Spec. No. 146-0

Date: June 6, 1941

Revised: Aug. 18, 1941 Revised: Sept. 20, 1941 Revised: September 26, 194 Revised: Feb. 5, 1942

#### MODEL SPECIFICATION

ENGINE, AIRCRAFT: MODEL V-1710-51 and -55

Allison Division of General Motors Corp.

(Allison Model Designation V-1710-FloR & FloL )

## A. APPLICABLE SPECIFICATIONS.

A-l. The following specifications of the issue in effect on date of invitation for bids shall form a part of this specification:

A-la. Army-Navy Specification. -

AN-9500 Engines, Aircraft; General Specification and applicable specifications of the issues indicated on page 17.

A-lb. U. S. Army Specification.

# None Applicable

## B. TYPE AND MODEL

B-1. This specification covers the requirements for the  $\nu$ -1710-51 and -55 engines.

C. MATERIAL AND WORKMANSHIP.

C-l. The requirements for material and workmanship shall be as specified in Specification AN-9500.

D. GENERAL REQUIREMENTS.

D-1. See Section E.

E. DETAIL REQUIREMENTS.

E-2. Drawings. - The following Allison Engineering drawings form part of this specification:

41001 Engine Assembly, Complete - (Showing Accessory Drive 011 Seals.) - V-1710-51

41581 Engine Assembly, Complete - (Showing Accessory Drive Oil Seals.) - V-1710-55

- 41000-D Installation Drawing (Showing clearences for engine accessories and their removal) V-1710-51.
- 41580-D Installation Frawing (Showing clearances for engine accessories and their removel) V-1710-55.
  - 36905-E Priming System Assembly
- 42065 Carburetor, PD12K3 Bendix-Stromberg
- 40600-J Spark Plug Assembly AC-LS85
- 40601-B Spark Plug Assembly Champion C34S
  - 42354 Terminal, Spark Plug
- 40208 Lubrication System Diagram
- 41550-A Magneto
- 42360 Radio Shielding Assembly V-1710-51 R.H.
- 42361 Radio Shielding Assembly V-1710-55 L.H.
- 37583-B Manifold Assem. Spark Plug Cooling R.H.
- 37584-B Manifold Assem. Spark Plug Cooling L.H.
- 33536-K Nut Magneto Cable Shielding Conn.
- 42348 Shielding Spark Plug Cable Intake
- 42347 Shielding Spark Plug Cable Exhaust
- 41616-C Bag Engine Shipping
- 36411-F Nut #50 Prop. Shaft Thread Protector
- A2288 Plug Crankcase Dehydrator
- E-3. Acceptance. The engine shall be model tested in accordance with AN-9502 with the following exceptions:
- (1) (Reference, Paragraph F-3b., Torsional Vibration and AN-9504, Par. E-96 and E-3c.) The vibration amplitude measured at the reer of the crankshaft shall not exceed ±1.2° for the 1-1/2 order, single node vibration, and 0.35° for the 6th order 2 node vibration.
- E-4. Weight. The total dry weight of the engine complete shall not exceed the values indicated below:

6-3 The 4.5

3.2-

31.1

7.2

None

	Spec. No. 146-C
	Basic Engine, including integral supercharger, supercharger drive mechanism, propeller raduction gears, coolant pump and piping on the engine, engine lubrication system, oil pumps, starter commection, including starter dog, tachemeter drives, fuel pump drive, generator drive, vacuum pump drives, propeller governor drive and all piping and controls between engine parts 1256
	Carburetor and injection nozzle
	Carburetor Screens and Gaskets
	Magneto, Shielded
22.4	Ignition Distributors (included in Shielding Assembly)

Radio Shielded Ignition assembly, complete with Cable and Distributors.

Spark Plugs Priming System on Engine

Cooling Air Deflectors and Baffles

Accessory Drive Covers

TOTAL DRY WEIGHT OF ENGINE

1.2 1345 lbs.

Performance Characteristics. - The ratings specified herein, and the curves specified herein and shown on pages 13, 14,15 & 10 shall constitute the power and specific fuel consumption guarantees. The terms used and the standard conditions shall be in accordance with the applicable definitions contained in specification AN-9502.

E-5a. Ratings. - Both engines shall be rated as follows, using fuel conforming to specification AN-VV-F-781 and oil conforming to specification AN-VV-0-446, Grade 1120.

> 1100 B.H.P. at 2600 R.P.M. at sea level 1100 B.H.P. at 2600 R.P.M. from sea level to 25,000 feet with an exhaust turbo supercharger installation of suitable output.

1325 B.H.P. at 3000 R.P.M. Take-off for five minutes. 1325 B.H.P. at 3000 F.P.M. military rating from sea level to 25,000 feet, for 15 minutes with an exhaust turbo supercharger installation of suitable output.

3120 R.P.M. rated overspeed dive R.P.M.

E-5b. Curves. - The following curves shall be furnished as part of this specification:

> E-5b. (1). Curve as specified in Paragraph E-5b (1) of specification AN-9501, - Page 15.

E-5b. (2). Curve as shown on Page 16.

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- E-5b.(3). The curves shall be constructed as shown on page 13.
- E-5b.(4). Engine power vs. exhaust back pressure curves will be incorporated on page 14 after calibration has been made on the particular airplane manufacturer's turbo exhaust piping.
- E-5e. Specific Oil Consumption. The specific oil consumption shall not exceed .025 lb./BHP/hr. at normal rated power and speed, .025 1b./BHP/hr. et 70 per cent normal rated power and 89 per cent normal rated speed.
- Coolant Flow and Heat Rejection. The following guarantee is given for the coolant flow and heat rejection to the coolant:

### Conditions:

Operation . . . . On dynamometer for 5 minutes Power . . . . Take-off (1325 bHP) Speed . . . . Take-off (3000 RPM) Fuel Consumption . . . Guaranteed Specific Oil Inlet Temp. . . . 185°F. Oil Pressure . . . 65 p.s.i. Coolent Outlet Temp. . . 250°F. Oil Flow . . . . 150 lb./min. Air Blast on Engine . 60°F. at 10 M.P.H.

### Guarantee:

Coolant flow not to exceed - 265 G.P.M. Heat rejection to coolant not to exceed - 430 H.P.

E-5h.(1); E-5h(1)(a); E-5h.(1)(b). - Coolant Pump Data required shall be furnished as part of this specification after completion of model test.

Oil Flow and Heat Rejection. - The following guarantee is given for the oil flow and heat rejection to the oil:

#### Conditions:

Operation . . . . . On dynamometer for 5 minutes Power . . . . . . . . . . . . . . Take-off (1325 BHP) Speed . . . . . . . . Take-off (3000 RPM) Fuel Consumption. . . . Guaranteed Specific Oil Inlet Temp. . . . 185°F. 

#### Guarantee:

Oil flow not to exceed 150 lb./min. Heat rejection to oil not to exceed 150 H.P. E-6. Figine Performance. - (Beference, specification AN-9500 pergraph D-6.) - The complete engine shall function satisfactorily at military rated power up to an altitude of 25,000 ft., in combination with an exhaust turbo installation of suitable output and performance. The contractor guarantees that the engine shall function satisfactorily; between 25,000 ft. and the service ceiling of the sirplene, assuming 25,000 feet as the critical altitude and the power falling off from this altitude as a normal, integrally supercharged engine having a critical altitude rating of 25,000 ft.

E-7. <u>Proceller</u>. - The engine shall have a number 50 proceller shaft end. Provision shall be made for a governor type of proceller control mechanism of the hydromatic type.

E-12. Overall Dimensions. - The overall dimensions of the engine shall not exceed the following:

Length 85 5/8 inches Width 29 9/32 inches Height 36 3/4 inches

E-14. <u>Preparation for Storage</u>. - The engine shall be prepared for storage in accordance with AN-F-E-568 with the following exceptions:

- (Aperence, Far. F-3h., Intake Manifold) The dehydrator bags shall be placed on the top
  of the carburetor screen and the cerburetor
  sealed by securing a gasketed cover to the
  cerburetor.
- (2) (Rof. Par. F-Jn., Crankease) Dehydrator plugs conforming to Allison Division drawing do. 42288 shall be installed in the crankease breather as soon as they can be made available.

  The crankease breather elbow, Part No. AM-350-16, shall be attached to the engine for shipment.
- (3) (Ref. Per.F-Zo., Propeller Shaft) A propeller shaft thread cap conforming to Allison Division Drawing No. 36411 shall be installed.
- (4) (Ref. Par. F-4a., Packing Procedure) The engine bag shall conform to Allison Division Drawing No. 41016.
- (5) (Ref. Par. F-4a(1)., When removing the engine from the engine case it shall be possible to reheat seal the openings which must be cut in the engine bag to insert the lifting hooks.
- (6) (Ref. Par. F-4b.) The engine shipping esse shall conform to Allison Division Drawing No. 37780 which provides a window through which the indicator card may be inspected instead of a hinged door.
- E-16b. Parts List of the Engine. The parts list applicable in all details to the engine which successfully completes Government tests shall constitute a requirement of this specification.

- E-18. Propeller Drive. The engine shall be equipped with a reduction gear ratio of 2.00:1. The direction of propeller rotation, when viewed from the anti-propeller end, shall be clockwise, for the V-1710-51 and counter-clockwise for the V-1710-55 engine.
- E-19. Impeller Gear. The impeller gear ratio shall be 7.48:1 and the impeller shall be 9-1/2 inches in diameter.
- E-20. Pistons. The engine shall be fitted with pistons of 6.65:1 compression ratio.

E-23a.(1) Spark Plugs.-The engine shall be fitted with Champion C343 or AC-LS85 Spark Plugs.

- E-23b. Radio Shielded Limition Assemblies. The engine shall be equipped with Allison designed radio smidded ignition assemblies with the following exceptions to AN-9500:
- (1) (Reference, Par. D-le, Mounting Lugs) Mounting clamps shall be provided in place of integral, soldered, or welded mounting lugs.
- (2) (Reference, Par. E-8, Capacitance) The capacitance between the shielding and each ignition cable contained therein shall not exceed 175 micro-microfrands.
- (3) (Ref., Par. E-la, Single Cable Conduits) Single cable conduit connections shall be as shown on Allison Drawing Nos.33536, 42347, and 42348.
- E-23c. <u>High Tension Ignition Cable</u>. (Reference, AN-9500, Par.D-23c High tension ignition cable with saturated moisture resistant braid in conformance with U.S. Army Spec. 95-32152 shall be used on all distributor head to spark plug leads.
- E-23d. <u>Magnetos</u>. The engine shall be equipped with the Scintille Type DFIN6 magneto in accordance with AN-9511 with the following exceptions:
- (1) (Reference, Par. D-lb(1), Threads) Connections for the high tension terminals are 15/16-18 threads.
- (2) (Reference, Par. E-1b(2), Type D Magneto.) The heads of screws for securing the bearing retainer in the flange project beyond the .125" minimum recess in pilot specified in Figure No. 3.
- The temperature rise of this magneto is 55.5°C.(100°F.) above room temperature.
- (4) (Reference, Par. E-2d., Endurance, F-4a(11)b.) (Elevated Temperature Run) This magneto will not meet the temperature requirements specified except for very short perjods of thee.
- F-4s(10)a., Rain and Spray Tost) The magneto will not meet the requirements when subjected to the test specified in this paragraph. The installation of this magneto on a liquid-cooled V engine requirements maximum ventilation in breaker cover.

E-23f. Cooling. - (Reference, Specification AN-9500, Par. D-23f.) - The engine shall be so designed as to permit the installation of adequate means for cooling the magnetos to required maximum temperature of 30°C (176°F.). Provision for cooling the spark plugs and the spark plug allows shall consist of air ducts, as shown on installation Drawing Nos. 41000 and 41580, and Drawing Nos. 37535 and 37584, to which the airplane manufacturer shall connect. For flight and ground operation, shark plug clows shall be satisfactory, provided the 1ghition vire temperature measured in the elbow does not exceed 115°C. (239°F.) and provided the cable furnished in accordance with U.S. Army Space. 95-32152 does not fail below this temperature.

E-24c: Oil Leakage Test. - (Reference, Specification AN-9500, Paragraph D-24c.) - With a mixture of eoual parts of aviation gasoline and oil conforming to Spec. AN-VV-0-46d. Grade 1100 supplied to the pressure eil pump inlet under a head of 35 inches the total flow of oil into the engine shall not exceed 0.2 pounds por hour.

E-24e. Saaventhm and Trassure Puans. - (Reference, Specification AN-9500, Faragraph D-24e and B-24f). - Provided no air traps exist in the external scavenging system, the engine scavenging system shell sdecuately scavenge the engine for coxtended periods of time under normal operating conditions, with a back pressure on the scavenging system not to exceed a maximum of 30 pounds per square inch at maximum flow, and two pounds per square inch at maximum flow, and two pounds per square inch at minimum flowing the Crade 1100 or Grade 1120 oil, conforming to Spec. AN-VV-0-448 at milet viscosity of 100 plus or minus 5 saybolt Universal seconds. The oil pressure pump shall function properly when its fallet pressure is 685 or more of the absolute atmospheric pressure.

E-24g. Oil Cleaner. - The engine shall be equipped with one Automatic Cuno No. 10863 oil strainer.

E-24j. Provision for G1 Connections - The oil inlet connection shall be a 2 Inch - 4 stud opening as shown on installation Drawing Nos. 41000 and 41880.

R-240. Crenkoase Breathers. - Ample breathing especity shall be provided in accordance with Faragraph D-24q, of Specification AN-9500, however, the airplane manufacturer shall locate the front and rear breather outlets to maintain a crank-case pressure measured at the front within the limits of 48 to -4 inches of water on any new or modified airplane installation.

It is desired that the pressure at the front breather be held to 2 to 6 inches of water higher than pressure at the rear breather to provide proper ventilation through the engine from front to rear.

E-25. Puel Motoring System. The engine shall be equipped with one Bendix-Stromborg Model PD12K3 injection carburetor in accordance with Specification AM-9815 except for the following:

(1) (Reference, Paragraph D-7, Strainer) - The carburetor shall meet requirements except that foreign material is not removed with the strainer.

(2) (Reference, Paragraph D-17, lixture control) - The mixture control positions are located as follows:

- (A) Idle cut-off full forward.
- (B) Automatic lean directly back of A. (C) Automatic rich directly back of B.
- (D) Full rich directly back of C.
- (3) (Reference, Paragraph D-26, Protective Treatment of Steel Parts.) Cadalum plated parts shall have a minimum plating thickness of .0005".
- (4) (Reforence, Parkgraph D-38a(1), Metering Characteristics Sea Level) The carboriests shall mest requirements except that at 30 to 70 per cent of airflow for normal rated power and speed the variation in fuel/air ratio shall be plus or minus 2 per cont.
- (5) (Reforence, Paragraph D-52b(1), Metering Characteristics, Master Carburetor) At take-off power and speed, the carburstor shall contain a setting which in the rich mixture control position will furnish mixture strengths within +4 -0 per cent of the guaranteed fuel consumption.
- (6) (Reference, Persgraph D-30b.(13), Carburetor Heat on Test) The complete airflew to the carburetor shall be heated to avoid icing conditions on test. Duplication of the airplane method of admitting warm air shall not be attempted.

(7) (Reference, paragraph D-32c., Metering Characteristics of Production Carburetors.) - The carburetors shall meet requirements except that at 30 to 70 percent of airflow for normal rated poor and speed the variation in fuel/air ratic shall be plus or minus 2 percent.

(8) (Reference, paragraph F-4e.(3), Metering Tests of Production Carburetors,) - A procedure for air box testing production carburetors, in accordance with War Department, Air Corps, Material Division letter of April 29, 1938, Serial No. E-57-809-16, shall be used, the procedure being as follows:

Mixture readings are obtained on the normal rated power and speed propeller load curve, using the fol-lowing points; such points being subject to change to agree with individual carburetor specifications:

AIRFLOW	L					MET				MIXTUR	CON1	ROL PO	DSITIO
ake-off Ai		airi	low			±2	%	Auto.	Rich	Auto.	Lean	Full	Rich
5% 11	. 11 -	11				. 11		11	*1				
2-1/2% 11	Ħ	11			1	11		n	11	Auto.	Lean		
7% 11	**	11		17		11		11	11	11	11	Full	Rich
5% 11	11	Ħ				11		n	11		. 17		
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In addition, carubretors designed for automatic altitude compensation are checked at an airflow equivalent to 50% of normal rated power airflow with the mixture control in the automatic rich position and readings are taken at air box pressures of 0, 4, 8, and 14 inches of Hg. less than atmospheric pressure.

E-26. Fuel Priming System. - Provision shall be made for priming the engine with fuel from a separately installed priming pump and lead line, supplied by the airplane manufacturer and attached to the engine priming connection.

E-29. <u>Coolant Pump</u>. - The coclant pump shall be supplied with an internal spring loaded packing, Replacement of the packing is made by diseaseably of the pump. No provision shall be made for external packing adjustment.

B-30; Coolant Temperature. - The cooling liquid outlet temperature for liquid cooled engines shall be 121°C. (250°F.)

E-31a(3). Supercharger Drain Valve. - (Reference, Specification AN-9500, paragraph D-31a(3).) - A gurgle passage without a valve shall be the only provision made for automatic drainage of the induction system.

E-32a. Exhaust Flanges. (Reference Specification AN-9500, paragraph D-32a). - Exhaust flanges and gaskets in accordance with installation

drawing Nos. 41000 and 41580 shall be supplied, but shall not be included in the engine dry weight. Planges and gashets shall be shaped with or separate from the engine, at the request of the procuring agency.

E-36. Accessory Drives. - The gear ratio of each accessory drive to the engine craikshait, based on the lowest normal rated speed of the engine, the maximum permissible torque in inch-pounds for continuous operation, the maximum permissible static torque in inch-pounds, and the direction of rotation when looking at the end of the accessory drive sheft in the engine shell be as follows:

ACCESSORY DRIVES	RATIO TO CRANKSHAFT	TORQUE RA INLE CONTINUOUS		ROTATIO	ON -55
Starter	1.000:1		1,6200	C	cc
Generator	1.440:1	600	6000	. c	C
Fuel Pump	0.864:1	25	450	CC ,	cc
Vacuum Pump (Rear)	1.440:1	150	2250	С	0
Vacuum Pump (Side)	1.440:1	150	2250	CC	CO
Tachometer (Two drives)	0.500:1	2.5	12,5	C	0
Propeller Governor	0.845:1	15	150	'cc	C

Note: CC indicates counter-clockwise rotation.
C indicates clockwise rotation.

E-36a. Starter. - The starter mounting pad and drive shall be Type I, in accordance with Specification AN-9317. The direction of rotation when looking at the starter dog attached to the engine shall be clockwise on the -51 and counter-clockwise on the -55.

R-36a(1) (Reference, AN-9517, Par. E-4b) Clearance shall be provided as shown on Installation Drawing Nos. 41000 and 41580.

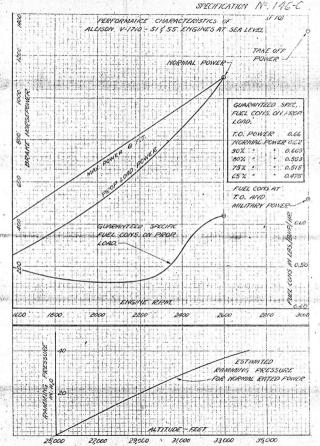
E-36c. Power Take-off Drive. - A power take-off drive shall not be provided for driving a gear box assembly.

E-56e. Pad and Drive for Gun Synchronizer Impulse Generator. Provision shall not be made for driving gun synchronizing Impulse generators.

E-36e(1) Gun Synchronizing Impulse Generators shall not be furnished.

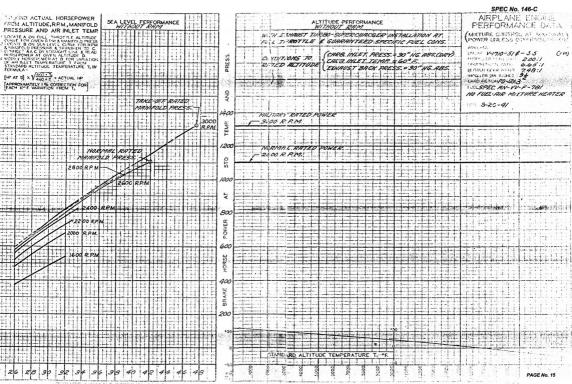
E-45. Interchangeability. - The V-1710-51 engine can be built at assembly from the detail parts of the V-1710-55 engine, or vice verse, by the substitution, addition or deletion of a few war common parts that have been held to a practical minimum, that is commensurate with similar performance and durability for either direction or rotation.

- F. METHODSOF SAMPLING, INSPECTION, AND TESTS
- F-1. The requirements for sampling, inspection and tests shall be as shown in Specification AN-9500.
- G. PACKAGING, PACKING, AND MARKING FOR SHIPMENT.
- G-1. The requirements for packaging, packing and marking for shipment shall be as shown in Specification AN-9500.



NOTE: Engine prwer vs. exhaust back pressure curve vill be incorporated on this page after calibration with the particular aircraft manufacturer's exhaust piping. Exhaust piping design, as well as back pressure, affects power variation.

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ESTIMATED AIRPLANE ENGINE O IND ACTUAL HORSEPOWER ALTITUDE PERFORMANCE SEA LEVEL PERFORMANCE PERFORMANCE DATA SOM ALTHTUDE, REM. MANIFOLD RESSURE AND AIR INLET TEMP MIXTURE CONTROL AT MAXIMUM CHATEA ON FULL THEOTICE ALTITUSE CHAT FOR CORES HIDM & MANDO DIMESS. THE CHARLE OF THE POWER UNLESS OTHERWISE NOTED! TURBO SUPERCHARGER FNONE V-17/0 - 51 & 55 INCHELLE CEAP HAVE 2.00:1 COMPRESSION SALES 6.45:11 BLOWER GEAR RATE 7.48:1 HP AT 0 X V 460 + T = ACTUAL HP IMPELLER DIA PICHES 9/2 CARGURETION PO 12 K3 (STROMBERG) APPROXIMATELY 1% CORPECTION FOR FUEL AN-VV-F-781 DATE FEB. 5, 1942 -18" HG. TEMP 7.46"HG. STD -35" HG. POWER HORSE BRAKE TOURD ALTITUDE TEMPERATURE TA-OF

SPEC No. 146-C

Specifications as of dates listed below shall be applicable to this model specification. Any specification revisions and/or amendments issued prior to date of bid for this model engine and after the particular dates limited below shall not be applicable.

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Note: a(Asterisk) and prefsoc number in ( ) (parentheses) indicate that the specification has been amended and the particular emergency that is applicable.