

TABLE 1

Schedule of fits, clearances and repair tolerances for
 rotary inverters Type 100B and 100D
 (all dimensions in inches)

Ref. No. in fig. 1 (1)	Parts and description (2)		Design Dimension (3)		Fit (4)	Acceptable worn Dimension (5)		Fit (6)	Remarks (7)
BALLRACE IN COMMUTATOR HOUSING									
35	Commutator housing	i/d	$\frac{0.86640}{0.86590}$			0.8667		$\frac{0.0001}{0.0006}$	By selective assembly.
15	Ballrace	o/d	$\frac{0.86615}{0.86565}$		$\frac{0.0001}{0.0004}$	0.8653			Renew at each overhaul.
10 or 62	BRUSH GEAR D. C. Brush length		$\frac{0.592}{0.572}$ L. S.	-	-	-	-	-	Minimum brush length measured from top of long side to arrow head marking = 0.387. Renew at each overhaul.
67	Spring	Spring pressure	$\frac{5.3}{4.3}$ oz	-	-	-	-	-	Spring pressure is measured when top of short side of brush is level with top of brush box.
			$\frac{164}{136}$ grm						
BALLRACE IN SLIP RING HOUSING									
43	Slip ring housing	i/d	$\frac{0.86640}{0.86590}$			0.8667		$\frac{0.0001}{0.0006}$	By selective assembly.
15	Ballrace	o/d	$\frac{0.86615}{0.86565}$		$\frac{0.0001}{0.0004}$	0.8653			Renew at each overhaul.

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TABLE 1 (continued)

Ref. No. in fig. 1 (1)	Parts and description (2)		Design Dimension (3)		Fit (4)	Acceptable worn Dimension (5)		Fit (6)	Remarks (7)
19	BRUSH GEAR A. C. Spring	Spring pressure	0.750 2.000 oz 21 56 grm		-	-	-	-	With spring retaining pin just released.
63	Brush length		0.353 0.333		-	-	-	-	Minimum brush length 0.200 measured from top to arrow head marking. Renew at each overhaul.
BALLRACE ON ARMATURE SHAFT (Commutator end and slip ring end)									
15	Ballrace	i/d	0.27570 0.27520			0.2760			By selective assembly.
66	Armature shaft	o/d	0.27545 0.27495	0.0001 0.0004		0.2746		0.0001 0.0006	Renew at each overhaul.
	Slip rings	o/d	0.877 0.873			0.812			Slip rings to be inspected for score or burn marks.
	Commutator	o/d	1.380 1.375			1.312			Bar to bar lift 0.0001 max. Total commutator eccentricity not to exceed 0.0003.

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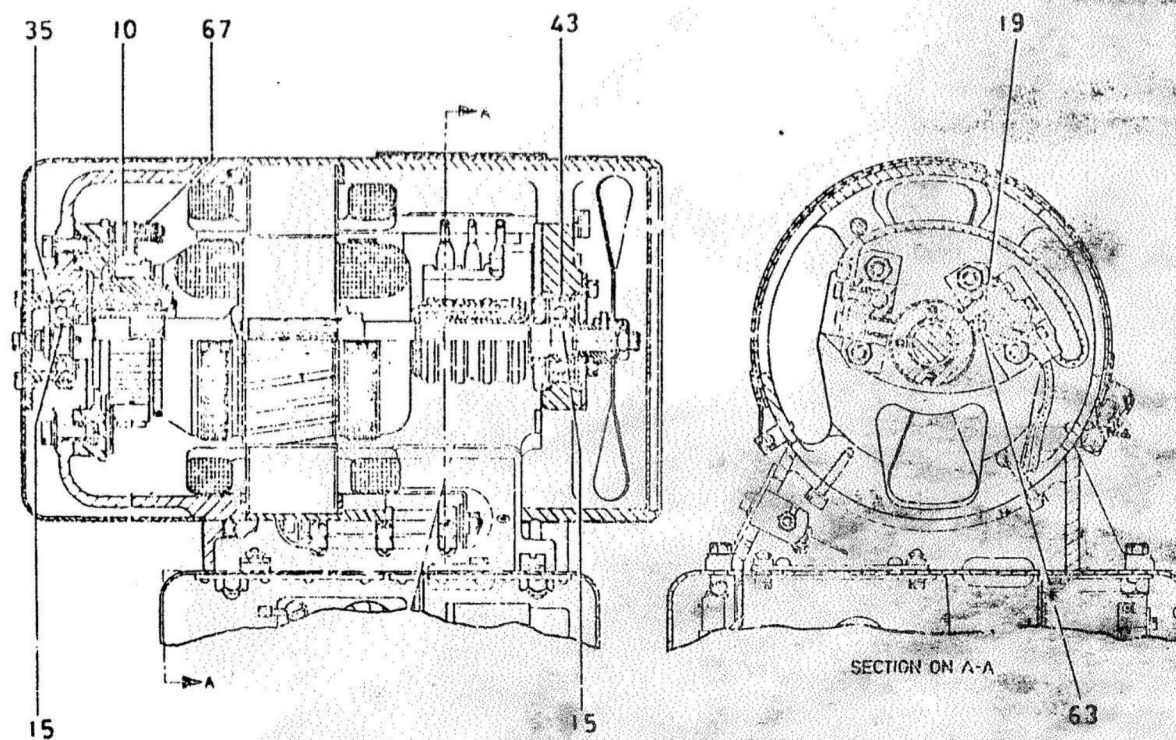


Fig.1 Diagram of fits and clearances

