

- NOTES:
1. MATERIAL: EXISTING HOUSING 251342 (Rev E).
  2. 100% VISUAL INSPECTION MUST BE PERFORMED ON ALL INTERNAL WEBS AND BLENDS AND EXISTING DATUMS. CONCERNS FOUND REQUIRE PAINT REMOVAL AND ADDITIONAL INSPECTION
  3. DATUMS FROM THE EXISTING COMPONENT ARE MARKED WITH A "E" PREFIX. ALL NON-SPECIFIED RADII R3.0 AND CHAMFERS 1x45°  
CHECK CAST WALL THICKNESS. REPORT TO ENGINEERING PRIOR TO MACHINING

4. CAUTION: CURRENT BORE SIZES FOR DATUMS "B" & "EV" ALLOW 1.00 mm MAX FOR CLEAN-UP.

5. MOUNT IN MACHINING CENTER, ALIGN TO DATUMS "A", "B", "EW", "EX", AND "EV". CHECK DATUM AND RECORD. FROM GENERATOR SIDE, CHECK CONCENTRICITY OF "EX-EY" AND ADVISE IF GREATER THAN .050. (TRY ADJUSTING ALIGNMENT OF FACE "A" TO IMPROVE "EX-EY"). CHECK BORE DIMENSIONS PRIOR TO MACHINING.
6. MACHINE BACK & SIDE FACES FIRST ALONG WITH HOLES AND THREADED HOLES ON ANNULS GEAR MOUNTING FACE FIRST.
7. RE-CHECK ALIGNMENT. MACHINE ANNULUS GEAR MOUNTING FACE. AND BORE DATUM "B" TO SIZE. MACHINE FACE OF CENTER PLATE MOUNTING SURFACE "D" AND BORE "EV".
8. PRIOR TO REMOVAL FROM MACHINE CENTER, MACHINE AND ASSEMBLE PER 254550

REV	CHANGED FROM	BY	DATE	APRD
E	CHANGES PER CUSTOMER REVIEW (1509-ECN-006/PP-016)	CPS	3/1/13	
F	CHANGES PER CUSTOMER REVIEW & RELEASED FOR PRODUCTION	CPS	4/9/13	
G	REPAIR DANGLING DIMENSION LINE, NOTES AND $\phi$	JMG	10/17/13	
H	CHANGES PER MANUFACTURER REVIEW AND INSTRUMENTATION	CPG	3/19/14	
I	60 ± 0.05 DIM ADDED RING GEAR FACE TO INNER BEARING FACE	GT	2/11/16	
J	HOLES IN MAIN FLANGE WAS 23x NOW 25x. SIZE OF FLANGE ADDED IN SHEET 2 DETAIL B. SHEET 3 COUNTERBORE SIZES ADDED FOR M10 HOLES	GT	2/12/16	

REPORT ERRORS & CHANGES REMOVE ALL BURRS AND SHARP EDGES DIMENSIONS ARE IN MILLIMETERS. UNSPECIFIED TOLERANCES:  
 DECIMALS: FINISH: ANGLES:  
 X. ±1.0 6.3  $\sqrt{\mu m Ra}$  < ± 0.5°  
 .X ±0.5  
 .XX ±0.25  
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MAKE FROM MODEL 1509-HG-020-B

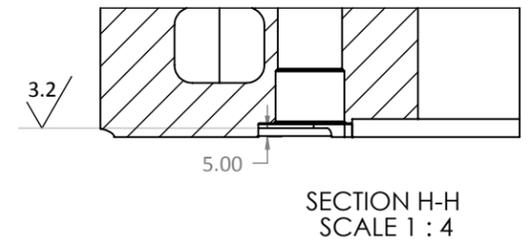
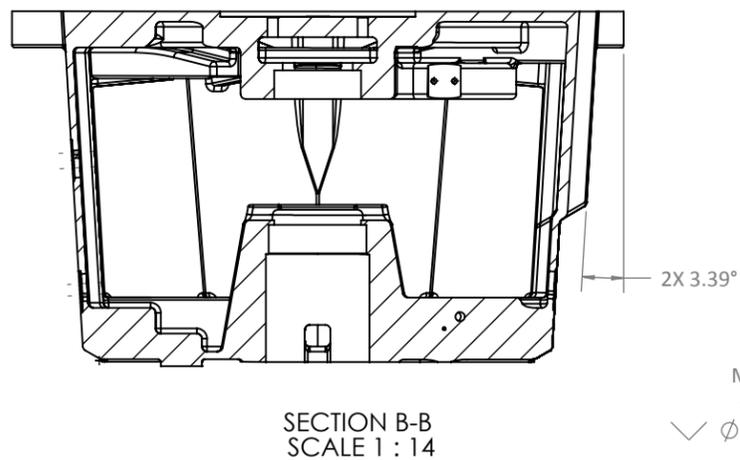
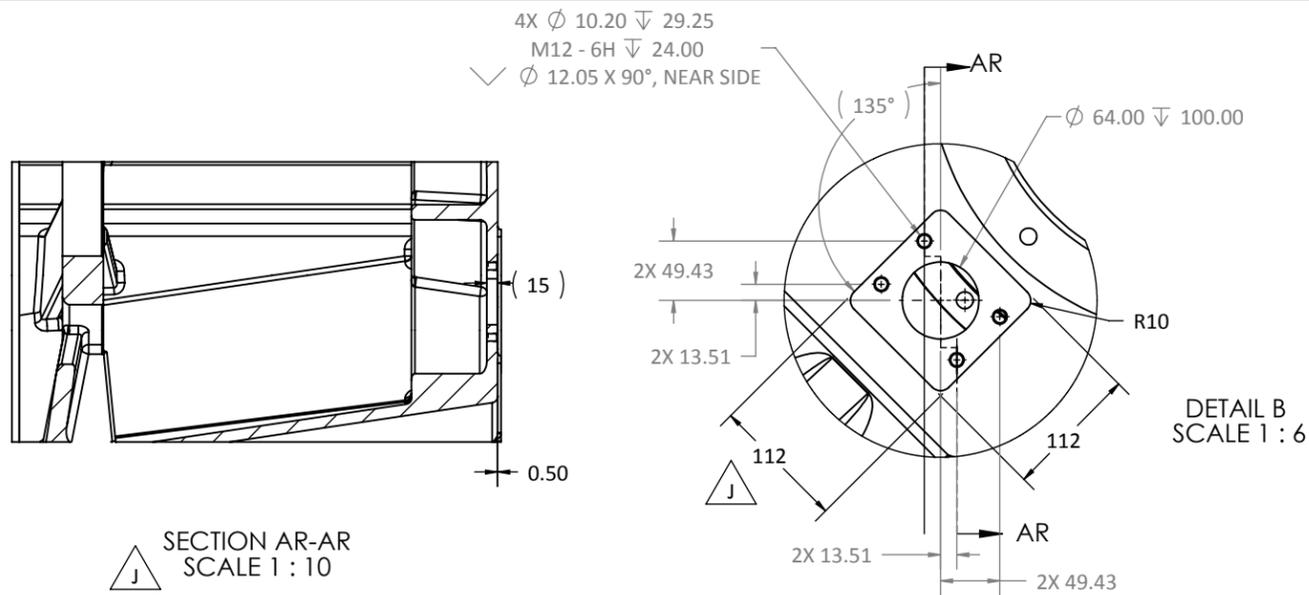
**National Renewable Energy Laboratory**

TITLE: REAR HOUSING REWORK

SIZE: **B** DWG. NO. 254492 REV: **J**

DRAWN: JFC DATE: 9/13/12  
 CHECKED: NJB THIRD ANGLE PRJ

SCALE: 1:12 WEIGHT: 921.15 kgs SHEET 1 OF 4

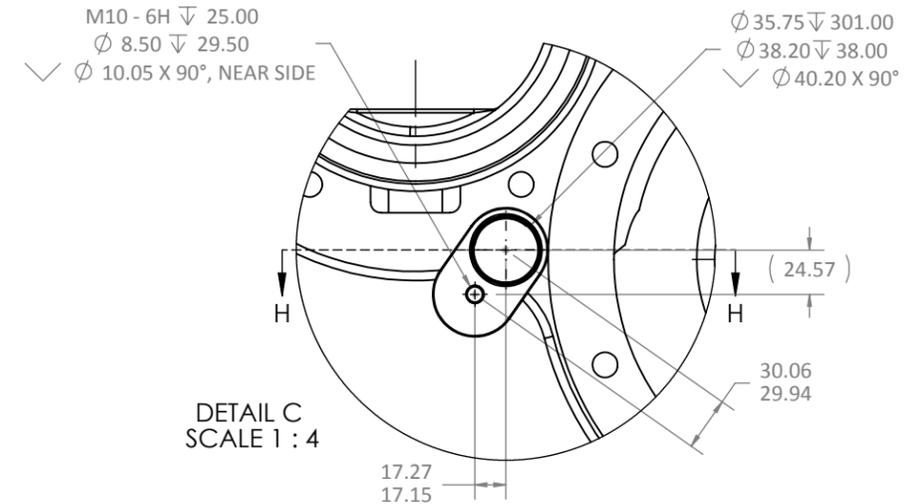
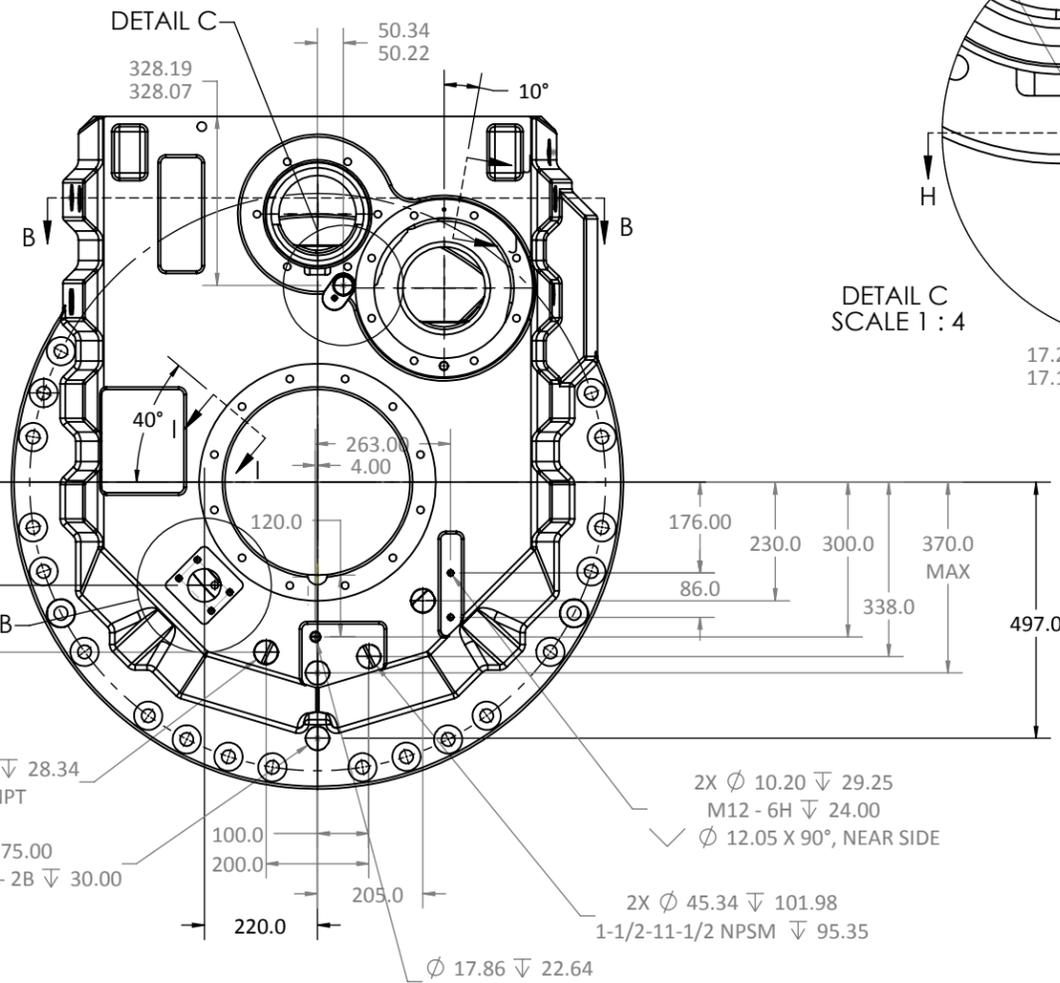
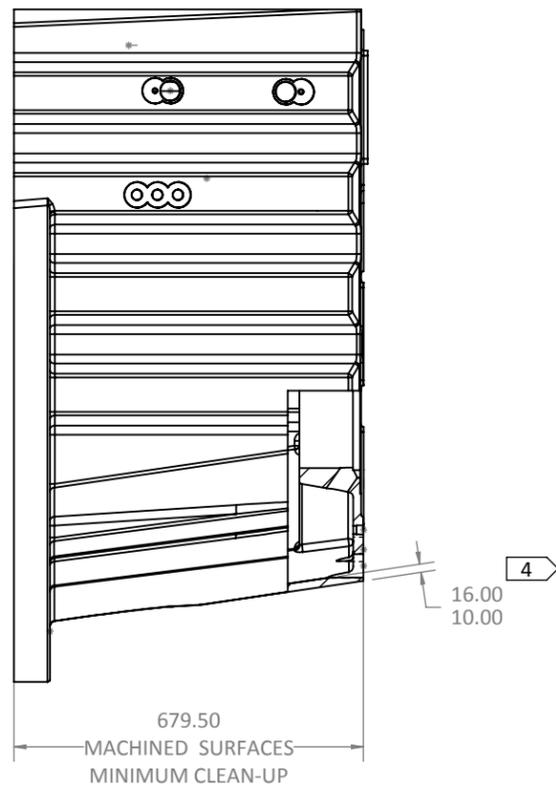


SECTION AR-AR  
SCALE 1 : 10

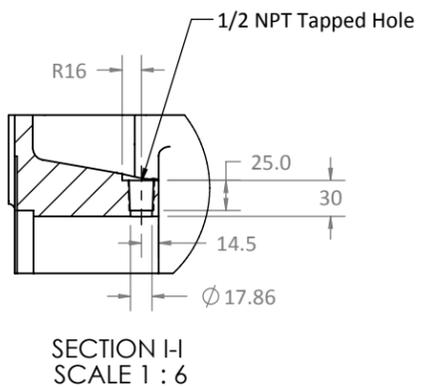
DETAIL B  
SCALE 1 : 6

SECTION B-B  
SCALE 1 : 14

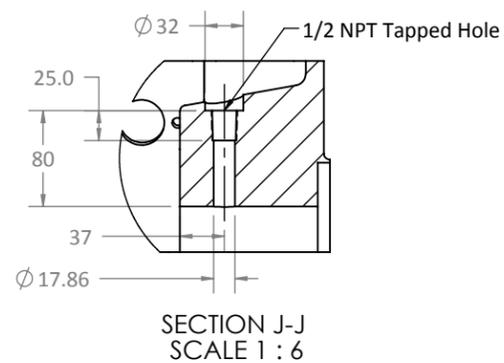
SECTION H-H  
SCALE 1 : 4



DETAIL C  
SCALE 1 : 4



SECTION H-I  
SCALE 1 : 6



SECTION J-J  
SCALE 1 : 6

REPORT ERRORS & CHANGES  
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DIMENSIONS ARE IN MILLIMETERS.  
UNSPECIFIED TOLERANCES:  
DECIMALS: FINISH: ANGLES:  
X. ±1.0 6.3  $\sqrt{\mu\text{m Ra}}$   $\leq \pm 0.5^\circ$   
.X ±0.5  
.XX ±0.25

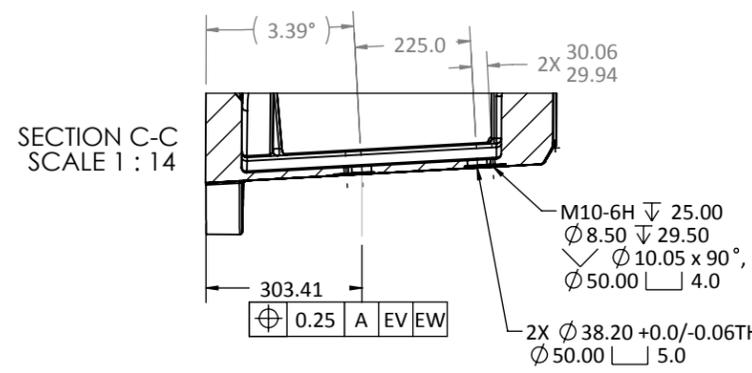
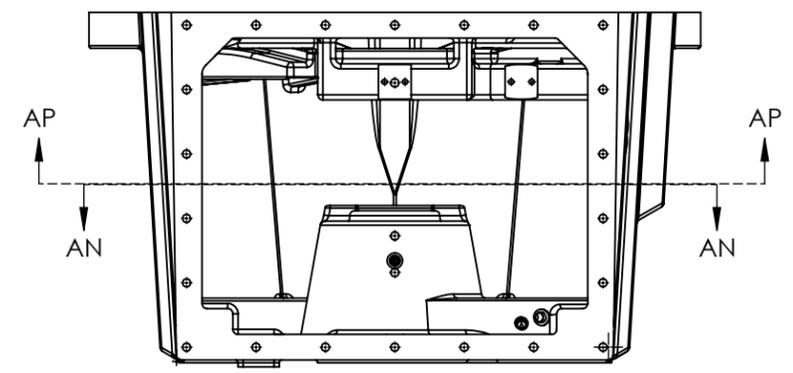
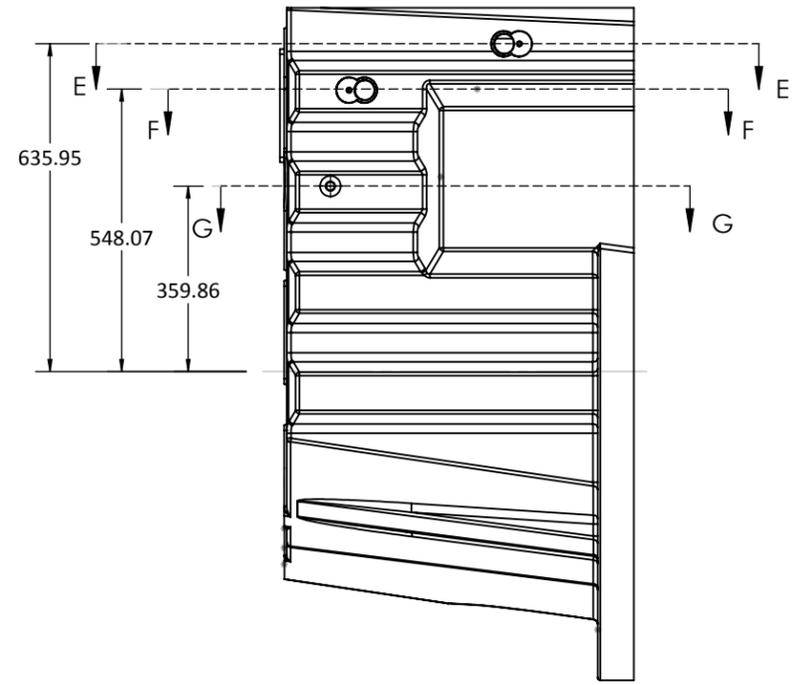
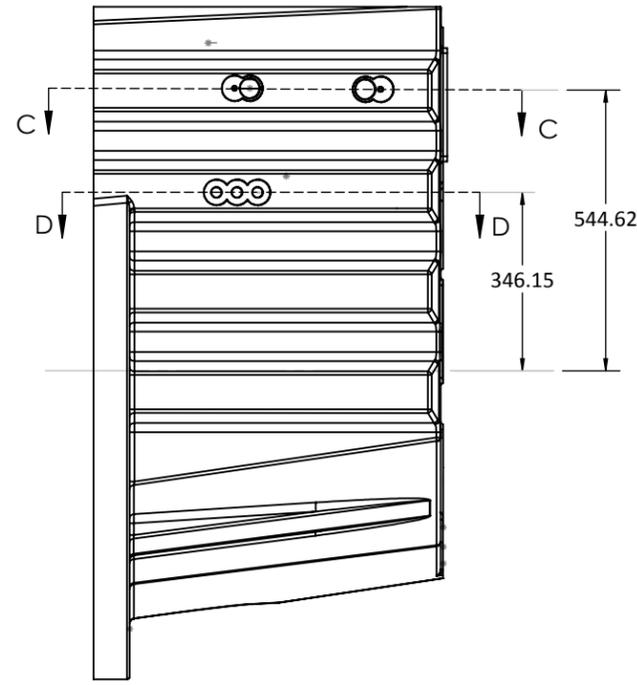
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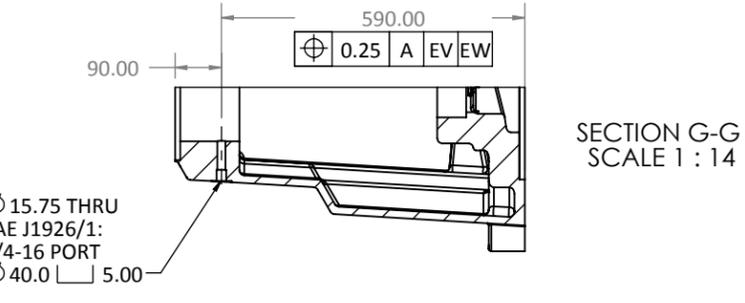
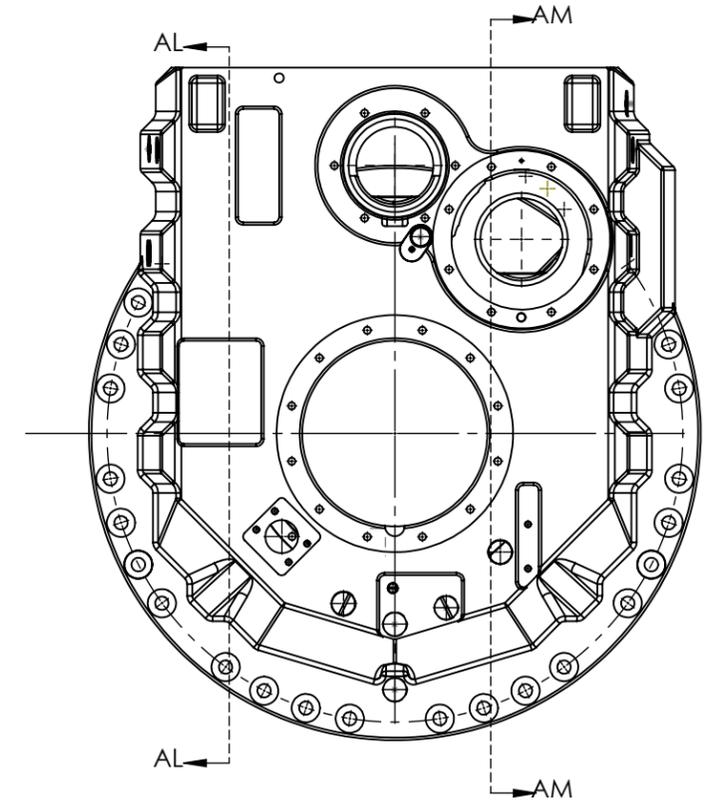
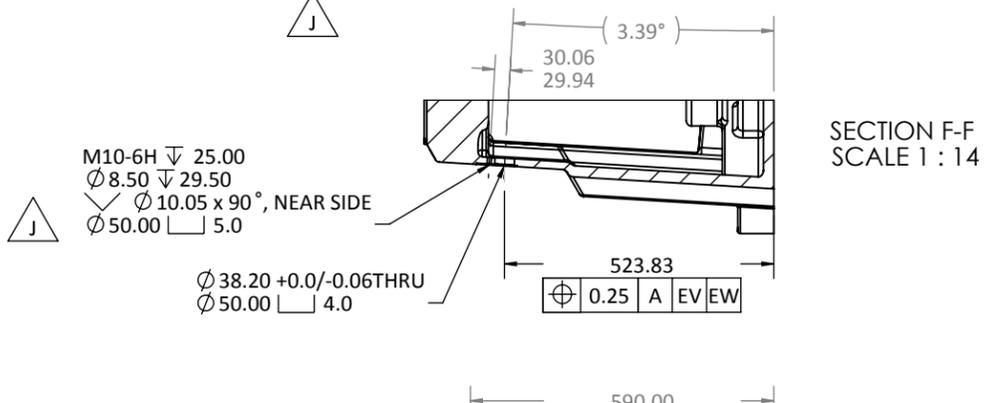
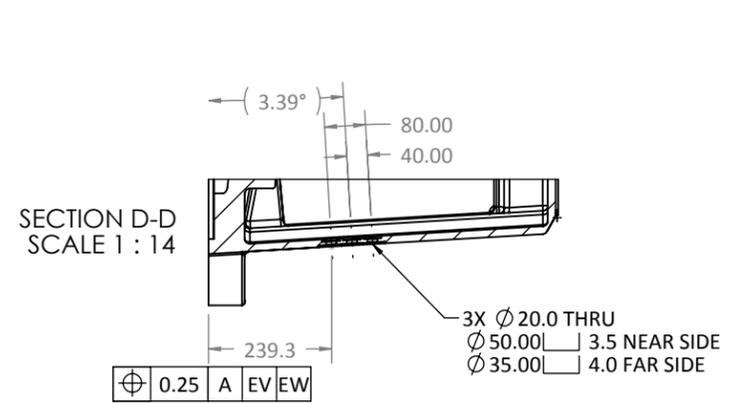
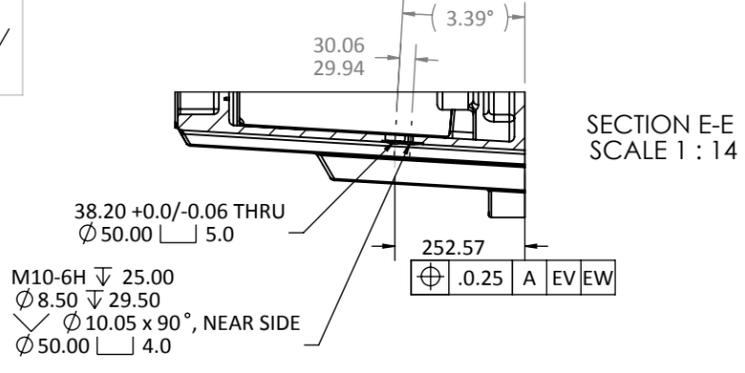
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SIZE <b>B</b>	DWG. NO. <b>254492</b>	REV <b>J</b>
SCALE: 1:20	WEIGHT: 921.15 kgs	SHEET 2 OF 4

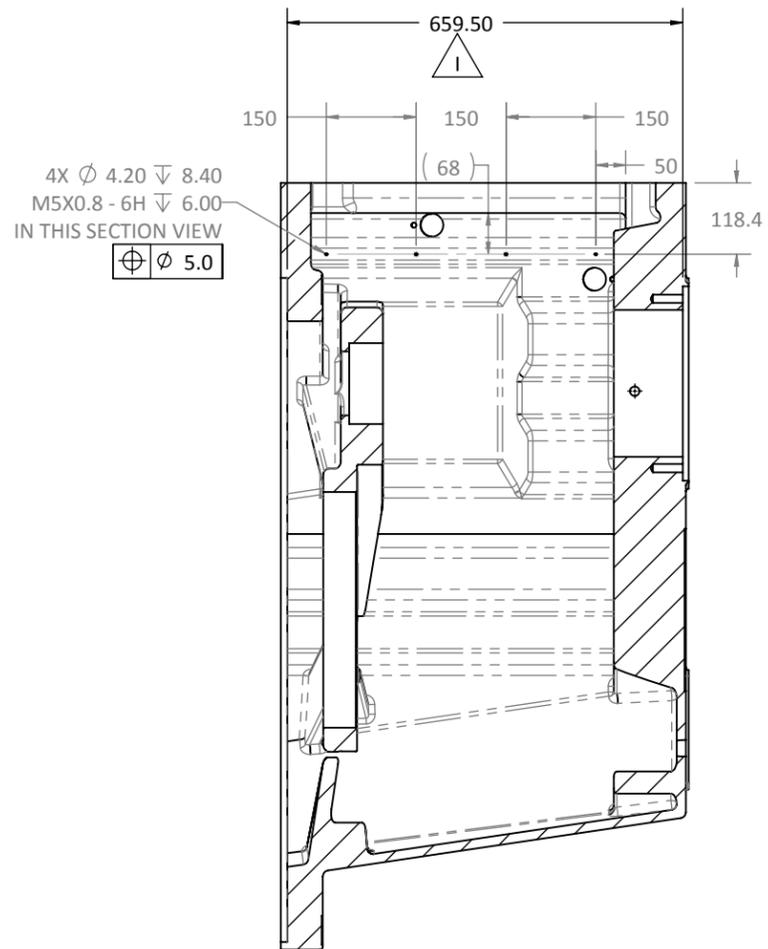


NOTE:  
ALL COUNTERBORES 3.2/  
AND BORE SURFACES

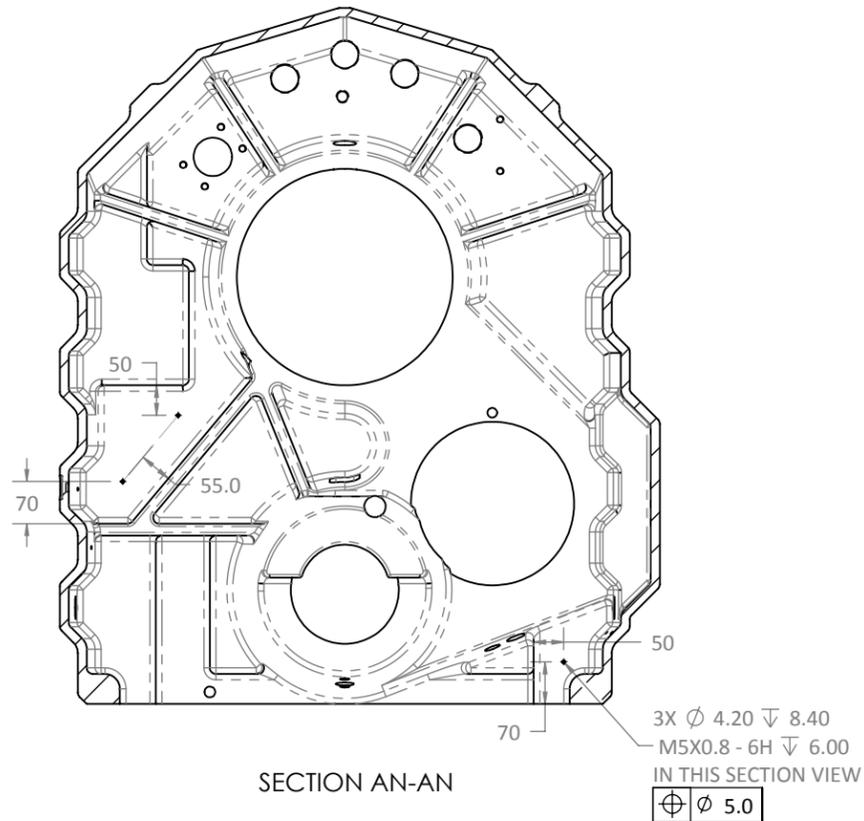


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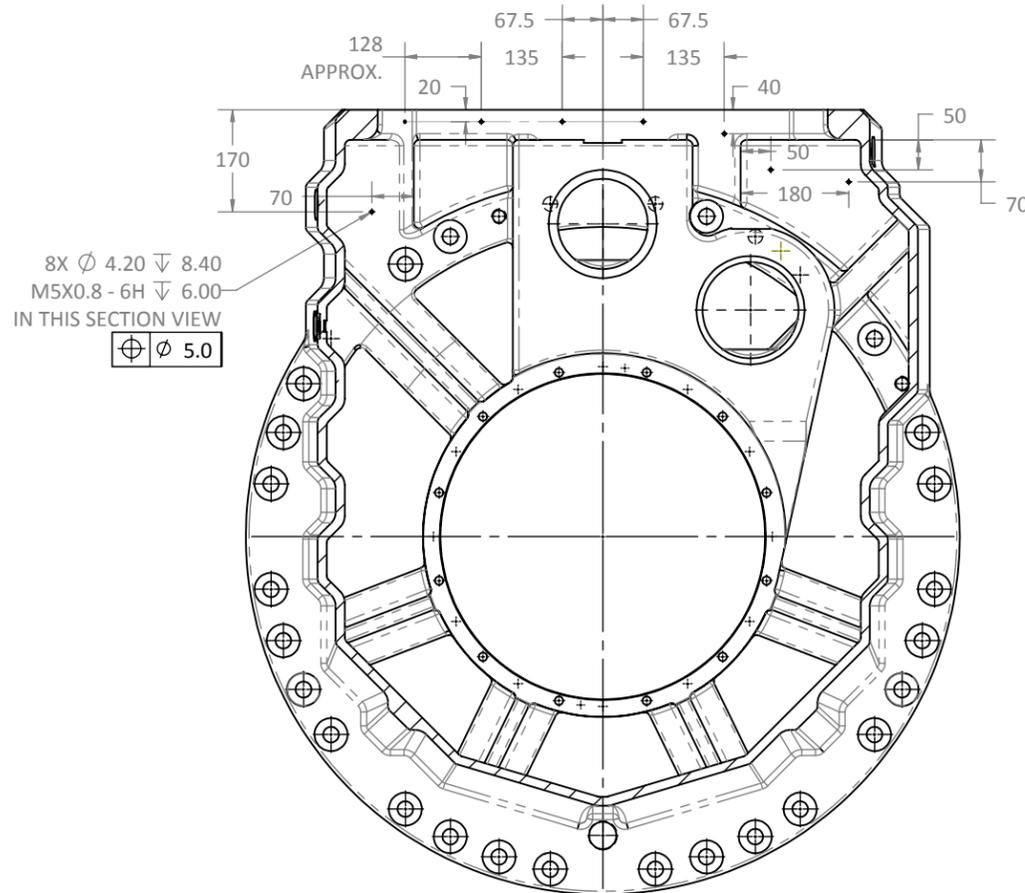
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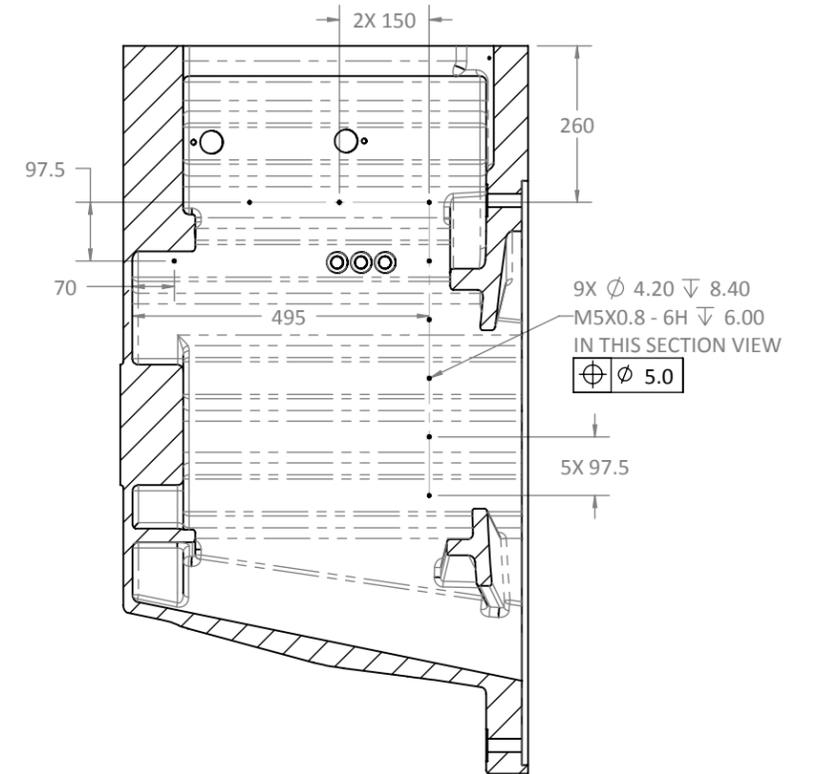
SECTION AM-AM



SECTION AN-AN



SECTION AP-AP



SECTION AL-AL

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