

REV.	DATE	ECO
-	14-OCT-85	
A	17-APR-86	
B	06-JUN-86	
C	02-FEB-90	
D	01-SEP-91	
E	14-MAR-02	

TABLE I MATERIAL

MATERIAL CODE	MATERIAL DESCRIPTION	"W" "MAX"	"L" "MAX"	MATERIAL SPECIFICATION
A	ALUMINUM	24	48	LW1000*A
AL	LOW OUTGASSING ALUMINUM	24	48	LW1000*AL
B	BRASS	20	48	LW1000*B
C	CORROSION RESISTANT STEEL	24	48	LW1000*C
T	TITANIUM	12	48	LW1000*T
K	POLYIMIDE FILM	24	48	LW1000*K

TABLE II THICKNESS

THICKNESS CODE	OVERALL "T"	TOLERANCE		"A" LAMS	"B" SOLID	LAMINATION THICKNESS
		"+"	"-"			
A	.015	.0015	.001	.015	-	.003±.0003
B	.033	.003	.002	.033	-	
C	.062	.006	.002	.030	.032	
D	.092	.009	.003	.042	.050	
E	.125	.012	.003	.063	.062	

TABLE III WIDTH AND LENGTH DIMENSIONAL TOLERANCES

DIMENSION		TOLERANCE	
FROM	TO	"+"	"-"
0.4	12.0	.030	.030
12.1	24.0	.060	.060
24.1	48.0	.125	.125

LAMSCO WEST, INC.
 24823 ANZA DR.
 SANTA CLARITA, CA. 91355
 FAX (661)295-8626
 TEL. (661)295-8620

ENGINEERING
[Signature]
 APPROVAL
[Signature]

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.

TITLE SHIM, LAMINATED

DWG. NO. LW1001 REV. E SHEET 1 OF 4

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ENGINEERING INFORMATION:

1. LAMINATED SHIMS TO BE SPECIFIED WHERE MANUFACTURING TOLERANCE CANNOT BE HELD CLOSE ENOUGH TO PRODUCE PROPER FIT.
2. WHEN SHIMMING BETWEEN DISSIMILAR MATERIAL SURFACES, THE SELECTION OF THE SHIM MATERIAL AND OF PROTECTIVE FINISHES MUST INCLUDE CONSIDERATION OF GALVANIC CORROSION.
3. THE THICKNESSES IN TABLE II ARE NORMALLY MANUFACTURED STOCK ITEMS. FOR INTERMEDIATE OR GREATER THICKNESSES, TWO OR MORE OF THE TABLE II CALLOUTS MAY BE COMBINED.
4. SPECIFY THICKNESS CODE AS CLOSE TO THE ACTUAL REQUIRED THICKNESS AS POSSIBLE.
5. FOR DESIGN PURPOSES, IT IS RECOMMENDED THAT THE LENGTH, AND/OR WIDTH, BE INCREASED TO THE NEXT EVEN INCH WHEN EITHER EXCEEDS 10.00 INCHES.

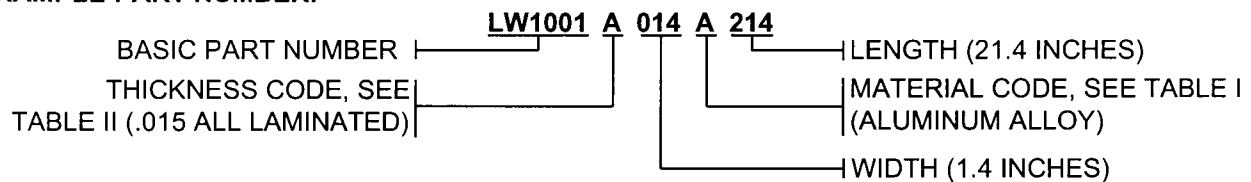
PART NUMBER CODE:

WIDTH AND LENGTH DIMENSIONS TO BE IN 0.10 INCH INCREMENTS. ALWAYS USE THREE DIGITS. DO NOT USE A DECIMAL POINT.

EXAMPLE:

PART NUMBER CALLED OUT X 0.10"	DESIRED DIMENSION
004	.4 INCHES
014	1.4 INCHES
214	21.4 INCHES

EXAMPLE PART NUMBER:



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MATERIAL:

- MATERIAL SPECIFICATION PER LW1000

NOTES:

1. THIS SPECIFICATION IS PROVIDED AS A COURTESY TO CUSTOMERS OF LAMSCO WEST, INC. FITNESS OF PURPOSE FOR THE INTENDED USE IS THE SOLE RESPONSIBILITY OF THE CUSTOMER.
2. THIS SPECIFICATION CONTAINS INFORMATION PROPRIETARY TO LAMSCO WEST, INC. UNAUTHORIZED USE OF THIS INFORMATION IS NOT ALLOWED.
3. ALL SHIMS SHALL BE MARKED FOR SHIPMENT AND STORAGE PER MIL-STD-129. THE SOLID SIDE OF FABRICATED SHIM STOCK SHALL BE DURABLY MARKED ONCE WITH THE COMPLETE APPROVED MATERIAL CALLOUT, LOT NUMBER OR DATE OF MANUFACTURE, AND THE LAMSCO WEST, INC. TRADEMARK. ALL MARKING SHALL BE LEGIBLE. FULLY LAMINATED SHIMS WITH NO SOLID PORTION MAY BE MARKED ON EITHER SURFACE. SHIMS LESS THAN 1.5 INCHES IN LENGTH OR WIDTH SHALL BE BULK BAGGED AND TAGGED.
4. SHIMS TO BE FREE OF IMPERFECTIONS DETRIMENTAL TO FABRICATION OR FUNCTIONAL PERFORMANCE OF PARTS.
5. SHIMS SHALL NOT SHOW ANY VISIBLE DELAMINATIONS EXCEEDING 0.25 INCHES.
6. PEEL STRENGTH: EACH INDIVIDUAL SHIM LAMINATION FOR MATERIAL CODES A, B, C, AND T (PER TABLE I) SHALL HAVE A PEEL STRENGTH NO LESS THAN 1 POUND PER LINEAR INCH AND NO MORE THAN 5 POUNDS PER LINEAR INCH, EXCEPT AT THE SOLID/LAMINATE BOND LINE WHICH MAY BE HIGHER. FOR MATERIAL CODE K (PER TABLE I) EACH INDIVIDUAL SHIM LAMINATION SHALL HAVE A PEEL STRENGTH NO LESS THAN 1/2 POUND PER LINEAR INCH AND NO MORE THAN 2 1/2 POUNDS PER LINEAR INCH, EXCEPT AT THE SOLID/LAMINATE BOND LINE WHICH MAY BE HIGHER. MATERIAL CODE AL IS EXEMPT FROM PEEL STRENGTH REQUIREMENTS.
7. SHIMS SHALL BE MANUFACTURED TO THE REQUIREMENTS OF LAMINATED SHIM STOCK SPECIFICATION LW1000.

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NOTES (CONTINUED):

1. REQUIREMENTS CONTAINED IN THIS SPECIFICATION MAY BE CHANGED WITHOUT NOTICE. CUSTOMERS SHOULD CONFIRM THE REVISION LEVEL PRIOR TO ORDERING.
2. LAMSCO WEST, INC. IS THE ONLY AUTHORIZED MANUFACTURER OF PARTS TO THIS SPECIFICATION.
3. "AL" MATERIAL CODE REFERS TO LAMINATED ALUMINUM BONDED WITH LAMSCO WEST, INC. PROPRIETARY "LOW OUTGASSING" ADHESIVE. THIS ADHESIVE EXHIBITS THE FOLLOWING PROPERTIES: TOTAL MASS LOSS 1.0 MAX., COLLECTED VOLATILE CONDENSABLE MATERIAL 0.1 MAX.

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