

MAINTENANCE MANUAL
 FOR THE
 LORD LM-827 DYNAFOCAL
 SUSPENSION SYSTEMS FOR THE
 AIRESEARCH TPE331-301 and TPE331-3-303
 TURBOPROP ENGINES

- Parts Lists
- Maintenance Instructions

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REVISION		BY	DATE	PAGE
A	Added LM-827E	MWM	1/27/70	All

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 ERIE, PENNSYLVANIA

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LORD MANUFACTURING COMPANY
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 PARTS LIST
 FOR
 LM-827A DYNAFOCAL SUSPENSION
 FOR
 AIRESEARCH TPE 331-301 ENGINE

SHEET 1 OF 1
 DATE 5/17/68 ARH.

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO REQ'D PER SUB-ASSEMBLY</u>	<u>NO REQ'D PER ENGINE</u>
LM-827-SA1	FRONT MOUNTING ASSEMBLY		3
LM-827-SA3	REAR MOUNTING ASSEMBLY		1

ONE LM-827-SA1 CONSISTS OF:

LM-827-1	HOUSING	1	3
LM-827-2	BRACKET	1	3
LM-827-3	WASHER	4	12
LM-821-6	BOLT	4	12
LM-827-5	WASHER C'SUNK	1	3
LM-827-6	SPACER	2	6
LM-827-7	WASHER	1	3
LM-827-8	NUT	1	3
LM-827-9	COTTER PIN	1	3
LM-827-10	SANDWICH MOUNTING	3	9
LM-827-11	SPACER	3	9
LM-827-12	PLATE	1	3
LM-827-13	RETAINING PIN	1	3
LM-827-14	LOCKWIRE	2	6
LM-827-18	GASKET	1	3

ONE LM-827-SA3 CONSISTS OF:

LM-827-16	HOUSING ASSEMBLY	1	1
LM-827-19	INNER MEMBER, BONDED	1	1
LM-827-20	BOLT	4	4
LM-827-21	WASHER	4	4
LM-827-14	LOCKWIRE	2	2
LM-827-22	COVER ASSEMBLY	1	1
LM-827-23	BRACKET	1	1
LM-827-24	WASHER	1	1
LM-827-25	NUT, SELF LOCKING	1	1

REVISIONS:

A. IN LM-827-SA1 P/N LM-821-6 WAS LM-827-4. *ARH, 7/25/60*

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PARTS LIST
FOR
LM-827C DYNAFOCAL SUSPENSION
FOR
AIRESEARCH TPE 331-3-303 ENGINE

SHEET 1 OF 1
DATE 11/26/68 ACH

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO. REQ'D PER SUB-ASSEMBLY</u>	<u>NO REQ'D PER ENGINE</u>
LM-827-SA1	FRONT MOUNTING ASSEMBLY		3
LM-827-SA3	REAR MOUNTING ASSEMBLY		1

ONE LM-827-SA1 CONSISTS OF:

LM-827-1	HOUSING	1	3
LM-827-2	BRACKET	1	3
LM-827-3	WASHER	4	12
LM-821-6	BOLT	4	12
LM-827-5	WASHER C'SUNK	1	3
LM-827-6	SPACER	2	6
LM-827-7	WASHER	1	3
LM-827-8	NUT	1	3
LM-827-9	COTTER PIN	1	3
LM-827-10	SANDWICH MOUNTING	3	9
LM-827-11	SPACER	3	9
LM-827-12	PLATE	1	3
LM-827-13	RETAINING PIN	1	3
LM-827-14	LOCKWIRE	2	6
LM-827-18	GASKET	1	3

ONE LM-827-SA3 CONSISTS OF:

LM-827-16	HOUSING ASSEMBLY	1	1
LM-827-19	INNER MEMBER, BONDED	1	1
LM-827-20	BOLT	4	4
LM-827-21	WASHER	4	4
LM-827-14	LOCKWIRE	2	2
LM-827-22	COVER ASSEMBLY	1	1
LM-827-23	BRACKET	1	1
LM-827-24	WASHER	1	1
LM-827-25	NUT, SELF-LOCKING	1	1

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SHEET 1 OF 1
 DATE 12/29/63 *AKW.*

PARTS LIST
 FOR
 LM-827D DYNAFOCAL SUSPENSION
 FOR
 AIRESEARCH TPE 331-3-303 ENGINE

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO. REQ'D PER SUB-ASSEMBLY</u>	<u>NO. REQ'D PER ENGINE</u>
LM-827-SA1	FRONT MOUNTING ASSEMBLY		2
LM-827-SA2	FRONT MOUNTING ASSEMBLY		1

ONE LM-827-SA1 CONSISTS OF:

LM-827-1	HOUSING	1	2
LM-827-2	BRACKET	1	2
LM-827-3	WASHER	4	8
LM-821-6	BOLT	4	8
LM-827-5	WASHER C'SUNK	1	2
LM-827-6	SPACER	2	4
LM-827-7	WASHER	1	2
LM-827-8	NUT	1	2
LM-827-9	COTTER PIN	1	2
LM-827-10	SANDWICH MOUNTING	3	6
LM-827-11	SPACER	3	6
LM-827-12	PLATE	1	2
LM-827-13	RETAINING RING	1	2
LM-827-14	LOCKWIRE	2	4
LM-827-18	GASKET	1	2

ONE LM-827-SA2 CONSISTS OF:

LM-827-15	HOUSING	1	1
LM-827-2	BRACKET	1	1
LM-827-3	WASHER	4	4
LM-821-6	BOLT	4	4
LM-827-5	WASHER C'SUNK	1	1
LM-827-6	SPACER	2	2
LM-827-7	WASHER	1	1
LM-827-8	NUT	1	1
LM-827-9	COTTER PIN	1	1
LM-827-10	SANDWICH MOUNTING	3	3
LM-827-11	SPACER	3	3
LM-827-12	PLATE	1	1
LM-827-13	RETAINING RING	1	1
LM-827-14	LOCKWIRE	2	2
LM-827-18	GASKET	1	1

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PARTS LIST
FOR
LM-827E DYNAFOCAL SUSPENSION
FOR
AIRESEARCH TPE 331-3-303 ENGINE

SHEET 1 OF 1

DATE: 11-20-67 *HE*

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>NO. REQ'D PER SUB-ASSEMBLY</u>	<u>NO. REQ'D PER ENGINE</u>
LM-827-SA7	FRONT MOUNTING ASSEMBLY		2
LM-827-SA2	FRONT MOUNTING ASSEMBLY		1
<u>ONE LM-827-SA7 CONSISTS OF:</u>			
LM-827-35	HOUSING	1	2
LM-827-2	BRACKET	1	2
LM-827-3	WASHER	4	8
LM-821-6	BOLT	4	8
LM-827-5	WASHER C'SUNK	1	2
LM-827-6	SPACER	2	4
LM-827-7	WASHER	1	2
LM-827-8	NUT	1	2
LM-827-9	COTTER PIN	1	2
LM-827-10	SANDWICH MOUNTING	3	6
LM-827-11	SPACER	3	6
LM-827-12	PLATE	1	2
LM-827-13	RETAINING RING	1	2
LM-827-14	LOCKWIRE	2	4
LM-827-18	GASKET	1	2

ONE LM-827-SA2 CONSISTS OF:

LM-827-15	HOUSING	1	1
LM-827-2	BRACKET	1	1
LM-827-3	WASHER	4	4
LM-821-6	BOLT	4	4
LM-827-5	WASHER C'SUNK	1	1
LM-827-6	SPACER	2	2
LM-827-7	WASHER	1	1
LM-827-8	NUT	1	1
LM-827-9	COTTER PIN	1	1
LM-827-10	SANDWICH MOUNTING	3	3
LM-827-11	SPACER	3	3
LM-827-12	PLATE	1	1
LM-827-13	RETAINING RING	1	1
LM-827-14	LOCKWIRE	2	2
LM-827-18	GASKET	1	1

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I. DESCRIPTION

The Lord Dynafocal[®] Mounting Assemblies for use with the AiResearch TPE331-301 and TPE331-3-303 turboprop engines (840 shp) have been designated the LM-827 Series parts. Several, slightly different, suspension systems are in service, as follows:

<u>Lord P/N for</u> <u>Eng. Suspension</u> <u>System</u>	<u>Consists of</u> <u>these</u> <u>Assemblies</u>	<u>Quantity</u> <u>per</u> <u>Engine</u>	<u>Engine</u> <u>Used</u> <u>On</u>
LM-827A	LM-827-SA1 side & top front	3	-301
	LM-827-SA3 top rear	1	
LM-827C	LM-827-SA1 side & bottom front	3	-3-303
	LM-827-SA3 bottom rear	1	
LM-827D	LM-827-SA1 side front	2	-3-303
	LM-827-SA2 bottom front	1	
LM-827E	LM-827-SA7 side front	2	-3-303
	LM-827-SA2 bottom front	1	

See Figures 1-4 in the Appendix for reduced prints of these suspension systems; Figures 5-8 in the Appendix are reduced prints of the individual assembly drawings.

II. INSPECTION OF MOUNTINGS AS INSTALLED AND SUPPORTING
THE ENGINE WEIGHT

The following visual inspection should be performed after approximately every 500 hours of service:

- A. Check metal parts visually for cracks or damage which imply failure and replace, if necessary.

Caution: At any inspection period when cleaning the engine, protect mountings from contamination with cleaning fluids and solvents. Wipe all excess cleaning fluid from the mountings. During engine maintenance protect the mountings from excessive oil exposure.

III. MOUNTING DISASSEMBLY

The individual mounting assemblies should be removed from the engine, disassembled and the component parts inspected per section V during each engine overhaul.

- A. LM-827-SA1, LM-827-SA2, and LM-827-SA7 Front Mounting Assemblies (see Figures 5, 6, and 8)

Note: In the following instructions, bracketed numbers refer to item numbers of Lord Manufacturing Company drawing numbers LM-827-SA1, -SA2, -SA3 or -SA7 as applicable (see Figures 5-8).

1. Grip flat side of engine bracket (3) in padded vise, then remove cotter pin (10), nut (9) and washer (8) from threaded end of engine bracket.
2. Slide housing (2) with mountings installed off of engine bracket.
3. Remove bolts (5), washers (4), gasket (16), and washer (6) from engine bracket (3).
4. Apply approximately 600 lbs. load to plate (13) using an arbor press and loading through a 2-1/4 inch diameter cylinder. With this load held, use commercially available retaining ring pliers (ex. Waldes No. 5 with 90° tips) to remove ring (14). Release load gradually.

5. Remove plate (13) sandwich mountings (11), outer spacers (12), and inner spacers (7) from housing (2).
 6. Spread split outer spacers (12) to disengage them from sandwich mountings (11).
- B. LM-827-SA3 Rear Mounting Assembly (see Figure 6)
1. Remove bolts (4) and washers (5).
 2. Remove bonded inner member (3), with bracket (8) and cover assembly (7) attached from housing assembly (2).
 3. Remove nut (10); washer (9), bracket (8) and cover assembly (7) are now loose and can be removed.

IV. CLEANING

- A. Wipe oil and dirt from bonded rubber parts using a clean, dry cloth. Wash unbonded metal parts in dry cleaning solvent, Federal Specification Number P-S-661 or equivalent.

Caution: Do not use cleaning solvent on bonded rubber parts.

V. INSPECTION, REPAIR OR REPLACEMENT

- A. Individual component parts should be inspected as indicated in the following table and replaced if necessary:

<u>Parts</u>	<u>Inspect for</u>
Unbonded Metal Parts	In general, all unbonded metal parts should be checked for: Cracks, with Magnaglo or Zyglo, as applicable, and replace if evident. Excessive scratches or nicks and replace if evident. Wear of cadmium plating on steel parts and replate if necessary per QQ-P-416 (a) or equivalent to .0005/.0003 thickness.

Parts

Inspect For

The following is a list of additional procedures and special precautions to be taken in inspecting individual components:

LM-827-10
Bonded Sandwich Mounting

Metal-to-rubber bond separation and replace if separation is greater than .10 in. deep.

Permanent shear set and replace if "A" dimension on Figure 7 is less than 0.41 in.

LM-827-1, -15 and -35

Cracks with Zyglo and replace if evident.

Excessive nicks, scratches and gouges especially in flange fillet radii or snap ring groove and replace if evident (minor scratches or nicks, max. of .03 in. deep, may be blended in and the part reanodized per spec. MIL-A-8625A, Type 1).

Excessive galling on wear in .313/.312 dia. holes in flange and replace if greater than .315.

LM-827-2 bracket

Cracks with Magnaflux and replace if evident (check .05 fillet radius area at root of stem closely).

Wear on 1.498/1.496 pilot diameter and replace if less than 1.493.

Wear on .563/.558 stem diameter and replace if less than .555.

Galling or wear of 7/16-20 UNF-3A threads and replace if not a class 3 fit.

LM-827-13
Snap Ring

Cracks with Magnaflux and replace if evident.

Excessive distortion and replace.

Parts	Inspect For
LM-827-12 Plate	Cracks with Magnaflux and replace if evident. Distortion and replace if washer is more than .020 in. out of flat
LM-827-11 and -6 Spacers	Excessive galling or distortion and replace if evident.
LM-827-16 Housing Assembly	Cracks with Magnaflux and replace if evident. Wear in .377/.375 diameter holes and replace if greater than .379. Damage to .190-32UNF-3B threads and replace if not a class 3 fit. Excessive nicks, scratches or gouges and replace if evident (minor scratches may be blended in.) Excessively damaged or missing Spauldite washers and replace with new washers (flat washer P/N LM-827-26 is to be affixed to the bottom face of the pocket and circular washer P/N LM-827-27 to the wall).
LM-827-19 Bonded Inner Member	Metal-to-rubber bond separation or flex cracks and replace if greater than .20 in. deep. Excessive compression set and replace if thickness is less than 1.11 in. (see Figure8).
LM-827-23 Bracket	Cracks with Magnaflux and replace if evident. Wear in .377/.375 diameter holes and replace if greater than .379.

<u>Parts</u>	<u>Inspect For</u>
LM-827-23 Bracket (cont.)	Damage to .312-24UNF-3A thread and replace if not a class 3 fit. Excessive nicks or gouges and replace if evident.
LM-827-22 Cover Assembly	Cracks with Magnaflux and replace if evident. Excessive distortion and replace if more than .020 in. out of flat. Excessive nicks or gouges and replace if evident. Excessively damaged or missing Spauldite washer and replace with new washer (flat washer P/N LM-827-26 is to be affixed to non-chamfered side of cover).

VI. REASSEMBLY

A. LM-827-SA1, LM-827-SA2 and LM-827-SA7 Front Mounting Assemblies (See Figures 5, 6 and 8)

1. Install three outer spacers (12) over sandwich mountings (11).
2. Insert above parts in housing (2), with an inner spacer (7) between each pair of sandwich mountings (11). Insert plate (13) in housing.
3. Apply load to plate (13) using an arbor press or hydraulic ram and loading through a 2-1/2 inch diameter cylinder. Continue to apply load (up to app. 1,000 lb.) until mountings (11) are compressed sufficiently that internal groove in housing (2) is completely visible. (Note: Excessive load or use of smaller diameter cylinder could result in permanent distortion to end plate (13). Use commercial retaining ring pliers to install ring (14).

3. (cont.)

Caution: Check to insure that retaining ring is fully seated and tight in housing by measuring I.D. of installed ring at several locations; I.D. should be 2.860 inch minimum. If ring is not fully seated, insert 2-3/4 inch washer inside of ring and use screwdriver between gap to wedge ring out into groove or tap ring carefully to seat.

4. Insert washer (6) over stem of bracket (3), with chamfered side toward shoulder.
5. Insert bracket (3), with bolts (5), washers (4), and washer (6) in place, through inner members of bonded mountings (11). Orient offset bracket (3) as shown in Figures 4 and 5.
6. Install washer (8) and tighten nut (9) to torque of 450-500 in.-lb., maintaining flat face of housing (2) parallel to bolt pattern centerlines in bracket (3) within ± 30 minutes.
(Note: Twist in excess of this amount will cause engine installation difficulties).
Install cotter pin (10).
7. Affix gasket (16) to back face of flange of bracket (2).

B. LM-827-SA3 Rear Mounting Assembly (See Figure 7)

1. Insert bracket (8) through hole in cover assembly (7) with chamfered side of hole toward clevis end of bracket.
2. Insert stem of bracket (8) through bonded inner member (3) and attach with washer (9) and nut (10). Tighten nut to torque of 160-200 in.-lbs.
3. Insert above parts into housing (2). Fasten cover assembly (7) to housing (2) with washers (5) and bolts (4). Before tightening bolts, align bracket and housing so that centerlines of housing (2) clevis holes and holes in clevis end of bracket (8) are in the same plane, within $\pm 2^\circ$. (Note: twist in excess of this amount may cause engine installation difficulties.)
4. Tighten bolts (4) to torque of 20-25 in.-lbs. and lock wire.

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VII. INSTALL ENGINE AND MOUNTINGS

1. Consult Aircraft Manufacturers Specifications for exact engine and mounting installation procedures. Make certain that all mounting attaching bolts or nuts are fully torqued and safely wired or cotter pinned.

APPENDIX

LM-827 D

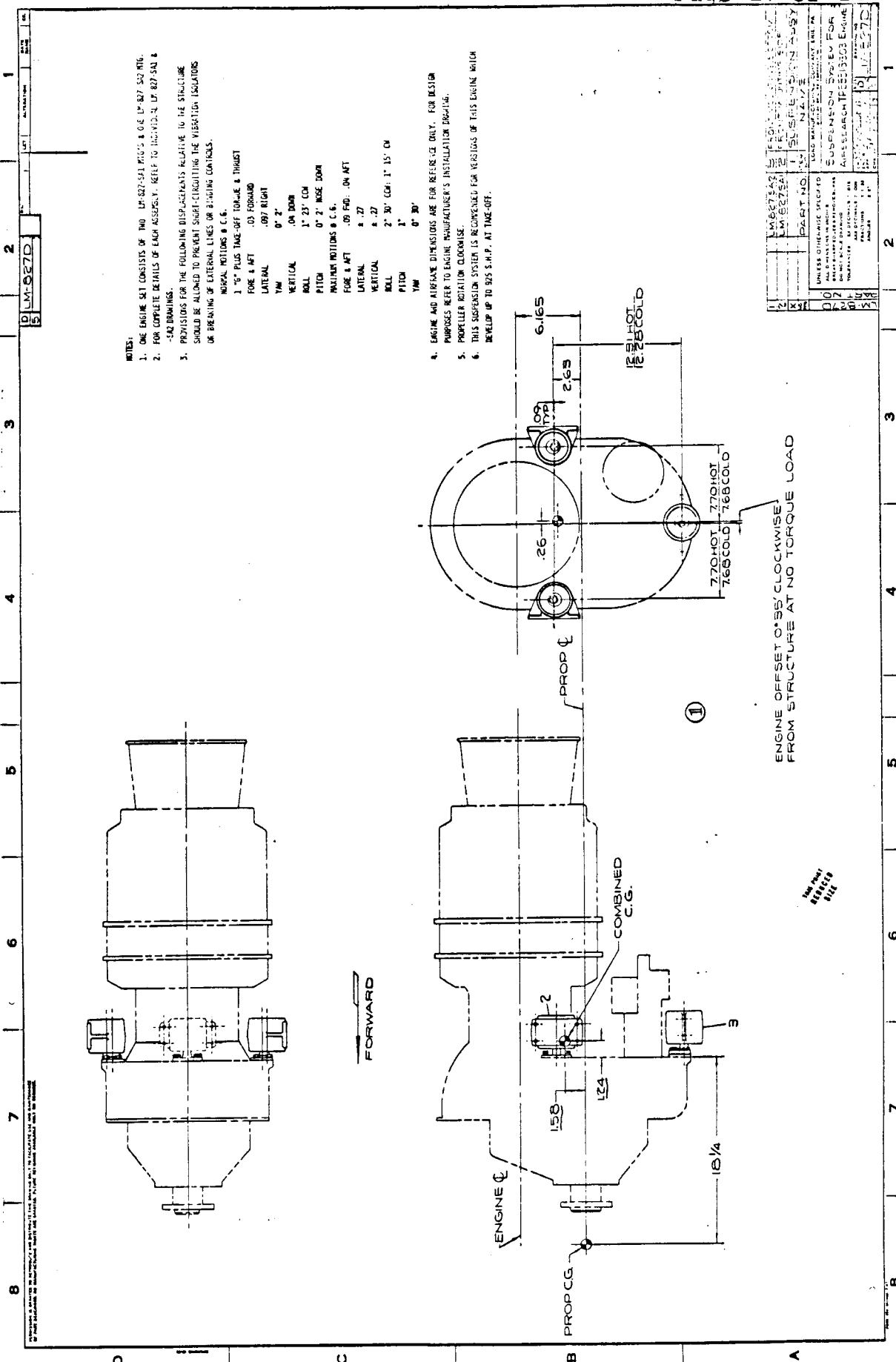


Figure 3

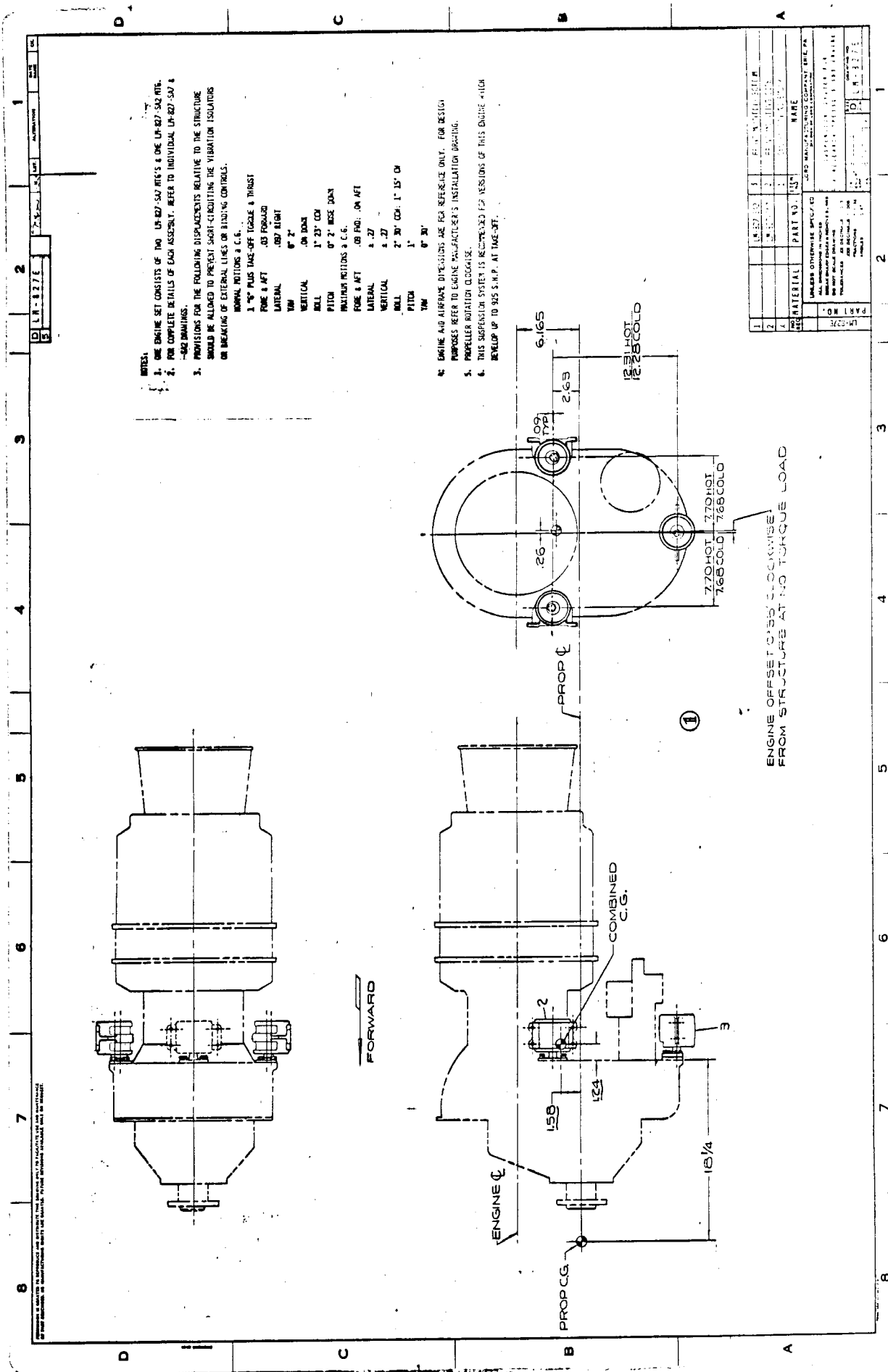
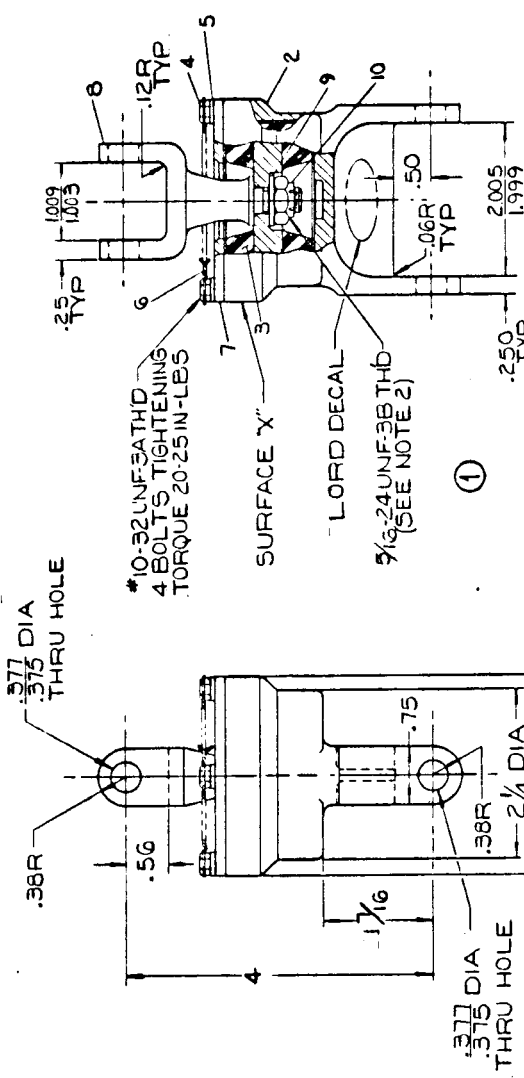
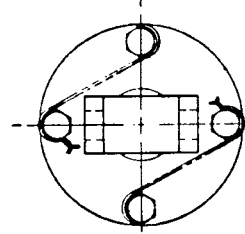


Figure 4

LM-827-SA3

REV	DATE	BY	CHK
1	10/15/58	WJ	WJ
2	12/15/58	WJ	WJ
3	1/15/59	WJ	WJ
4	2/15/59	WJ	WJ

- NOTES:
- "LORD MFG. CO. ERIE PA. USA & REAR MOUNTING ASSEMBLY P/N LM-827-SA3" INK STAMPED ON SURFACE "X" & COVERED WITH CLEAR PROTECTIVE COATING.
 - BRACKET (ITEM 8), WITH COVER ASS'Y (ITEM 7) SLIPPED ON, TO BE ASSEMBLED WITH BONDED INNER MEMBER (ITEM 3) AND NUT (ITEM 10) TORQUED TO 160-200 IN.-LBS. PRIOR TO ASSEMBLY IN HOUSING (ITEM 2).
 - MOUNTING SHOWN ASSEMBLED, AS INSTALLED, IN TOP REAR POSITION, BUT UNDER NO EXTERNAL LOAD.
 - MOUNTING CHARACTERISTICS:
 STATIC SPRING RATE #/IN.
 DIRECTION
 VERTICAL 2000
 LATERAL 2500
 FORE & AFT 0
 MAXIMUM MOTION (IN)
 ± .27 (DUE TO Fz = ± 5000#)
 ± .35 (DUE TO Fy = ± 4520#)



FORE & AFT

LM-827-SA3

1	STEEL	25	10	NUT SELF-LOCKING
2	STEEL	21	9	WASHER
3	STEEL	22	7	BRACKET
4	STAINLESS	21	5	COVER ASSEMBLY
5	STAINLESS	21	5	WASHER
6	STAINLESS	21	5	WASHER
7	STAINLESS	21	5	WASHER
8	STAINLESS	21	5	WASHER
9	STAINLESS	21	5	WASHER
10	STAINLESS	21	5	WASHER
11	STAINLESS	21	5	WASHER
12	STAINLESS	21	5	WASHER
13	STAINLESS	21	5	WASHER
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86	STAINLESS	21	5	WASHER
87	STAINLESS	21	5	WASHER
88	STAINLESS	21	5	WASHER
89	STAINLESS	21	5	WASHER
90	STAINLESS	21	5	WASHER
91	STAINLESS	21	5	WASHER
92	STAINLESS	21	5	WASHER
93	STAINLESS	21	5	WASHER
94	STAINLESS	21	5	WASHER
95	STAINLESS	21	5	WASHER
96	STAINLESS	21	5	WASHER
97	STAINLESS	21	5	WASHER
98	STAINLESS	21	5	WASHER
99	STAINLESS	21	5	WASHER
100	STAINLESS	21	5	WASHER

FEDERAL SUPPLY CODE 76005

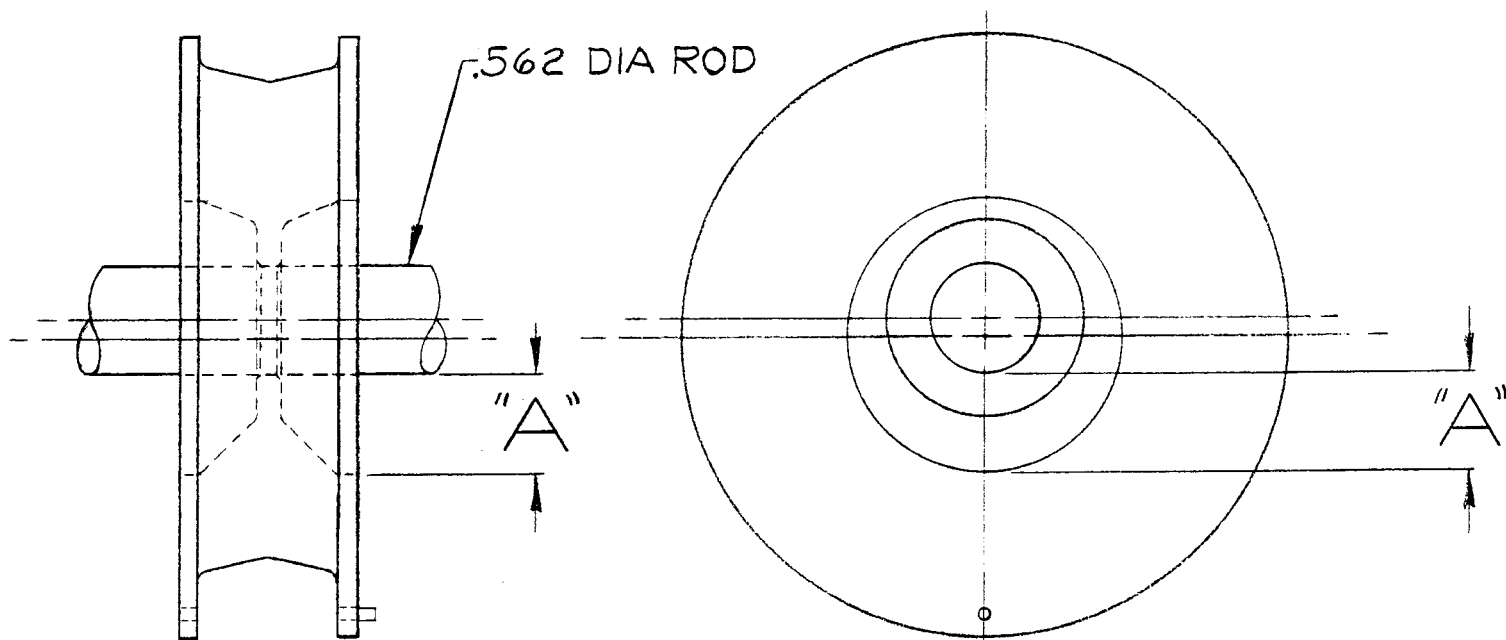
Figure 7

THIS PART
SHOULD BE
RECEIVED
HERE

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FIGURE 9

Dimension for checking shear set of
LM-827-10 Bonded Sandwich Mounting



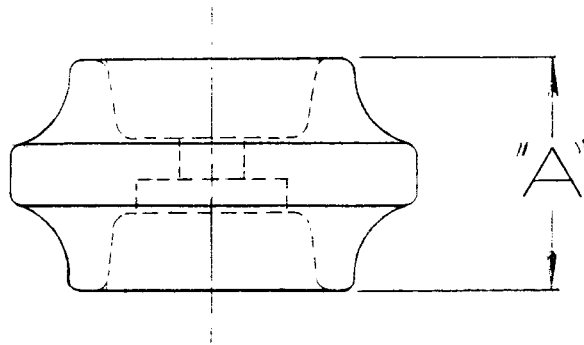
If "A" is less than 0.41 (measured from hole toward pin),
replace part.

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FIGURE 10

Dimension for Checking Compression Set of
LM-827-19 Bonded Inner Member.



If "A" is less than 1.11, replace part.