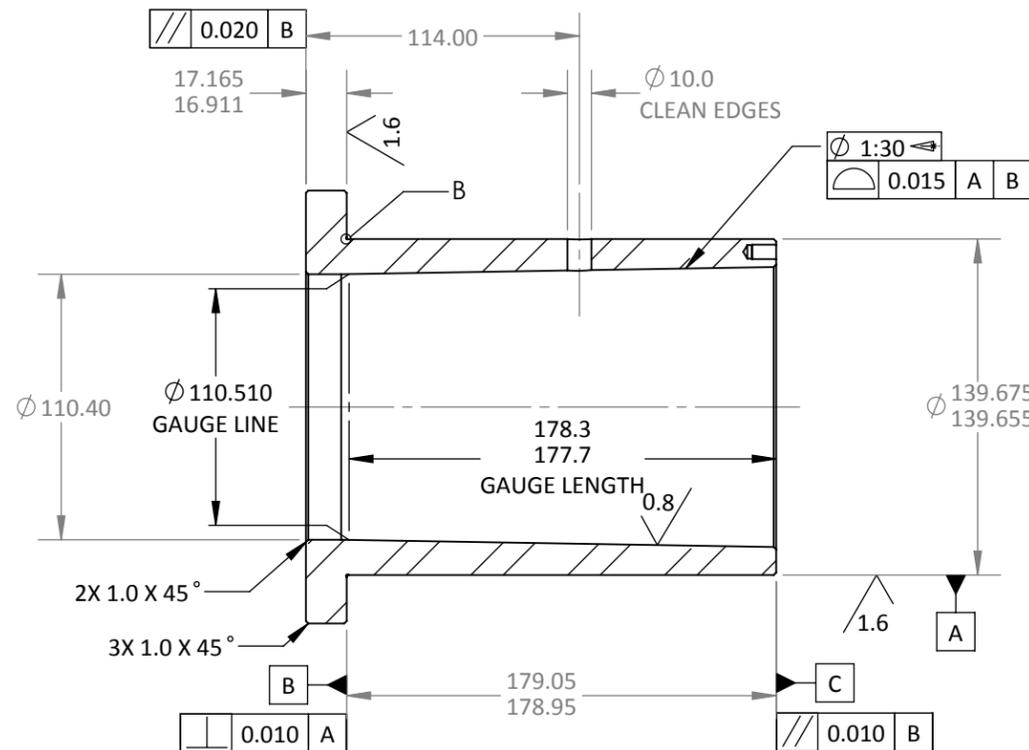
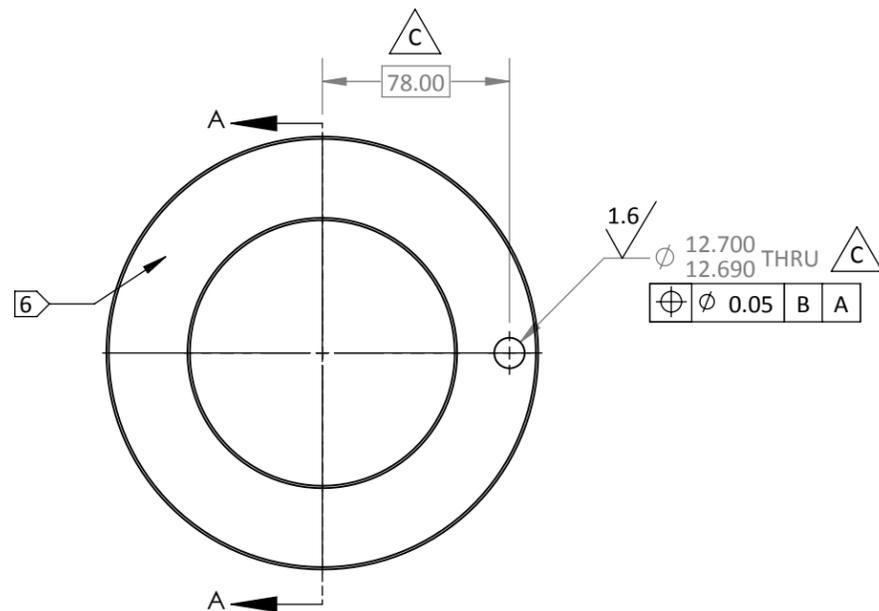
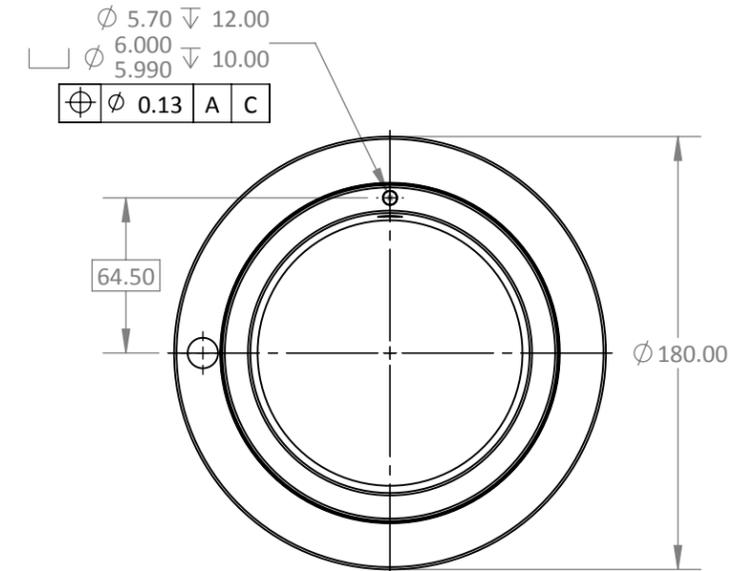


DETAIL B
SCALE 8 : 1



SECTION A-A
SCALE 1 : 3



NOTES:

- MATERIAL: 34CRNIMO. ALT: 4140H OR 4142H, BAR STOCK, THICK WALLED WROUGHT TUBE. REFER TO ISO 6336-5 (or AGMA 2001-404) FOR MATERIAL QUALITY COMPLIANCE. PROVIDE INSPECTION REPORTS OR PROOF ACCORDING TO THE PROVISIONS EN-10204-3.1.
- HEAT TREAT: PRE-HEAT TREATED TO 269/321 BHN
- ULTRASONIC TESTING: TESTING OF FORGINGS 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.)
- CRACK TESTING: MAGNETIC PARTICLE TESTING OR DYE PENETRANT TEST GROUND SURFACES TO ISO 6336-5 (ALT: AGMA 2001-D04-GRADE 3) NO CRACKS ALLOWED.
- VISUALLY INSPECT TAPER 100% AND RECORD MEASUREMENTS AT GAUGE DIA AND LENGTH AND @ DATUM [C]. ALT: CMM REPORT ACCEPTABLE.
- IDENTIFY WITH PART NUMBER, REV LEVEL, SUPPLIER INITIALS, JOB NUMBER, AND SHOP ORDER NUMBER
- HOLES MUST MEET CROSS HOLES, FULL DIAMETER
- NON SPECIFIED FILLETS - R3, NON SPECIFIED CHAMFERS - 1x45°

MAKE FROM MODEL: SUPERSEDES 1509-GS-014-A

REV	CHANGED FROM	BY	DATE	APRD
A	PRE-RELEASE, REDRW-2012 VER, REVIEWED PER 1509-ENC-004	CPS	1/14/13	
B	CHANGES PER NREL DRW REVIEW. UPDATED BORDER	CPS	3/13/13	
C	RELEASE FOR PRODUCTION	CPS	4/19/13	
D	REPAIR DANGLING DIMENSION LEADER	JMG	10/18/13	
E	CHANGES REQUESTED PER MANUFACTURER DRW REVIEW	CPG	12/17/13	

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	3.2 $\sqrt{\mu m Ra}$	≤ ± 0.5°
COPYRIGHT ©		
NOT TO BE REPRODUCED OR USED TO MAKE OTHER DRAWINGS OR MACHINERY		
DRAWN	CPS	DATE: 1/14/13
CHECKED	NJB	THIRD ANGLE PRJ

National Renewable Energy Laboratory		
TITLE: SLEEVE, PLANET BEARING PIN		
SIZE B	DWG. NO. 254553	REV E
SCALE: 1:3	WEIGHT: 9.35 kgs	SHEET 1 OF 1