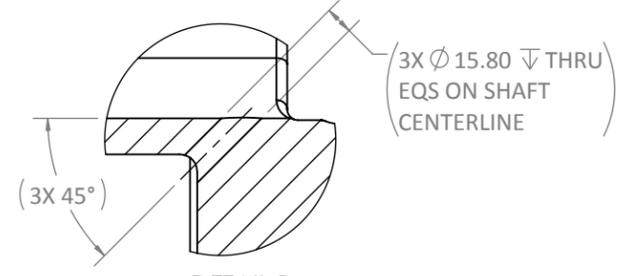
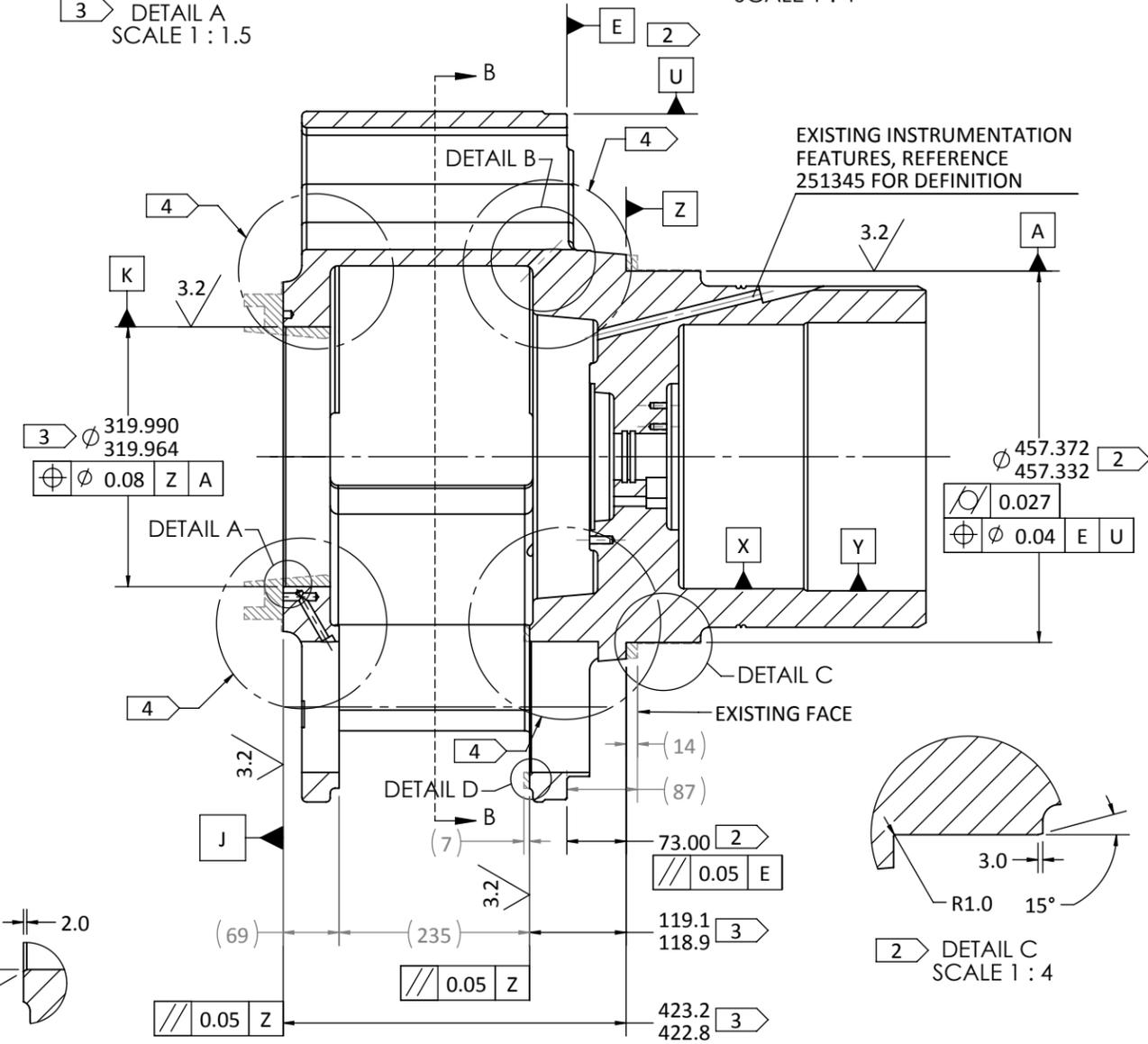
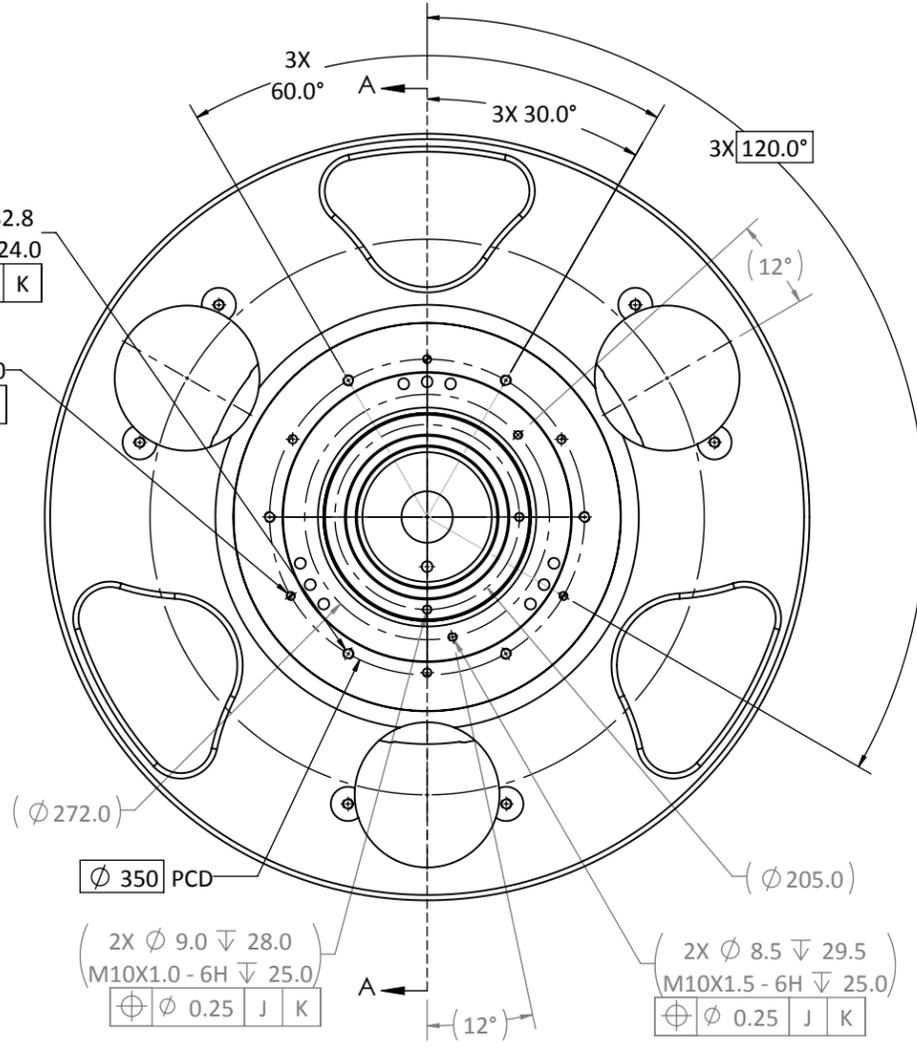


3 DETAIL A  
SCALE 1 : 1.5



DETAIL B  
SCALE 1 : 4



REFERENCE MATERIAL	GGG40.3
	EN-GJS-400U-LT EN-JS 1049
SOURCE: DIN EN 1563	
MODULUS of ELASTICITY "E"	169 Mpa
ULTIMATE STRENGTH "Su"	370 Mpa
YIELD STRENGTH "Sy"	220 Mpa
Poisson Ratio (ν)	0.275
ELONGATION AT FRACTURE	12% MIN
DENSITY (ρ)	7.1 Kg/M3

- NOTES:
- MATERIAL: EXISTING CARRIER 251345 Rev G
  - TRUE COMPONENT TO EXISTING DATUMS "E" AND "U". CHECK ALIGNMENT OF MAIN SHAFT BORES "X" AND "Y". IF "X" OR "Y" RUNOUT IS MORE THAN 0.075mm REPORT VALUE TO PROJECT MANAGEMENT. MACHINE "A" AND "Z".
  - TRUE COMPONENT TO DATUMS "A" AND "Z". REMACHINE REMAINING COMPONENT FEATURES PER NON-REFERENCE DIMENSIONS, CHECK AND RECORD BORE IN CARRIER THAT RECEIVES INSERT 245515.
  - ULTRASONIC TESTING: TESTING OF FORGINGS, IN AREAS SHOWN, MUST FOLLOW THE PROVISIONS OF EN-10228-3 LEVEL 3 (AGMA A-388- TO AN EQUIVALENT 3 mm FLAT BOTTOMED HOLE IS AN ACCEPTABLE ALTERNATIVE.)
  - STAMP A, B, AND C FOR EACH PIN LOCATION IN AREA SHOWN.
  - NOT ALL PRE-EXISTING FEATURES OF 251345 ARE INDICATED

REV	CHANGED FROM	BY	DATE	APRD
A	PRE-RELEASE	JFC	8/XX/12	
B	MACHING ONLY, ASS'Y ON 254594, REVIEWED PER 1509-ENC-004	CPS	1/14/13	
C	CHANGES PER NREL REVIEW NOTES. UPDATED BORDER	CPS	3/12/13	
D	RELEASE FOR PRODUCTION	CPS	4/19/13	
E	INSTRUMENTATION MOUNT THREADS, ROUTING HOLES, PLANET STAMPS	CPG	3/18/14	
F	CHANGES PER MFG REVIEW	CPG	10/16/15	

REPORT ERRORS & CHANGES REMOVE ALL BURRS AND SHARP EDGES DIMENSIONS ARE IN MILLIMETERS. UNSPECIFIED TOLERANCES:  
 DECIMALS: FINISH: ANGLES:  
 X. ±1.0 6.3 μm Ra < ±0.5°  
 .X ±0.5  
 .XX ±0.25  
 COPYRIGHT ©  
 NOT TO BE REPRODUCED OR USED TO MAKE OTHER DRAWINGS OR MACHINERY  
 DRAWN JFC DATE: 9/22/12  
 CHECKED NJB THIRD ANGLE PRJ

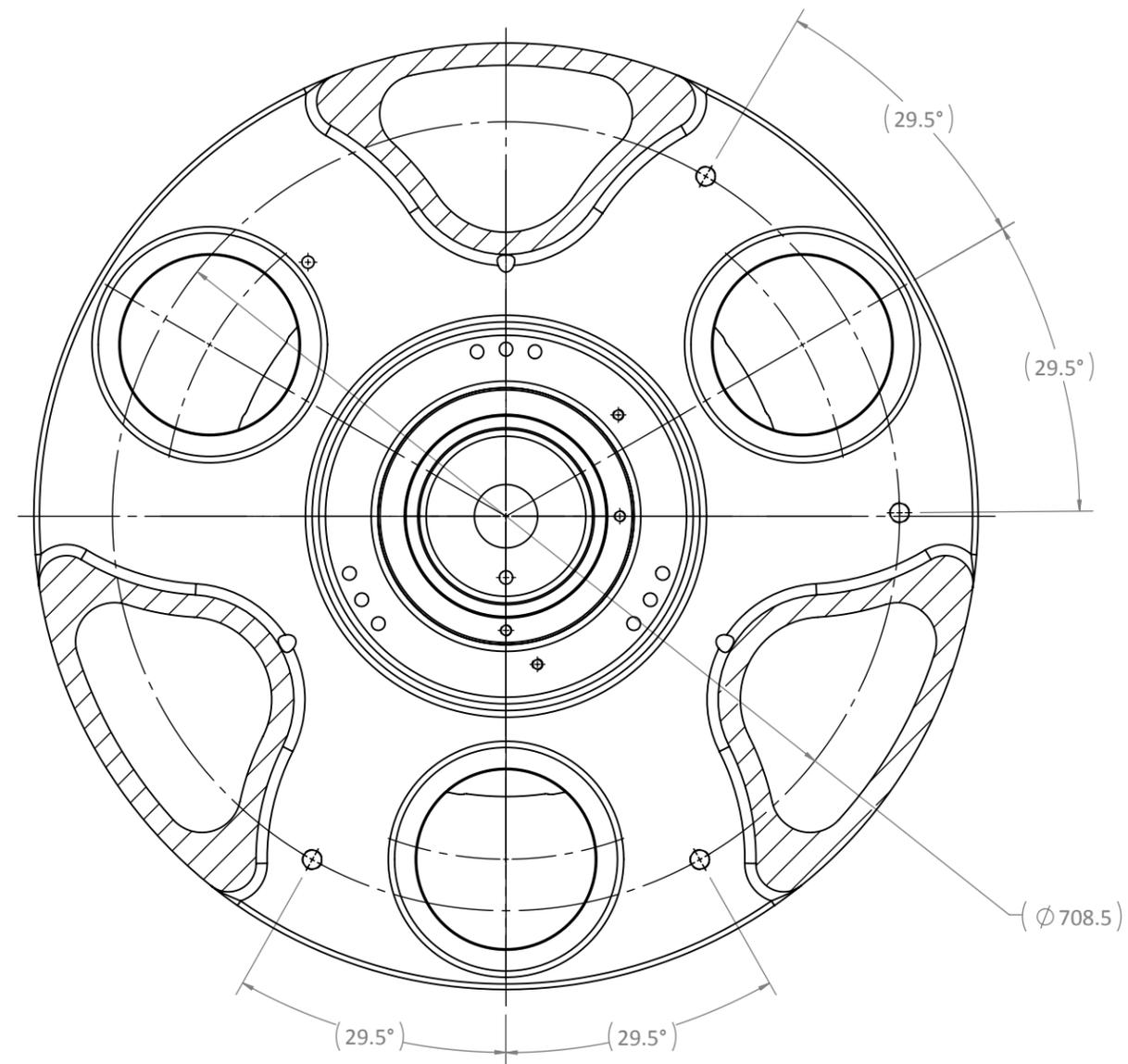
MAKE FROM MODEL: 1509-GS-007-B

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TITLE:  
**PLANET CARRIER REMACHINING**

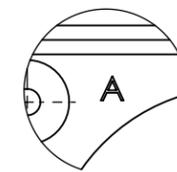
SIZE **B** DWG. NO. **254520** REV **F**

SCALE: 1:10 WEIGHT: 577.88 kgs SHEET 1 OF 2

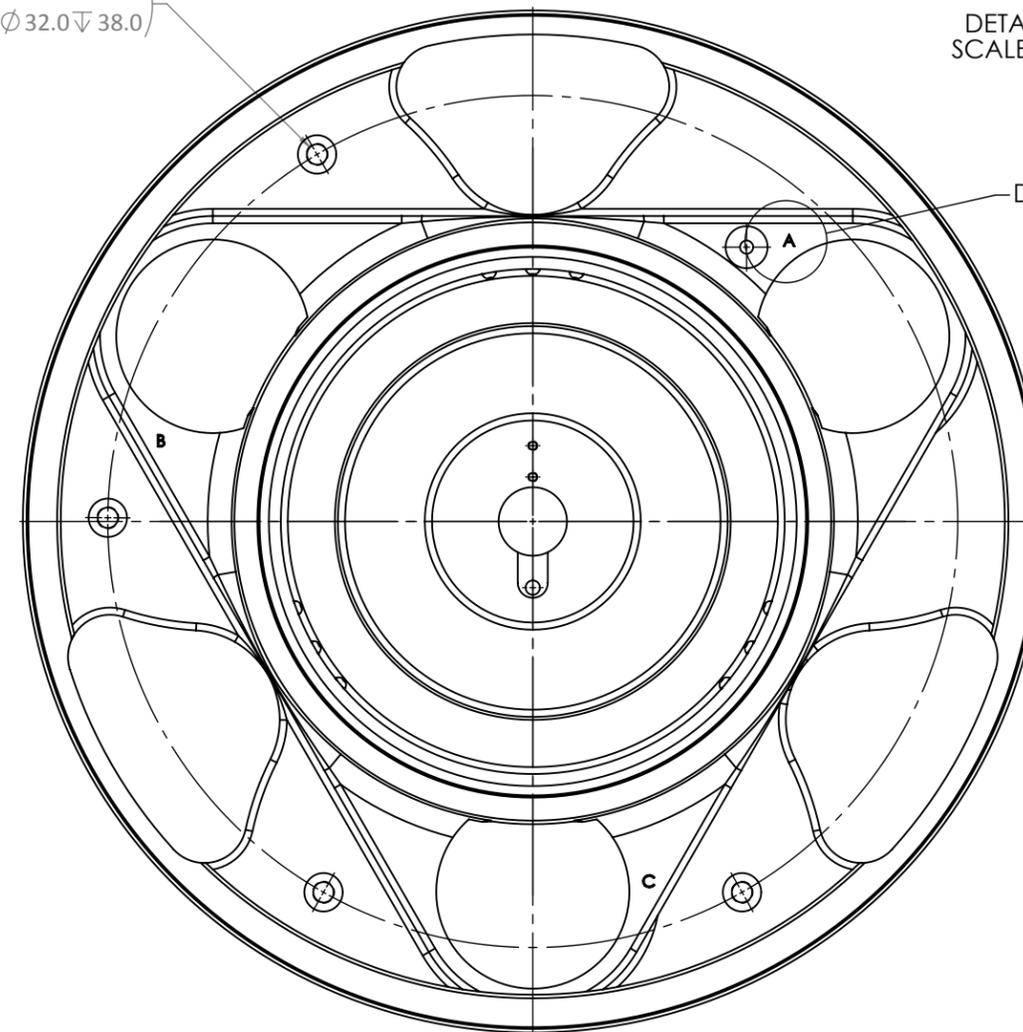


SECTION B-B

(M18X1.0 - 6H THRU)  
 (Ø 32.0 38.0)



DETAIL E  
 SCALE 1:3



REPORT ERRORS & CHANGES REMOVE ALL BURRS AND SHARP EDGES DIMENSIONS ARE IN MILLIMETERS. UNSPECIFIED TOLERANCES:		
DECIMALS:	FINISH:	ANGLES:
X. ±1.0 .X ±0.5 .XX ±0.25	6.3 $\sqrt{\mu\text{m Ra}}$	$\leq \pm 0.5^\circ$
COPYRIGHT ©		
NOT TO BE REPRODUCED OR USED TO MAKE OTHER DRAWINGS OR MACHINERY		
DRAWN	JFC	DATE: 9/22/12
CHECKED	NJB	THIRD ANGLE PRJ

**National Renewable  
 Energy Laboratory**

TITLE:  
 PLANET CARRIER REMACHINING

SIZE	DWG. NO.	REV
<b>B</b>	254520	<b>F</b>
SCALE: 1:6	WEIGHT: 577.88 kgs	SHEET 2 OF 2