR SHAFT Clearance—bore	0·438 / 0·4375	0·43825	0·0005 / 0·00125	0·0015	
	Shaft—dia.	0·4370 / 0·43675				
2	PISTON SPRING Fitted length	0·689 / 0·531				$3\frac{1}{2}°$ cam plate
	Fitted load	11 lb / 6 lb				
3	PISTON CLEARANCE Bore—dia.	0·3755 / 0·375	0·3757	0·000 / 0·001	0·0012	
	Piston outside—dia.	0·375 / 0·3745				
4	BALL DIA.	0·2500	0·248			

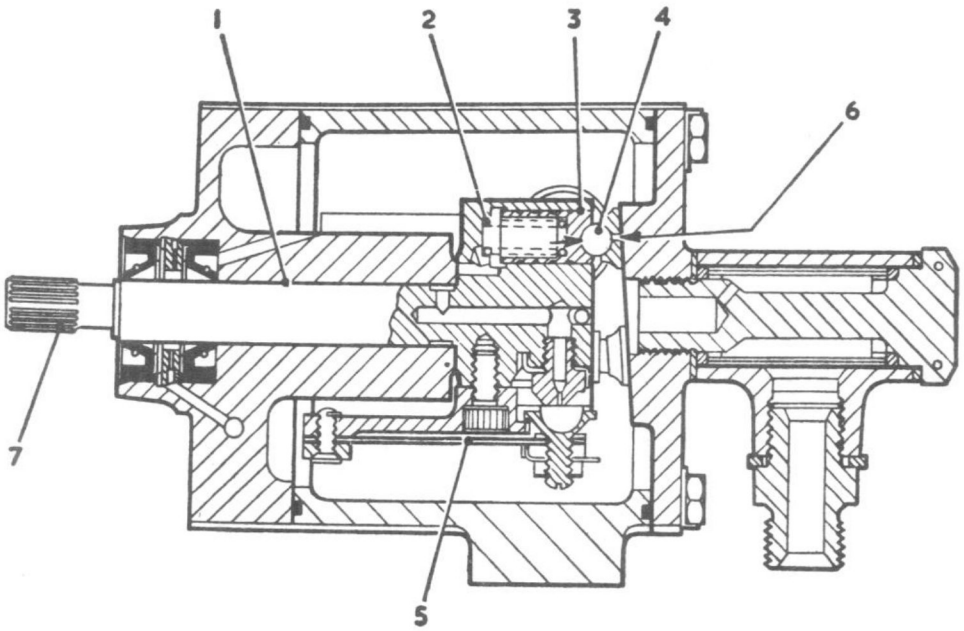

Fig. 1. Fuel pump

Schedule 14—(continued) **FUEL PUMP**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
5	GOVERNOR LEAF SPRING High speed fitted load	13.35 lb / 12·85 lb				
	Low speed fitted load	12·05 lb / 11·55 lb				
6	SLIPPER	0·291 / 0·301	0·287			Measured with 0·250 dia. ball
7	PUMP ROTOR SHAFT SERRATIONS OVER PINS	0·4274 / 0·4257	0·4227			0·0494 dia. pins

Schedule 15 — COMBUSTION CHAMBER

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	FLAME TUBE AND LOCATION SLEEVE					
	Location sleeve inner—dia.	1·254 / 1·252	1·264	0·008 / 0·002	0·020	
	Flame tube head—dia.	1·250 / 1·246	1·244			
2	BURNER SIT BACK			0·055 / 0·075		
3	FLAME TUBE SUPPORTS					
	Outer casing—bore	4·960 / 4·952		0·034 / 0·006		
	Flame tube supports—dia.	4·946 / 4·926				
4	FLAME TUBE SKIRT THICKNESS	0·036	0·027			
	VOLUTE ENTRY PANEL THICKNESS	0·036	0·020			
5	SUSPENSION PLUG					
	Location—dia.	0·590 / 0·586	0·578	0·003 / 0·011	0·022	
	Location sleeve inner—dia.	0·597 / 0·593	0·600			

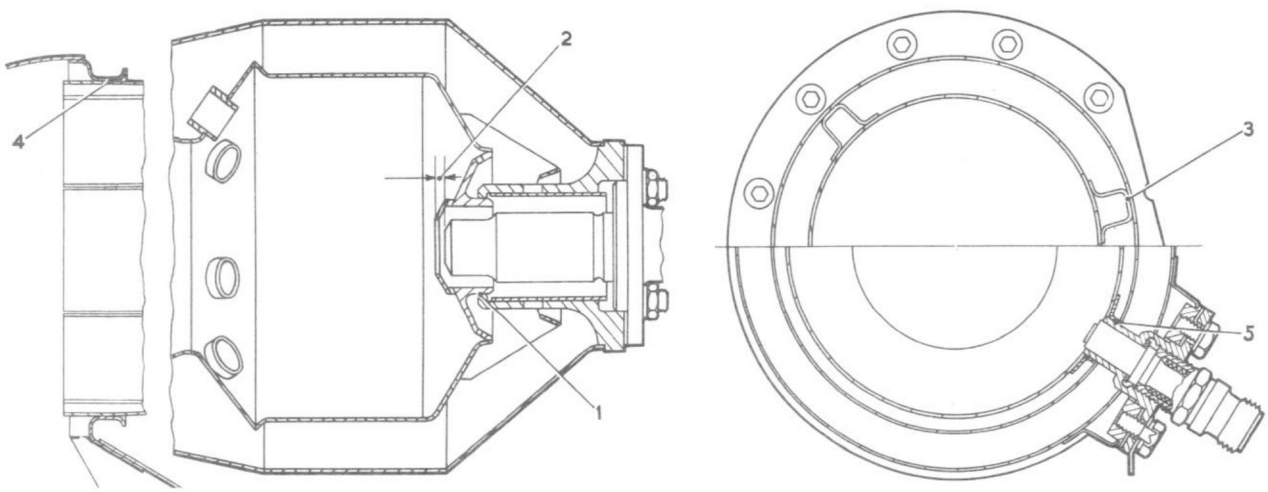

Fig. 1. Combustion chamber

Schedule 16 **BLOWER UNIT ASSEMBLY**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	ROLLER BEARING IN HOUSING					
	Housing—bore	1·3777 / 1·3772		0·0002 / —0·0008		
	Bearing—dia.	1·3780 / 1·3775				
2	ROLLER BEARING ON SHAFT					
	Bearing—bore	0·5906 / 0·5902		0·0002 / —0·0005		
	Shaft—dia.	0·5907 / 0·5904				
3	ROLLER BEARING DIAMETRAL PLAY			0·0011 / 0·0015	0·0025	3-spot bearing

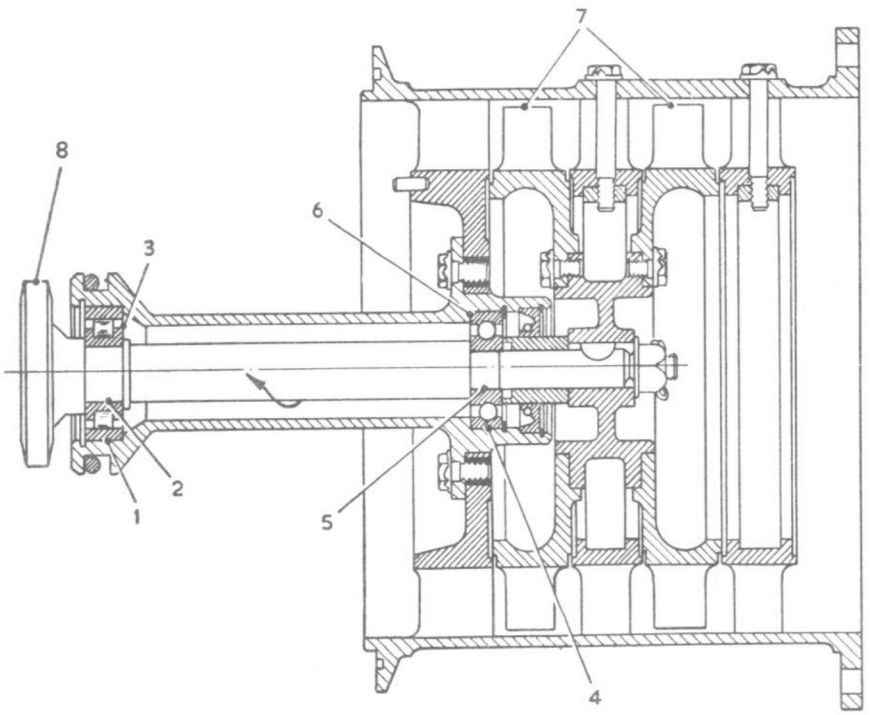

Fig. 1. Blower assembly

Schedule 16—*continued* **BLOWER UNIT ASSEMBLY**

Fig. Ref. No.	Part and Description	Dimension New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
4	BALL BEARING IN HOUSING					
	Housing—bore	1·1809 / 1·1804		0·0002 — 0·0007		
	Bearing outside—dia.	1·1811 / 1·1807				
5	BALL BEARING ON SHAFT					
	Bearing—bore	0·3937 / 0·3934		0·0002 — 0·0004		
	Shaft—dia.	0·3938 / 0·3935				
6	BALL BEARING ENDFLOAT			0·003 / 0·006	0·009	3-spot bearing.
7	IMPELLER TIP CLEARANCE					
	Housing—bore	5·4016 / 5·4000		0·036 — 0·042		Radial clearance of 0·014 to 0·025. This allows for eccentricities of 0·008 on total clock reading.
	Impeller—dia.	5.364 / 5·360				
8	DRIVE GEAR TEETH Variation from true involute profile	0·0002	0·0005			

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