

I. PURPOSE:

- A. This specification covers the detail requirements for the preparation of Tables of Limits and Limits and Lubrication Charts for Aircraft Engines.
- B. Use: The Tables of Limits and Limits and Lubrication Charts covered in this specification are to be used in connection with maintenance, service, and repair of aeronautical engines.

II. SCOPE: This specification covers the requirements for the preparation of Tables of Limits and Limits and Lubrication Charts in published form.

III. GENERAL REQUIREMENTS:

- A. Units of Measurement which are used throughout the Tables shall conform to SAE standards.
- B. Revisions shall be effected either by the production of later editions or through the use of revised pages.

IV. DETAIL REQUIREMENTS:

A. Format

1. Lubrication Charts shall be 20" by 30" (the 30" dimension being vertical).
 - a. Reduced size charts, 8-1/2" x 11" for single pages and 11" x 15" for fold-over pages, may be included as a part of the Tables of Limits.
2. Size: Tables of Limits shall be printed on 8-1/2" x 11" pages with margins adjusted to accommodate the type binder to be used.
 - a. The first page of each table shall be numbered "1" (arabic numerals), and the numbers carried straight through to the last page of the Table.
3. Type Size: The type size appearing in the Tables of Limits shall not be smaller than approximately eight point.
4. Each page shall have a running head indicating models covered and may also show the chart numbers.
5. Major Divisions of the Tables of Limits:
 - a. Title Page: The title page shall include the title, engine models covered, date of publication, and the engine manufacturer's name (and seal if desired), and address.

- b. Introduction: The introduction shall consist of comprehensive introductory matter as determined by the engine manufacturer, including an explanation of all unusual terms and abbreviations employed in the publication, such as "T" and "L". If drawing numbers are referred to in the Tables of Limits, a paragraph substantially as follows shall be included:

"The drawing numbers are provided as a guide only, and where it is desired to know the actual part number, reference shall be made to the Parts Catalog."

- c. Section I: This section shall comprise the principal Tables of Limits (clearances, fits, etc.). These shall be arranged in groups according to engine models in as economical form as possible. In Tables of Limits covering large engines, it shall be permissible to arrange clearances by sections of the engine (reduction gear section, power section, etc.). This section shall contain all pertinent fits and clearances applicable to the engine being covered in the tables.

Each Table of Limits shall list, with reference numbers in numerical order, the information shown in Fig. 1, Example A or B.

- d. Section II: This section shall be entitled "Miscellaneous" and shall include such items as spring pressures; i.e., minimum (or replacement) load in pounds with spring compressed to a specified height. Wire gage or wire diameter may also be included if desired.

This section shall also contain tightening torque limits for pertinent studs, bolts, nuts, screws, cap screws, spark plugs, etc. Torque limits shall be stated in inch pounds or in the case of highly stretched parts, by actual stretch in engines. It will be assumed that an anti-seize compound will be used wherever applicable.

- e. Section III: This section shall be optional and when used shall contain reduced size charts as described in paragraph IV, Ala of this specification.

B. Charts:

1. Full size charts as described in paragraph IV, A2 of this specification shall show clearly all points of limits appearing in the Tables of Limits (including spring loading and specific torque tightening limits). Where several limits occur near one point on a chart, one arrow to the part may be used with an appropriate tabulation in the Table of Limits. Charts shall be cross-sectional and show the entire engine exclusive of accessories.
2. Charts shall bear an appropriate title, chart number and list of engine models shown.
3. Charts shall not show limits, but only reference numbers as given in the Tables of Limits with arrows to the points of clearance.
4. Charts shall illustrate the lubrication system of the engine.
 - a. Pressure oil shall be distinguished from return oil by the use of colors, such as red for pressure oil, and green for return oil. Additional colors may be used if necessary.
 - b. Each chart shall include a legend explaining all colors used.