SCHEDULE 2

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
1	INLET GUIDE VANE PIVOT BUSH IN FRONT BEARING HOUSING					
	Housing - bore	0.9375 0.9385	-	0.0015 0.0030	-	
	Bush - dia.	0.9355 0.9360	-			
2	INLET GUIDE VANE PIVOT IN BUSH					
	Bush - bore	0.750 0.751	0.754	0.006 0.008	0.010	Measured at the greates diameter on pivot spherical
	Pivot - dia.	0.743 0.744	0.740			
3	AXIAL CLEARANCE BETWEEN INLET GUIDE VANE REAR SUPPORT RING AND STAGE 1 ROTOR BLADE	-	-	Min. 0.128	-	Minimum check clearan on engine build. This figure is cold nipped a allowable clearance, w end float of centre bea taken up, with rotor fu forward.
4	ROTOR BLADE TIP CLEARANCES					
	Stage 1 to front of stage 10	-	-	0.060 0.090	-	This clearance is to be measured with roto blades pulled full ward to take up pin
	Rear of stage 10 to stage 15	-	-	0.065 0.095	-	clearance.
	Blades - width of flange	0.221 0.223	-	0.006	-	
6	AXIAL CLEARANCE BETWEEN REAR OF STAGE 1 ROTOR BLADE PLATFORM AND FRONT EDGE OF STAGE 1 STATOR SHROUD	-	-	0.280 0.358	-	Check clearance on engine build. This range is cold nipped allowable clearance, with end float of centre bearing taken up with rotor fully forward.

SCHEDULE 2 (*continued*)

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
7	STAGES 4 AND 5 STATOR RETAINING RINGS IN COMPRESSOR CASING					
	Casing - width of groove	0.175 0.177	-	0.003 0.007	-	
	Ring - width of flange	0.170 0.172	-			
8	STAGE 4 STATOR BLADES IN RETAINING RING					
	Ring - width of groove	0.225 0.226	-	0.002 0.005	-	
	Blade - width of flange	0.221 0.223	-			
9	STAGE 5 STATOR BLADES IN RETAINING RING					
	Ring - width of groove	0.225 0.226	-	0.001 0.004	-	
	Blade - width of flange	0.222 0.224	-			
10	STAGE 6 ROTOR BLADES IN FRONT COMPRESSOR CASING					
	Casing - width of groove	0.175 0.177	-	0.001 0.005	-	
	Blade - width of flange	0.172 0.174	-			
11	STAGES 7, 8 AND 9 STATOR BLADES IN INTERMEDIATE COMPRESSOR CASING					
	Casing - width of groove	0.150 0.152	-	0.001 0.005	-	
	Blade - width of flange	0.147 0.159	-			

SCHEDULE 2 *(continued)*

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
12	STAGE 10 STATOR FLANGED RETAINING RINGS IN COMPRESSOR OUTLET CASING					
	Casing - bore	30.906 30.909	-	0.008 0.014	-	
	Ring - dia.	30.895 30.898	-			
13	STAGES 10-14 STATORS AND O.G.V. IN RETAINING RINGS AND OUTLET CASING					
	Ring - width of groove	0.075 0.077	-	0.003 0.007	-	
	Blade - width of flange	0.070 0.072	-			
14	STAGES 10 AND 11 STATOR RETAINING RING IN OUTLET CASING					
	Casing - bore	30.756 30.759	-	0.008 0.014	-	
	Ring - dia.	30.745 30.748	-			
15	STAGES 11 AND 12 STATOR RETAINING RING IN OUTLET CASING					
	Casing - bore	30.356 30.359	-	0.008 0.014	-	
	Ring - dia.	30.345 30.348	-			
16	STAGES 12 AND 13 STATOR RETAINING RING IN OUTLET CASING					
	Casing - bore	29.956 29.959	-	0.008 0.014	-	
	Ring - dia.	29.945 29.948	-			

SCHEDULE 2 (*continued*)

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
17	STAGES 13 AND 14 STATOR RETAINING RING IN OUTLET CASING					
	Casing - bore	29.556	-			
		29.559		0.008	-	
				0.014		
	Ring - dia.	29.545	-			
		29.548				
18	STAGE 14 STATOR RETAINING RING IN OUTLET CASING					
	Casing - bore	29.156	-			
		29.159		0.008	-	
				0.014		
	Ring - dia.	29.145	-			
		29.148				
19	O.G.V. RETAINING RING IN STAGE 14 STATOR RETAINING RING					
	Stator ring - bore	28.990	-			
		28.994		0.002	-	
				0.009		
	O.g.v. ring - dia.	28.985	-			
		28.988				
20	RADIAL CLEARANCE BETWEEN O.G.V. AND STAGE 15 SEAL CARRIER	-	-	0.010	-	
				0.027		
21	STAGE 15 SEALING RING IN CARRIER					
	Carrier - bore	23.500	-			
		23.502		Tight		
				0.004	-	Mod. 1960
				0.000		
	Ring - dia.	23.502	-			
		23.504				
22	CLEARANCE ON DIAMETER BETWEEN STAGE 15 SEAL AND SEALING RING					
	Ring - bore	22.227	-			
		22.229		0.052	-	Mod. 1960
				0.056		
	Seal - dia.	22.173	-			
		22.175				

SCHEDULE 2 *(continued)*

AVON Mk. 20800 SERIES

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING.

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
23	COMPRESSOR REAR SHAFT FRONT LABYRINTH SEAL ON SHAFT.					
	Seal - bore	7.989 7.990	-	Tight 0.016	-	
	Shaft - dia.	8.004 8.005	-	0.014 Tight		
24	COMPRESSOR REAR SHAFT REAR LABYRINTH SEAL ON SHAFT					
	Seal - bore	5.250 5.251	-	Tight 0.004	-	
	Shaft - dia.	5.253 5.254	-	0.002 Tight		
25	REAR COMPRESSOR SHAFT AND WHEELCASE DRIVING PINION					
	Backlash between serrations	-	-	0.001 0.003	0.006	
26	BUSH IN WHEELCASE DRIVING PINION					
	Pinion - bore	4.8000 4.8005	-	Tight 0.002	-	
	Bush - dia.	4.8015 4.8020	-	0.001 Tight		
27.	WHEELCASE DRIVING PINION BUSH ON REAR SHAFT					
	Bush - bore	4.5000 4.5005	4.5025	0.0005 0.0015	0.003	
	Shaft - dia.	4.4990 4.4995	4.4970			

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
28	CENTRE COUPLING SCREWED BALL IN REAR SHAFT					
	Shaft - spherical bore	4.0005 4.0010	4.0020	0.0005 0.0015	0.002	
	Ball - spherical dia.	3.9995 4.0000	3.9985			
	Axial clearance	-	-	0.0010 0.0017	0.003	
29	STAGES 14-15 PIN RETAINING RING IN STAGE 15 WHEEL					
	Wheel - bore	23.500 23.505	-	0.007 0.014	-	
	Ring - dia.	23.491 23.493	-			
30	STAGES 14-15 PIN RETAINING RING IN STAGE 14 WHEEL					
	Wheel - bore	23.488 23.490	-	Tight 0.005	-	
	Ring - dia.	23.491 23.493	-	0.001 Tight		
31	STAGES 13-14 PIN RETAINING RING IN STAGE 14 WHEEL.					
	Wheel - bore	23.500 23.505	-	0.007 0.013	-	Pre-Mod. 1446
	Ring - dia.	23.492 23.493	-			
	Wheel - bore	23.4935 23.4955	-	0.0005 0.0045	-	Mod. 1446
	Ring - dia.	23.4910 23.4930	-			

SCHEDULE 2 (*continued*)

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
32	STAGE 13 - 14 PIN RETAINING RING IN STAGE 13 WHEEL					
	Wheel - bore	23.488 / 23.489	-	Tight / 0.005	-	Pre-Mod. 1446
	Ring - dia.	23.492 / 23.493	-	0.003 / Tight		
	Wheel - bore	23.488 / 23.490	-	Tight / 0.005	-	Mod. 1446
	Ring - dia.	23.491 / 23.493	-	0.001 / Tight		
33	STAGE 12-13 PIN RETAINING RING IN STAGE 13 WHEEL					
	Wheel - bore	23.4935 / 23.4945	-	0.0005 / 0.0025	-	Pre-Mod. 1446
	Ring - dia.	23.4920 / 23.4930	-			
	Wheel - bore	23.4935 / 23.4955	-	0.0005 / 0.0045	-	Mod. 1446
	Ring - dia.	23.4910 / 23.4930	-			
34	STAGE 12-13 PIN RETAINING RING IN STAGE 12 WHEEL					
	Wheel - bore	23.488 / 23.489	-	Tight / 0.005	-	Pre-Mod. 1446
	Ring - dia.	23.492 / 23.493	-	0.003 / Tight		
	Wheel - bore	23.488 / 23.490	-	Tight / 0.005	-	Mod. 1446
	Ring - dia.	23.491 / 23.493	-	0.001 / Tight		

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
35	STAGES 11-12 PIN RETAINING RING IN STAGE 12 WHEEL.					
	Wheel - bore	23.4935 / 23.4945	-	0.0005 / 0.0025	-	Pre-Mod. 1446
	Ring - dia.	23.4920 / 23.4930	-			
	Wheel - bore	23.4935 / 23.4955	-	0.0005 / 0.0045	-	Mod. 1446
	Ring - dia.	23.4910 / 23.4930	-			
36	STAGES 11-12 PIN RETAINING RING IN STAGE 11 WHEEL					
	Wheel - bore	23.488 / 23.489	-	Tight / 0.005	-	Pre-Mod. 1446
	Ring - dia.	23.492 / 23.493	-	0.003 Tight		
	Wheel - bore	23.488 / 23.490	-	Tight / 0.005	-	Mod. 1446
	Ring - dia.	23.491 / 23.493	-	0.001 Tight		
37.	STAGES 10-11 PIN RETAINING RING IN STAGE 11 WHEEL					
	Wheel - bore	23.4935 / 23.4945	-	0.0005 / 0.0025	-	Pre-Mod. 1446
	Ring - dia.	23.4920 / 23.4930	-			
	Wheel - bore	23.4935 / 23.4955	-	0.0005 / 0.0045	-	Mod. 1446
	Ring - dia.	23.4910 / 23.4930	-			

SCHEDULE 2 (*continued*)

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING.

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
38	STAGES 10-11 PIN RETAINING RING IN STAGE 10 WHEEL					
	Wheel - bore	23.488 23.489	-	Tight 0.005	-	Pre-Mod. 1446
	Ring - dia.	23.492 23.493	-	0.003 Tight		
	Wheel - bore	23.488 23.490	-	Tight 0.005	-	Mod. 1446
	Ring - dia.	23.491 23.493	-	0.001 Tight		
39	STAGES 9-10 PIN RETAINING RING IN STAGE 10 WHEEL					
	Wheel - bore	23.4935 23.4945	-	0.0005	-	Pre-Mod. 1446
	Ring - dia.	23.4920 23.4930	-	0.0025		
	Wheel - bore	23.4935 23.4955	-	0.0005	-	Mod. 1446
	Ring - dia.	23.4910 23.4930	-	0.0045		
40	STAGES 9-10 PIN RETAINING RING IN STAGE 9 WHEEL					
	Wheel - bore	23.487 23.489	-	Tight 0.006	-	Pre-Mod. 1446
	Ring - dia.	23.492 23.493	-	0.003 Tight		
	Wheel - bore	23.488 23.490	-	Tight 0.005	-	Mod. 1446
	Ring - dia.	23.491 23.493	-	0.001 Tight		

SCHEDULE 2 (*continued*)

FRONT BEARING HOUSING COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
41	STAGES 8-9 PIN RETAINING RING IN STAGE 9 WHEEL					
	Wheel - bore	23.4935	-			
		23.4955		0.0005	-	Pre-Mod. & Mod. 1446
				0.0045		
	Ring - dia.	23.4910	-			
		23.4930				
42	STAGE 8-9 PIN RETAINING RING IN STAGE 8 WHEEL					
	Wheel - bore	23.488	-	Tight		
		23.490		0.005	-	
				0.001		
	Ring - dia.	23.491	-	Tight		
		23.493				
43	STAGES 7-8 PIN RETAINING RING IN STAGE 8 WHEEL					
	Wheel - bore	23.4935	-			
		23.4955		0.0005	-	
				0.0045		
	Ring - dia.	23.4910	-			
		23.4930				
44	STAGE 7-8 PIN RETAINING RING IN STAGE 7 WHEEL					
	Wheel - bore	23.448	-	Tight		
		23.449		0.004	-	
				0.001		
	Ring - dia.	23.450	-	Tight		
		23.452				
45	STAGE 6-7 PIN RETAINING RING IN STAGE 7 WHEEL					
	Wheel - bore	23.4500	-			
		23.4510		0.0005	-	
				0.0025		
	Ring - dia.	23.4485	-			
		23.4495				
46	STAGES 6-7 PIN RETAINING RING IN STAGE 6 WHEEL					
	Wheel - bore	23.448	-	Tight		
		23.449		0.005	-	
				0.003		
	Ring - dia.	23.452	-	Tight		
		23.453				

SCHEDULE 2 *(continued)*

AVON Mk. 20800 SERIES

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING.

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
47	STAGES 5-6 SPACER IN STAGE 6 WHEEL					
	Wheel - bore	22.1250 22.1260	-	0.0005 0.0035	-	
	Spacer - dia.	22.1225 22.1245	-			
48	STAGES 5-6 SPACER IN STAGE 5 WHEEL					
	Spacer - bore	21.849 21.851	-	Tight 0.004	-	
	Wheel - dia.	21.852 21.853	-	0.001 Tight		
49	STAGES 4-5 SPACER IN STAGE 5 WHEEL					
	Wheel - bore	21.400 21.401	-	0.0005 0.0025	-	
	Spacer - dia.	21.3985 21.3995	-			
50	STAGES 4-5 SPACER IN STAGE 4 WHEEL					
	Spacer - bore	20.350 20.351	-	Tight 0.003	-	
	Wheel - dia.	20.352 20.353	-	0.001 Tight		
51	STAGES 3-4 SPACER IN STAGE 4 WHEEL					
	Wheel - bore	19.800 19.801	-	0.0005 0.0025	-	
	Spacer - dia.	19.7985 19.7995	-			
52	STAGES 3-4 SPACER IN STAGE 3 WHEEL					
	Spacer - bore	18.525 18.526	-	Tight 0.003	-	
	Wheel - dia.	18.527 18.528	-	0.001 Tight		

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
53	STAGES 2-3 SPACER IN STAGE 3 WHEEL					
	Wheel - bore	17.9000 17.9010	-	0.0005 0.0025	-	
	Spacer - dia.	17.8985 17.8995	-			
54	STAGES 2-3 SPACER IN STAGE 2 WHEEL					
	Wheel - bore	16.500 16,501	-	Tight 0.003	-	
	Spacer - dia.	16.502 16.503	-	0.001 Tight		
55	STAGES 1-2 SPACER IN STAGE 2 WHEEL					
	Wheel - bore	15.700 15.701	-	0.007 0.010	-	
	Spacer - dia.	15.691 15.693	-			
56	STAGES 1-2 SPACER IN STAGE 1 WHEEL					
	Spacer - bore	13.949 13.951	-	Tight 0.005	-	
	Wheel - dia.	13.952 13.954	-	0.001 Tight		
57	RADIAL CLEARANCE BETWEEN ACTUATING RING ROLLERS AND TRACK	-	-	0.0115 0.0145	0.016	Pre-Mod. & Mod. 2254
58	ACTUATING RING ROLLER IN ACTUATING RINGTRACK					
	Ring - width of track	0.3125 0.3135	0.3180	0.0125 0.0145	0.018	Pre-Mod. & Mod. 2254
	Roller - width	0.299 0.300	0.2945			

SCHEDULE 2 (*continued*)

FRONT BEARING HOUSING COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description.	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
59	I.G.V. OPERATING LEVER TRUNNION IN ACTUATING RING					
	Ring - bore	0.5000 0.5010	-	0.0040 0.0055	-	Pre-Mod. 2254
	Trunnion - dia.	0.4955 0.4960	-			
	Ring - bore	0.500 0.501	-	0.014 0.016	-	Mod. 2254
	Trunnion - dia.	0.485 0.486	-			
60	I.G.V. OPERATING LEVER IN TRUNNION					
	Trunnion - bore	0.2500 0.2505	0.2525	0.0025 0.0035	0.005	Pre-Mod. & Mod. 2254
	Lever - dia.	0.2470 0.2475	0.2450			
61	I.G.V. OPERATING LEVER IN SUPPORT RINGS					
	Rings - bore	0.4375 0.4385	0.4415	0.001 0.003	0.005	Measured at greatest diameter on spherical bore and diameter
	Lever - dia.	0.4355 0.4365	0.4325			
62	END FLOAT OF OPERATING LEVER IN SUPPORT RINGS	-	-	0.005 0.007	0.009	
63	BUSHES IN STAGE 1 ROTOR BLADE					
	Blade - bore	0.65620 0.65645	-	Tight 0.0033	-	
	Bush - dia.	0.65925 0.65950	-	0.0028 Tight		

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
64	STAGE 1 BLADE RETAINING PIN IN WHEEL AND BUSH					
	Wheel and bush - bore	0.5937 0.5947	-	0.0147 0.0162	-	.579 .016 .595 .060 .655
	Pin - dia.	0.5785 0.5790	-			
65	BUSH IN STAGE 2 ROTOR BLADE					
	Blade - bore	0.53120 0.53145	-	Tight 0.0027	-	
	Bush - dia.	0.53365 0.53390	-	0.0022 Tight		
66	STAGE 2 BLADE RETAINING PIN IN WHEEL AND BUSH					64126 SA #664
	Wheel and bush - bore	0.4687 0.4697	-	0.0147 0.0162	-	
	Pin - dia.	0.4535 0.4540	-			
67	BUSH IN STAGE 3 ROTOR BLADE					
	Blade - bore	0.50000 0.50025	-	Tight 0.0025	-	
	Bush - dia.	0.50225 0.50250	-	0.0020 Tight		
68	STAGE 3 BLADE RETAINING PIN IN WHEEL AND BUSH					
	Wheel and bush - bore	0.4375 0.4385	-	0.0150 0.0165	-	
	Pin - dia.	0.4220 0.4225	-			
69	BUSH IN STAGE 4 ROTOR BLADE					
	Blade - bore	0.43750 0.43775	-	Tight 0.0022	-	
	Bush - dia.	0.43945 0.43970	-	0.0017 Tight		

SCHEDULE 2 (*continued*)

AVON Mk. 20800 SERIES

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
70	STAGE 4 BLADE RETAINING PIN IN WHEEL AND BUSH					
	Wheel and bush bore	0.3750 0.3760	-	0.0150 0.0165	-	
	Pin - dia.	0.3595 0.3600	-			
71	STAGE 5 BLADE RETAINING PIN IN WHEEL AND BLADE					
	Wheel and blade - bore	0.3125 0.3135	-	0.0150 0.0165	-	
	Pin - dia.	0.2970 0.2975	-			
72	AXIAL CLEARANCE BETWEEN STAGE 6 ROTOR BLADE TRAILING EDGE AND STAGE 6 STATOR LEADING EDGE	-	-	0.2094 0.2634	-	
73	RADIAL CLEARANCE BETWEEN STATOR BLADES AND PIN RETAINING RINGS					
	Stage 6	-	-	0.065 0.080	-	
	Stage 7, 8 and 9	-	-	0.065 0.084	-	
	Stages 10-14	-	-	0.063 0.082	-	
74	BLADE RETAINING PINS IN STAGES 6 and 7 ROTOR BLADES AND WHEELS					
	Wheel and blade - bore	0.2812 0.2822	-	0.0152 0.0167	-	
	Pin - dia.	0.2655 0.2660	-			
75	AXIAL CLEARANCE BETWEEN STAGE 10 ROTOR TRAILING EDGE AND STAGE 10 STATOR LEADING EDGE	-	-	0.1944 0.2324	-	

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
76	STAGES 8, 9, 10 and 11 BLADE RETAINING PINS IN WHEELS AND BLADES					
	Wheel and blade - bore	0.4219 0.4229	-	0.0199 0.0214	-	
	Pin - dia.	0.4015 0.4020	-			
77	SETTING DISTANCE FROM FRONT FACE OF STAGE 10 STATOR FLANGED LOCATING RING TO REAR OF STAGE 15 ROTOR WHEEL OUTER FLANGE	-	-	9.784 9.794	-	This figure is given in the cold nipped condition with centre bearing end float taken up with rotor fully forward.
78	STAGES 12, 13, 14 and 15 BLADE RETAINING PINS IN WHEELS AND BLADES					
	Wheel and blade - bore	0.3750 0.3760	-	0.0050 0.0065	-	
	Pin - dia.	0.3695 0.3700	-			
79	TAPER BOLTS IN STAGE 15 WHEEL, SEAL AND REAR SHAFT					
	Clearance between head of bolt and rear face of seal.	-	-	0.020 0.050	-	Before tightening bolt.
80	STAGE 15 OUTER AIR SEALING RING IN CARRIER.					
	Carrier - bore	23.500 23.502	-	Tight 0.004 0.000	-	Pre-Mod. 1960
	Ring - dia.	23.502 23.504	-			
81	RADIAL CLEARANCE BETWEEN OUTER AIR SEALING RING AND SEAL					
	Rear	-	-	0.035 0.037	-	Pre-Mod. 1960
	Front	-	-	0.028 0.030	-	

SCHEDULE 2 (*continued*).

FRONT BEARING HOUSING COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
82	STAGE 15 INNER AIR SEALING RING IN CARRIER.					
	Carrier - bore	22.110 22.112	-	Tight 0.004	-	Pre-Mod. 1960
	Ring - dia.	22.112 22.114	-	0.000		
83	RADIAL CLEARANCE BETWEEN INNER AIR SEALING RING AND SEAL					
	Front	-	-	0.028 0.030	-	Pre-Mod. 1960
	Rear	-	-	0.034 0.036	-	
84	TAPER BOLTS IN FRONT AND REAR SHAFTS					
	Clearance between head of bolt and rear face of flange	-	-	0.020 0.050	-	Before tightening bolt.
85	TAPER BOLTS IN FRONT SHAFT AND 15th STAGE WHEEL					
	Clearance between head of bolt and rear face of flange	-	-	0.020 0.050	-	Before tightening bolt.
86	RADIAL CLEARANCE BETWEEN STAGE 4 STATOR SHROUD AND STAGES 4-5 SPACER	-	-	0.060 0.085	-	
87	RADIAL CLEARANCE BETWEEN STAGE 3 STATOR SHROUD AND STAGES 3-4 SPACER	-	-	0.060 0.085	-	
88	RADIAL CLEARANCE BETWEEN STAGE 2 STATOR SHROUD AND STAGES 2-3 SPACER	-	-	0.060 0.085	-	
89	RADIAL CLEARANCE BETWEEN STAGE 1 STATOR SHROUD AND STAGE 1-2 SPACER	-	-	0.060 0.085	-	Pre-Mod. 1605
		-	-	0.052 0.064	-	Mod. 1605

SCHEDULE 2 (*continued*)

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
90	FRONT BEARING AIR SEAL IN HOUSING					
	Housing - bore	6.8500 / 6.8510	-	Tight / 0.0010	-	Mod. 1815
	Seal - dia.	6.8505 / 6.8510	-	0.0005 Clear		
91	OIL AND AIR SEALING LAND ON STAGE 1 WHEEL					
	Land - bore	5.015 / 5.016	-	Tight / 0.002	-	
	Wheel - dia.	5.015 / 5.017	-	0.001 Clear		
92	COMPRESSOR NIP	-	-	-	-	The amount of nip load required is that sufficient to produce a movement of hub, relative to rim of stage 1 disc, of 0.016.
93	CLEARANCE ON DIAMETER BETWEEN FRONT BEARING AIR SEAL AND SEALING LAND.					
	Front end					
	Seal - bore	6.350 / 6.352	-	0.015 / 0.019	-	Mod. 1815 Conical slope between largest and smallest diameter sealing fins.
	Land - dia.	6.333 / 6.335	-			
	Rear end					
	Seal - bore	6.350 / 6.352	-	0.007 / 0.011	-	
	Land - dia.	6.341 / 6.343	-			
94	CLEARANCE ON DIAMETER BETWEEN FRONT BEARING OIL SEAL AND SEALING LAND					
	Seal - bore	5.250 / 5.251	-	0.012 / 0.014	-	
	Land - dia.	5.237 / 5.238	-			

SCHEDULE 2 (*continued*)

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
95	OIL AND AIR SEALING LAND ON FRONT COMPRESSOR SHAFT					
	Land - bore	3.7500	-			
		3.75030		Tight		
				0.00050	-	
				0.00005		
	Shaft - dia.	3.75025	-	Clear		
		3.75050				
96	FRONT BEARING AIR SEAL IN HOUSING					
	Seal nip	-	-	0.001	-	Mod. 1815
				0.003		
97	FRONT ROLLER BEARING INNER RACE ON SHAFT					
	Race - bore	3.74970	-			
		3.75020		Tight		
				0.00080	-	
				0.00005		
	Shaft - dia.	3.75025	-	Tight		
		3.75050				
98	CLEARANCE ON DIAMETER OF FRONT ROLLER BEARING IN OUTER RACE					
	Race - bore	4.8750	-			
		4.8755		0.003	0.006	Dimension over rollers.
				0.004		
	Bearing - dia.	4.8715	-			
		4.8720				
99	ROLLER BEARING OUTER RACE IN FRONT BEARING HOUSING					
	Housing - bore	5.2500	-			
		5.2505		0.000	-	
				0.001		
	Race - dia.	5.2495	-			
		5.2500				

SCHEDULE 2 (*continued*)

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
100	CLEARANCE ON DIAMETER BETWEEN FRONT BEARING AIR SEALS AND SEALING LAND					
	Front end					
	Seal - bore	6.350 6.352	-	0.015 0.019	-	Pre-Mod. 1815 Conical slope between largest and smallest diameter sealing fins.
	Land - dia.	6.333 6.335	-			
	Rear end					
	Seal - bore	6.350 6.352	-	0.007 0.011	-	
	Land - dia.	6.341 6.343	-			
101	FRONT BEARING AIR SEALS IN HOUSING					
	Nip	-	-	0.001 0.003	-	Pre-Mod. 1815
102	FRONT BEARING AIR SEALS IN HOUSING					
	Housing - bore	6.8500 6.8510	-	Tight 0.0035	-	Pre-Mod. 1815
	Seal - dia.	6.8525 6.8535	-	0.0015 Tight		
103	ACTUATING RING ROLLERS IN ACTUATING RING					
	Ring - bore	0.3125 0.3135	0.3155	0.0010 0.0025	0.004	Pre-Mod. 2254
	Roller - dia.	0.3110 0.3115	0.3085			
	Ring - bore	0.3125 0.3135	0.3155	0.0080 0.0095	0.011	Mod. 2254
	Roller - dia.	0.3040 0.3045	0.3015			

SCHEDULE 2 *(continued)*

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
104	STATOR BLADES IN COMPRESSOR CASING CIRCUMFERENTIAL GAPS MEASURED ADJACENT TO PORT AND STARBOARD SPLIT LINES.					
	Stage 1 (Pre-Mod. 1605)	-	-	0.0125 / 0.0825	-	Blades to be choc-a-bloc to port and starboard side with edge of blade platform in line with bottom of recess in plate as shown.
	(Mod. 1605.)	-	-	0.0125 / 0.0225	-	
	Stage 2	-	-	0.0125 / 0.0825	-	
	Stage 3	-	-	0.020 / 0.090	-	
105	STATOR BLADES IN COMPRESSOR CASING, CIRCUMFERENTIAL GAPS MEASURED ADJACENT TO PORT AND STARBOARD SPLIT LINES					
	Stage 4	-	-	0.020 / 0.090	-	Blades to be choc-a-block to port and starboard split lines as shown.
106	STATOR BLADES IN COMPRESSOR CASING, CIRCUMFERENTIAL GAPS MEASURED ADJACENT TO PORT AND STARBOARD SPLIT LINES.					
	Stage 5	-	-	0.025 / 0.095	-	Pre-Mod. 1234 — Blades to be choc-a-bloc to port and starboard split lines as shown
		-	-	0.0125 / 0.0225	-	Mod. 1234 — Blades to be choc-a-bloc to port and starboard split lines as shown

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
107	STATOR BLADES IN COMPRESSOR CASING, CIRCUMFERENTIAL GAP MEASURED ADJACENT TO PORT AND STARBOARD SPLIT LINES.					
	Stage 6	-	-	0.025 / 0.095	-	Pre-Mod. 1234
		-	-	0.0125 / 0.0225	-	Mod. 1234
	Stage 7	-	-	0.045 / 0.115	-	Pre-Mod. 1234
		-	-	0.0125 / 0.0225	-	Mod. 1234
						Blades to be choc-a-bloc to port and starboard split lines as shown.
108	STATOR BLADES IN COMPRESSOR CASINGS, CIRCUMFERENTIAL GAP MEASURED ADJACENT TO PORT SPLIT LINE					
	Stage 8	-	-	0.050 / 0.120	-	Pre-Mod. 1234.
		-	-	0.0125 / 0.0225	-	Mod. 1234
	Stage 9	-	-	0.055 / 0.125	-	Pre-Mod. 1234.
		-	-	0.0125 / 0.0225	-	Mod. 1234
						Blades to be choc-a-bloc to starboard split line as shown.
109	STATOR BLADES IN COMPRESSOR CASINGS, CIRCUMFERENTIAL GAP MEASURED ADJACENT TO STARBOARD SPLIT LINE					
	Stage 8	-	-	0.092 / 0.162	-	Pre-Mod. 1234
		-	-	0.0125 / 0.0225	-	Mod. 1234
	Stage 9	-	-	0.091 / 0.061	-	Pre-Mod. 1234
		-	-	0.0125 / 0.0225	-	Mod. 1234
						Blades to be choc-a-bloc to port split line as shown.

SCHEDULE 2 *(continued)*

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
110	STATOR BLADES AND OUTLET GUIDE VANES IN COMPRESSOR OUTLET CASING, QUARTER STAGE BLADE CIRCUMFERENTIAL CLEARANCE					
	Stage 10-14 and o.g.v.	-	-	0.025	-	Pre-Mod. 1234 With blades assembled in the retaining rings and the blades of the quarter stage and also the preceding location blade held choc-a-bloc against the blade stop slots in direction indicated, the quarter stage blade clearance is the measured dimension shown.
		-	-	0.0125 / 0.0225	-	Mod. 1234
111	OPERATING LEVERS IN OPERATING INLET GUIDE VANES.					
	Backlash between serrations.	-	-	0.0009 / 0.0030	0.006	
112	OPERATING LEVERS IN BEARING SLEEVE					
	Sleeve - bore	0.502 / 0.504	0.508	0.004 / 0.007	0.010	
	Lever - dia.	0.497 / 0.498	0.492			
113	OPERATING LEVERS IN BALL BEARING					
	Bearing - bore	0.49980 / 0.50020	-	Tight / 0.00020	-	
	Lever - dia.	0.49975 / 0.50000	-	0.00045 Clear		

SCHEDULE 2 (*continued*)

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
114	BALL BEARING IN BEARING SLEEVE					
	Sleeve - bore	1.3125 1.3130	-			
				0.0003 0.0013	-	
	Bearing - dia.	1.3117 1.3122	-			
115	BALL BEARING					
	End float between inner and outer races.	-	-	0.0055	-	
116	BEARING SLEEVE IN CONTROL HOUSING					
	Housing - bore	1.4250 1.4255	-			
				0.000 0.001	-	
	Sleeve - dia.	1.4245 1.4250	-			
171	CONTROL SHAFT SEALING RINGS IN OPERATING LEVER GROOVES					
	Groove - width	0.040 0.041	0.045			
				0.001 0.003	0.006	
	Ring - width	0.038 0.039	0.034			
118	CONTROL SHAFT SEALING RINGS ON OPERATING LEVER					
	Ring gap	-	-	0.001 0.005	-	Measured in a 0.502 diameter gauge
119	SPHERICAL BUSHES IN CONNECTING LINK					
	Link - bore	0.5625 0.5630	0.5655			
				0.001 0.002	0.004	
	Bush - dia.	0.5610 0.5615	0.5585			

SCHEDULE 2 *(continued)*

FRONT BEARING HOUSING, COMPRESSOR SHAFTS, ROTORS AND OUTLET CASING

AVON Mk. 20800 SERIES

Ref. No. on Diagram	Parts and Description	Dimensions New	Permissible Worn Dimension	Clearance New	Permissible Worn Clearance	Remarks
120	CONTROL LEVER SCREWS IN SPHERICAL BUSHES					
	Bush - bore	0.2969 / 0.2974	0.2994	0.0005 / 0.0015	0.003	
	Screw - dia.	0.2959 / 0.2964	0.2939			
121	CONTROL LEVER SCREWS IN OPERATING LEVERS					
	Lever - bore	0.2969 / 0.2974	-	0.0005 / 0.0015	-	
	Screw - dia.	0.2959 / 0.2964	-			
122	ROTOR BLADES IN ROTOR WHEELS, CLEARANCE BETWEEN BLADE FLANKS					
	Stages 1 to 5	-	-	Min. 0.033	-	This flank clearance is to be checked by inserting a feeler guage in the space between adjacent blade platforms. Size of feeler is to give the minimum figure for each stage as quoted. It is important that the feeler should enter until its end contacts the wheel diameter beneath the blades. Only one feeler should be inserted at a time. While the flank clearance is being checked the blades are not to be under any restraint other than that imposed by the retaining pins.
	Stages 6 and 7	-	-	Min. 0.032	-	
	Stage 8 (Pre-Mod. and Mod. 1446)	-	-	Min. 0.043	-	
	Stages 9 - 11 (Pre-Mod. 1446)	-	-	Min. 0.043	-	
	Mod. 1446	-	-	Min. 0.015	-	
	Stages 12 to 15	-	-	Min. 0.015	-	
123	ROTOR BLADES IN ROTOR WHEELS, BLADE TIP ROCK					The blades should be free to rock about the pin axis through an angle of 4° minimum each side of blade radial centre line, when the blade is in the running position, i. e. pulled outwards to limit of pin clearance.

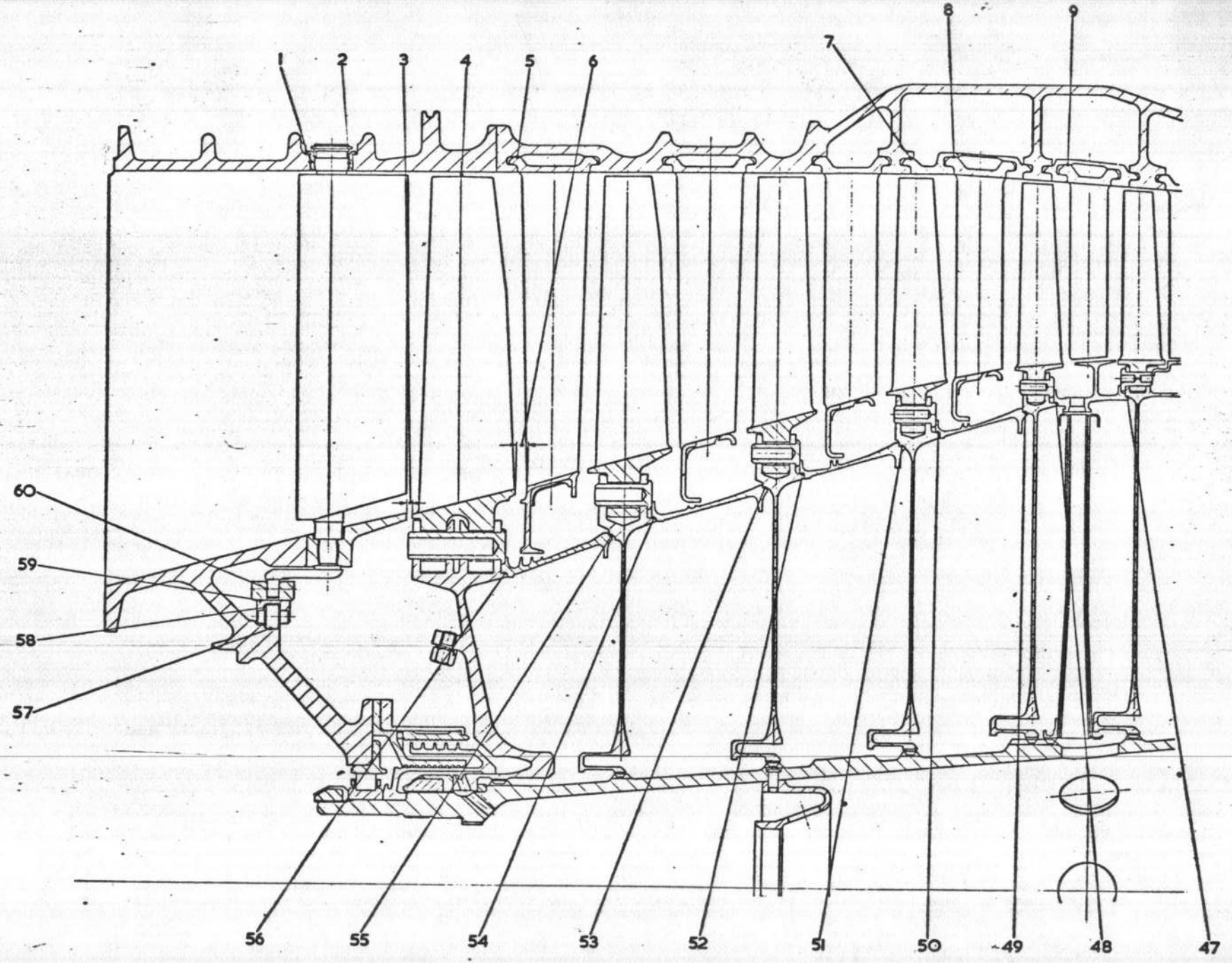


Fig. 1 Front bearing housing, compressor shafts, rotors and outlet casing

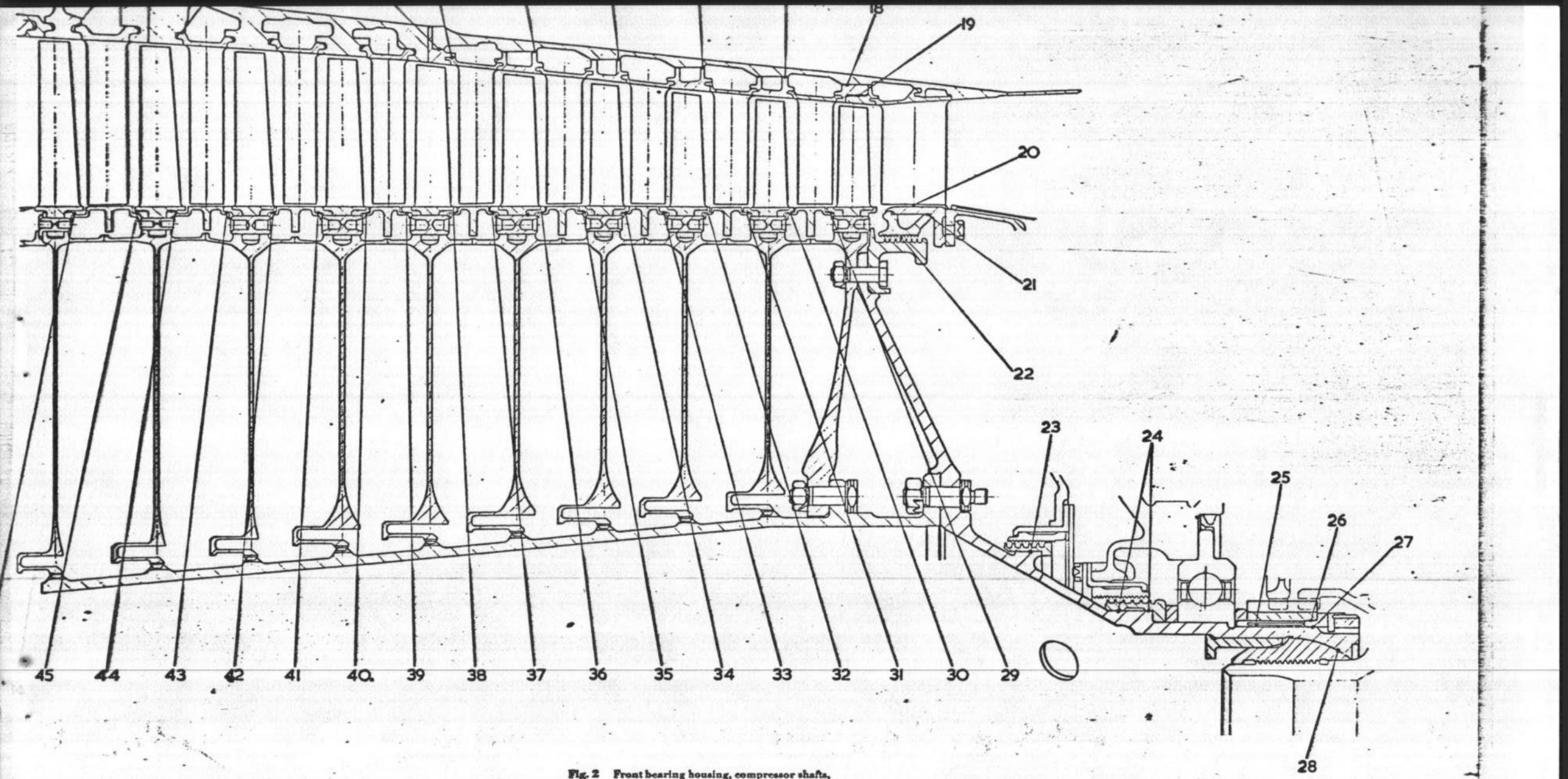


Fig. 2 Front bearing housing, compressor shafts, rotors and outlet casing

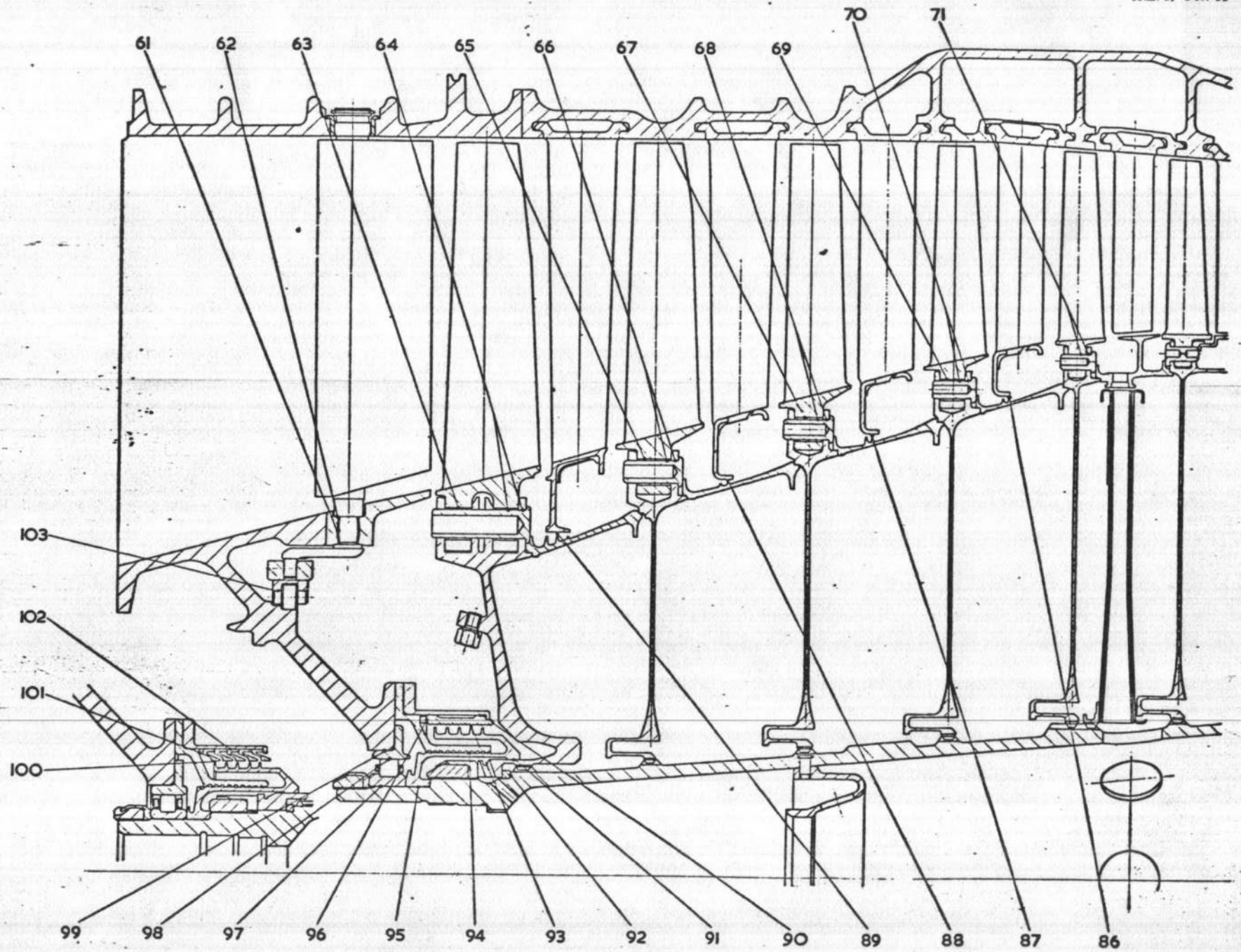


Fig. 3 Front bearing housing, compressor shafts, rotors and outlet casing

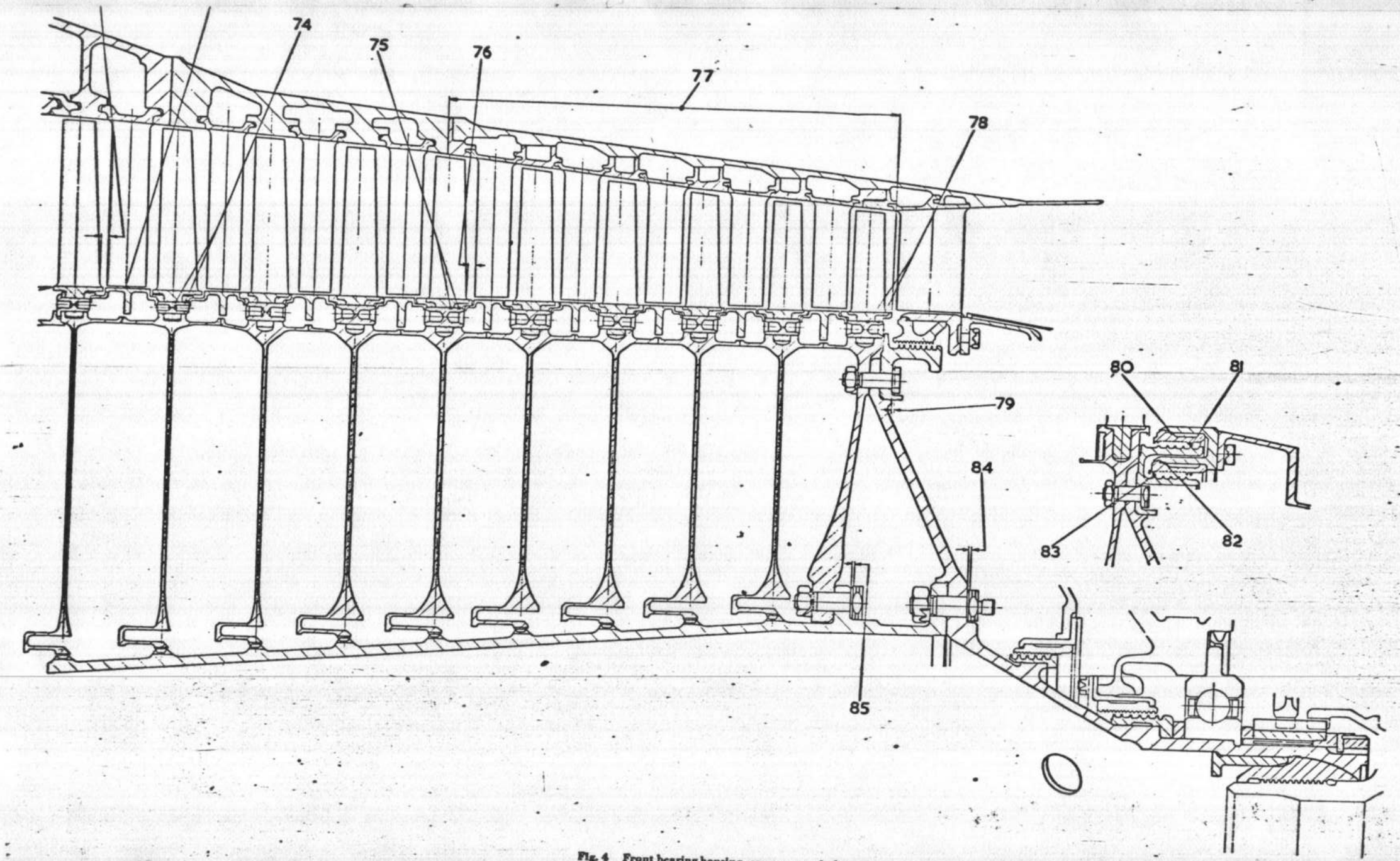
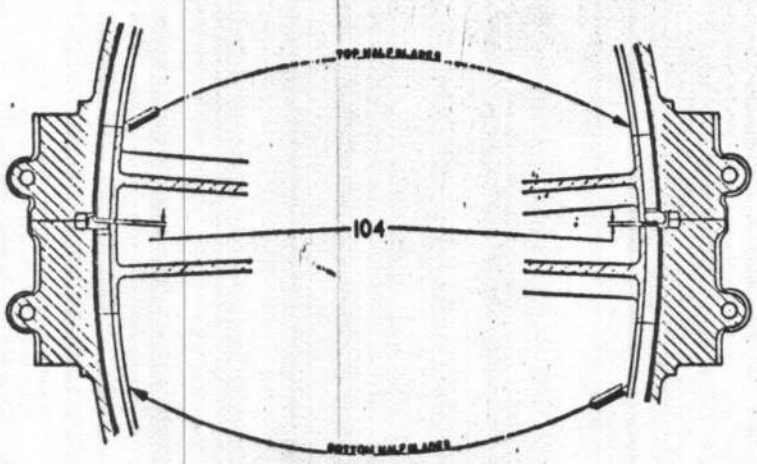
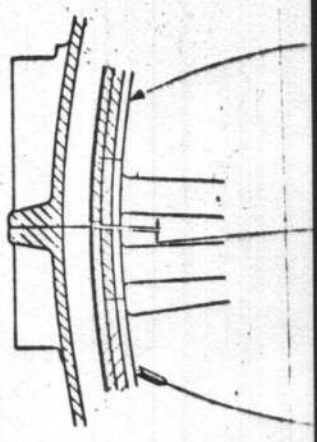
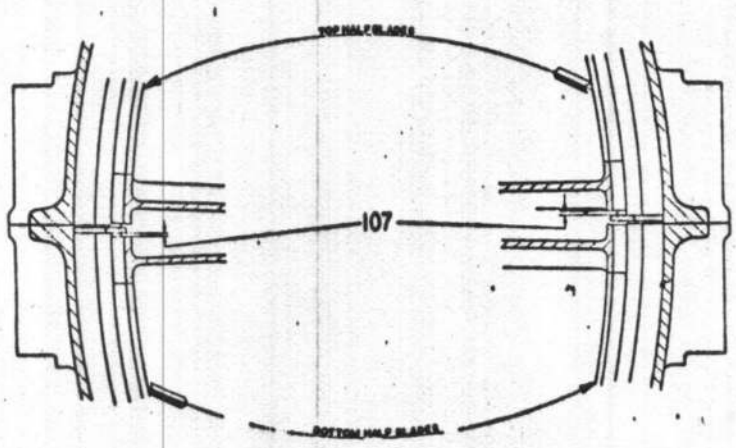
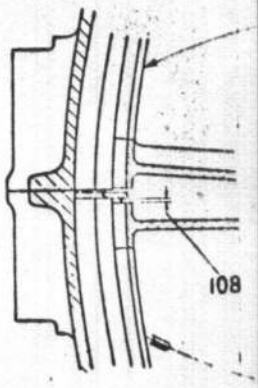


Fig. 4 Front bearing housing, compressor shafts, rotors and outlet casing


TOP HALF BLADES
104
BOTTOM HALF BLADES




TOP HALF BLADES
107
BOTTOM HALF BLADES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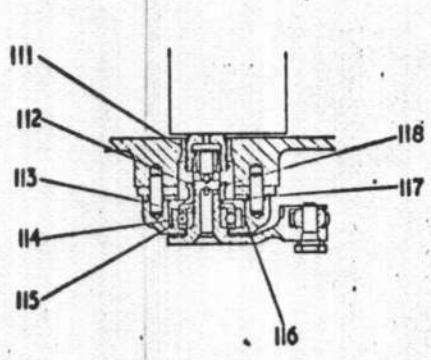
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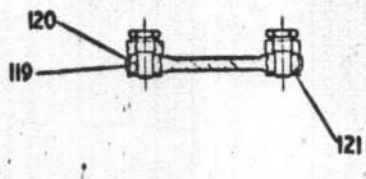
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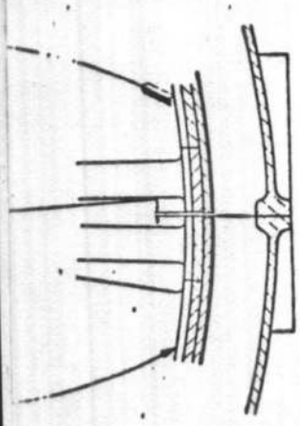
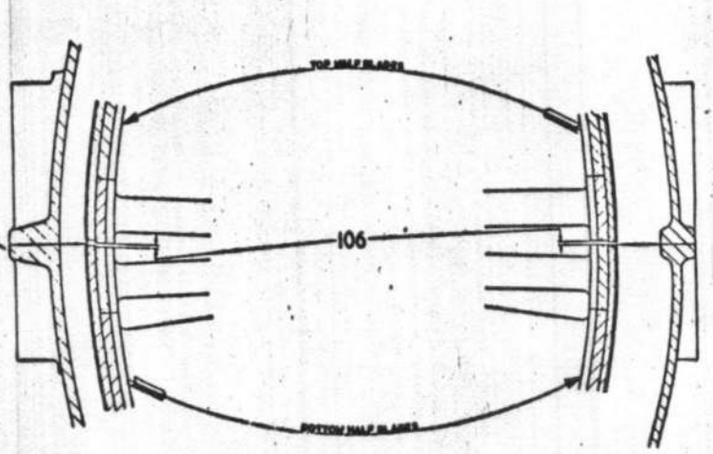
Fig. 5 Front

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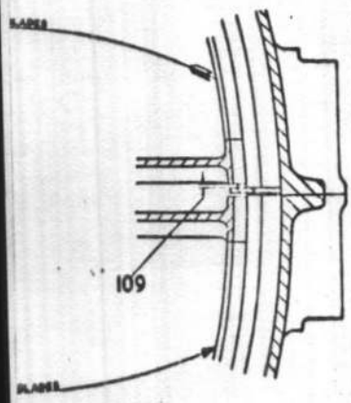
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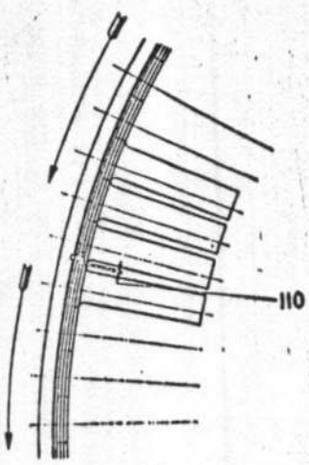
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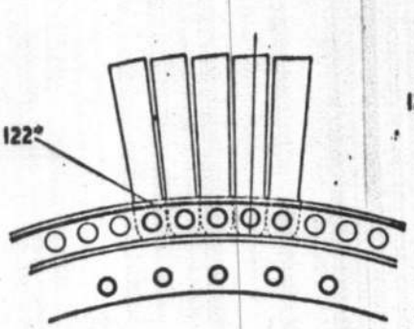
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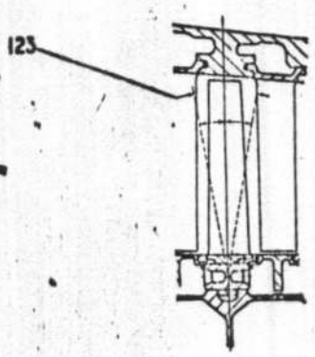
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