

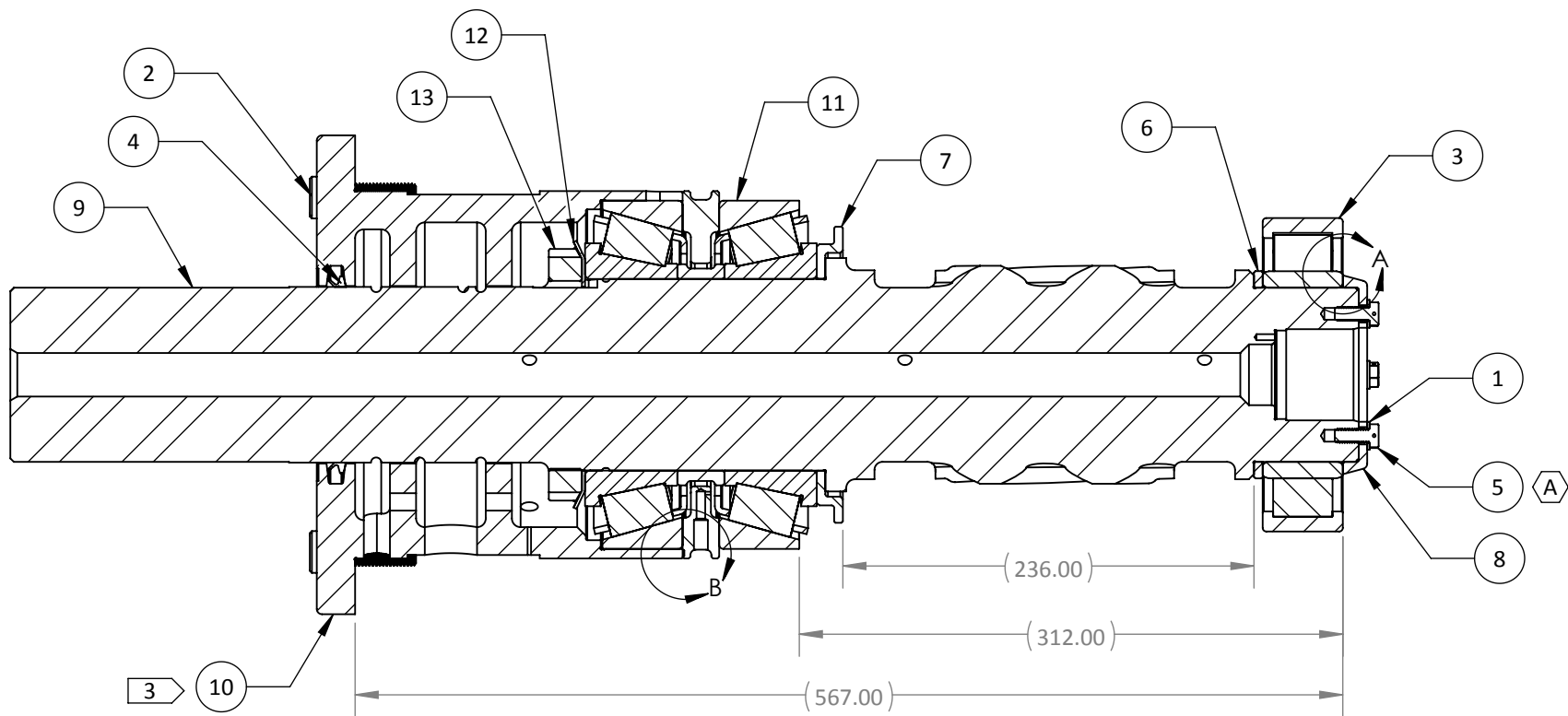
FILL THIS PROFILE AND
ADJACENT FACES WITH
SUITABLE GREASE
COMPATIBLE OIL.

DETAIL A
SCALE 1 : 1

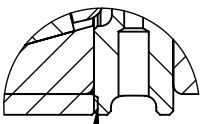
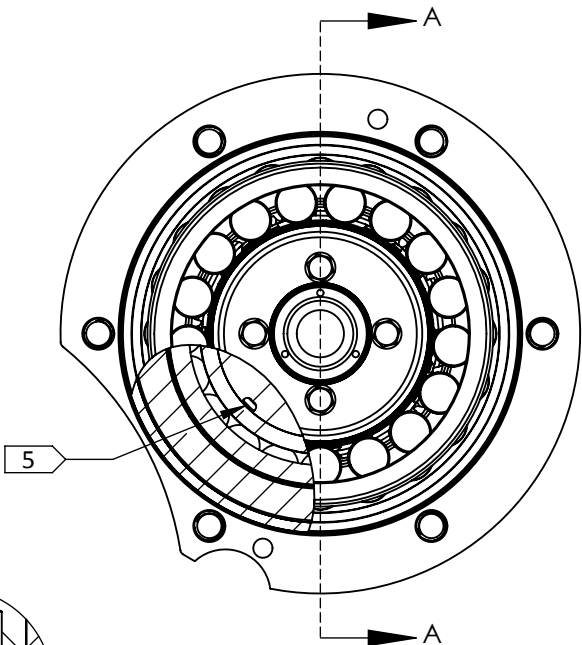
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	90097	WASHER, FLAT,PLAIN, STEEL,M8	4
2	90490	SOC HD CAPSCREW, M16 x 45 GR 8.8	6
3	93229	BEARING HSS - A	1
4	98218	HSS V RING 100_VA_V_HIHI	1
5	98225	HEX HD CAPSCREW, M8x20, DRILLED HD, GRADE 5	4
6	254558	PLATE, BEARING BAFFLE	1
7	254559	SHIELD, BEARING OIL	1
8	254509	IM SHAFT - LEADING END CAP	1
9	254517	SHAFT, PINION, HIGH SPEED	1
10	254551	HSS END COVER	1
11	254623	BEARING ASSEMBLY, HS SHAFT	1
12	99902	WASHER, LOCK, MB 22	1
13	99901	NUT, LOCK, KM 22	1

TORQUE VALUES (LUBED):

A ITEM # 6: 27.3 Nm



SECTION A-A
SCALE 1 : 4



DETAIL B
SCALE 1 : 2

NOTES:

1. APPLY LOCTITE 577 THREAD SEALANT ON ALL THREADS PER MFG. INSTRUCTIONS.
2. WIRE TIE ITEM # 6 AFTER APPLING PROPER TORQUE TO BOLTS. USE \varnothing 1mm 302/304 STAINLESS STEEL WIRE. APPLY PER STD. ACCEPTABLE PROCEDURES.
3. ADJUST LENGTH OF END COVER 254551, ITEM 11, AT FINAL ASSEMBLY TO SPECIFICATION ON DRAWING 254719.
4. INSTRUMENTATION TO BE COMPLETED PRIOR TO ASSEMBLY PER LAYOUT DRAWINGS 1551-LY-301, 1551-LY-302, 1551-LY-303, 1551-LY-304, 1551-LY-801, AND 1551-LY-901.
5. DURING ASSEMBLY OF TAPERED BEARING SET, INSTRUMENTATION GAUGES ADHERED TO BEARING BORE MUST ALIGN WITH AXIAL GROOVE OF HIGH SPEED SHAFT, P/N 254517, TO AVOID DAMAGING GAUGES.

3 FINAL ASSEMBLY
MACHINING REQUIRED

MAKE FROM MODEL: 1509-AS-005-B

REV	CHANGED FROM	BY	DATE	APRD	REPORT ERRORS & CHANGES REMOVE ALL BURRS AND SHARP EDGES DIMENSIONS ARE IN MILLIMETERS. UNSPECIFIED TOLERANCES: DECIMALS: FINISH: ANGLES:	National Renewable Energy Laboratory		
A	PRE-RELEASE, REVIEWED PER 1509-ENC-004	CPS	1/14/13		X. ± 1.0 .X ± 0.5 .XX ± 0.25 6.3 μ m Ra $\angle \pm 0.5^\circ$	TITLE: HIGH SPEED SHAFT ASSEMBLY		
B	UPDATE BORDER	CPS	2/27/13		COPYRIGHT © NOT TO BE REPRODUCED OR USED TO MAKE OTHER DRAWINGS OR MACHINERY	SIZE B	DWG. NO. 254593	REV F
C	UPDATE PER 1509-DDS-018-A03 & 1509-DDS-024. RELEASE FOR PRODUCTION	CPS	4/18/13			SCALE: 1:8	WEIGHT: 84.44 kgs	SHEET 1 OF 1
D	REPAIR DANGLING DIMENSION LEADERS	JMG	10/18/13		DRAWN CPS	DATE: 1/14/13		
E	CHANGES PER MANUFACTURER REVIEW AND INSTRUMENTATION	CPG	3/20/14		CHECKED NJB	THIRD ANGLE PRJ		
F	CHANGES PER MFG REVIEW	CPG	1/20/16					