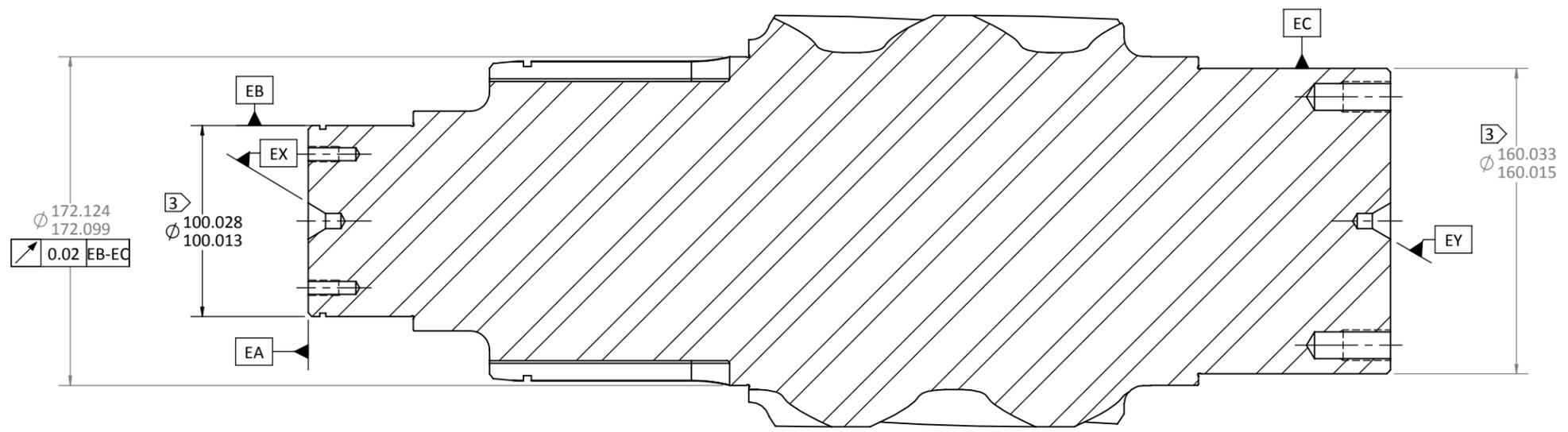
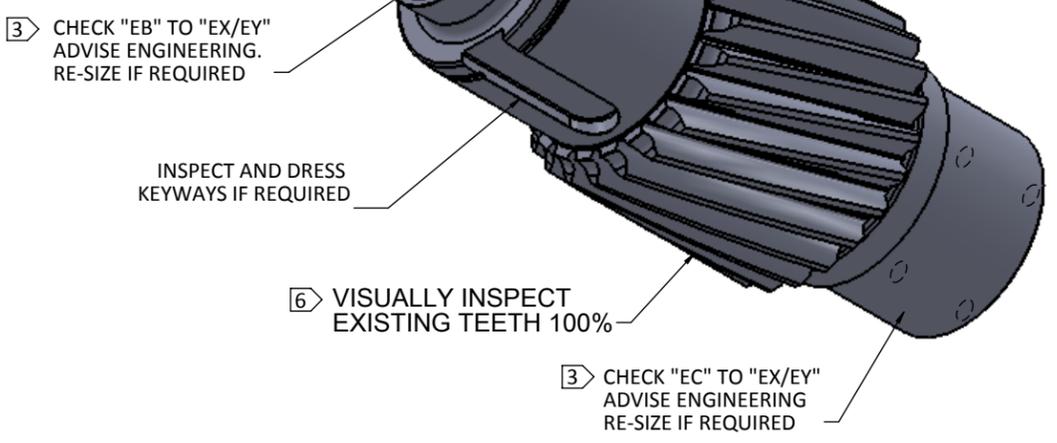


1
4X Ø 6.8 ∇ 25mm MAX
M8 X 1.25 - 6H THD ∇ 16
Ø 0.4 EX EY



SECTION A-A

- 1 MATERIAL: EXISTING SHAFT 251243 (Rev F). ADD HOLES AS SHOWN. RADIAL ALIGNMENT OF TAPPED HOLES TO OTHER FEATURES NOT REQUIRED
- 2. PROVIDE INSPECTION REPORTS OR PROOF ACCORDING TO THE PROVISIONS EN-10204-3.1 REQUEST SEARCH FOR ORIGINAL MATERIAL CERTIFICATIONS, NDT REPORTS, AND CONCESSION DATA.
- 3 REFERENCES DIAMETERS GIVEN FOR INSPECTION. TOLERANCES & GD&T GIVEN ON P/N 251243. RESIZE TO DIAMETERS GIVEN. IF UNDERSIZE, GRIND TO CLEAN UP, HARD CHROME PLATE AND RE-GRIND TO SIZES INDICATED. ALT: REPAIR BY METAL SPRAY, 45 Rc min HARDNESS. RECORD PROCESS USED AND DIMENSIONS AS IDENTIFIED.
- 4. DATUMS FROM THE EXISTING COMPONENT ARE MARKED WITH AN "E" PREFIX REFERENCE P/N 251243 FOR SURFACE FINISH ON GEAR TEETH. NON SPECIFIED FILLETS - R3, NON SPECIFIED CHAMFERS - 1x45°
- 5. CRACK TESTING: FOR EXISTING TEETH, MAGNETIC PARTICLE TESTING OR DYE PENETRANT TEST GROUND SURFACES TO ISO 6336-5. (ALT: AGMA 2001-D04-GRADE 3) NO CRACKS ALLOWED.
- 6 VISUALLY INSPECT EXISTING TEETH 100%. NO STEP ALLOWED ON PROFILE. MICRO INSPECT WORSE TOOTH IN THREE (3) PLACES ALONG THE LENGTH.
- 7. ULTRASONIC TESTING: TESTING OF EXISTING FEATURES 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.) PERFORM ONLY ON PROBLEM AREAS AS NOTED.



MAKE FROM MODEL: 1509-GS-011-B

REV	CHANGED FROM	BY	DATE	APRD
B	REVIEWED & UPDATED PER 1509-ENC-004	CPS	1/18/13	
C	CHANGES PER CUSTOMER REQUEST ON NREL DRW REVIEW NOTES	CPS	3/6/13	
D	CHANGES PER CUSTOMER REQUEST; RELEASE FOR PRODUCTION	CPS	4/11/13	
E	REPAIR DANGLING TAGS	JMG	10/17/13	
F	CHANGES REQUESTED PER MANUFACTURER DRW REVIEW	CPG	12/11/13	

REPORT ERRORS & CHANGES REMOVE ALL BURRS AND SHARP EDGES DIMENSIONS ARE IN MILLIMETERS. UNSPECIFIED TOLERANCES:

DECIMALS: X. ±1.0 .X ±0.5 .XX ±0.25

FINISH: 6.3 $\sqrt{\mu m Ra}$

ANGLES: $\leq \pm 0.5^\circ$

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DRAWN JFC DATE: 8/28/12
CHECKED NJB THIRD ANGLE PRJ

National Renewable Energy Laboratory

TITLE: INTERMEDIATE SHAFT - REWORK

SIZE **B** DWG. NO. 254507 REV **F**

SCALE: 1:3 WEIGHT: 99.66 kgs SHEET 1 OF 1