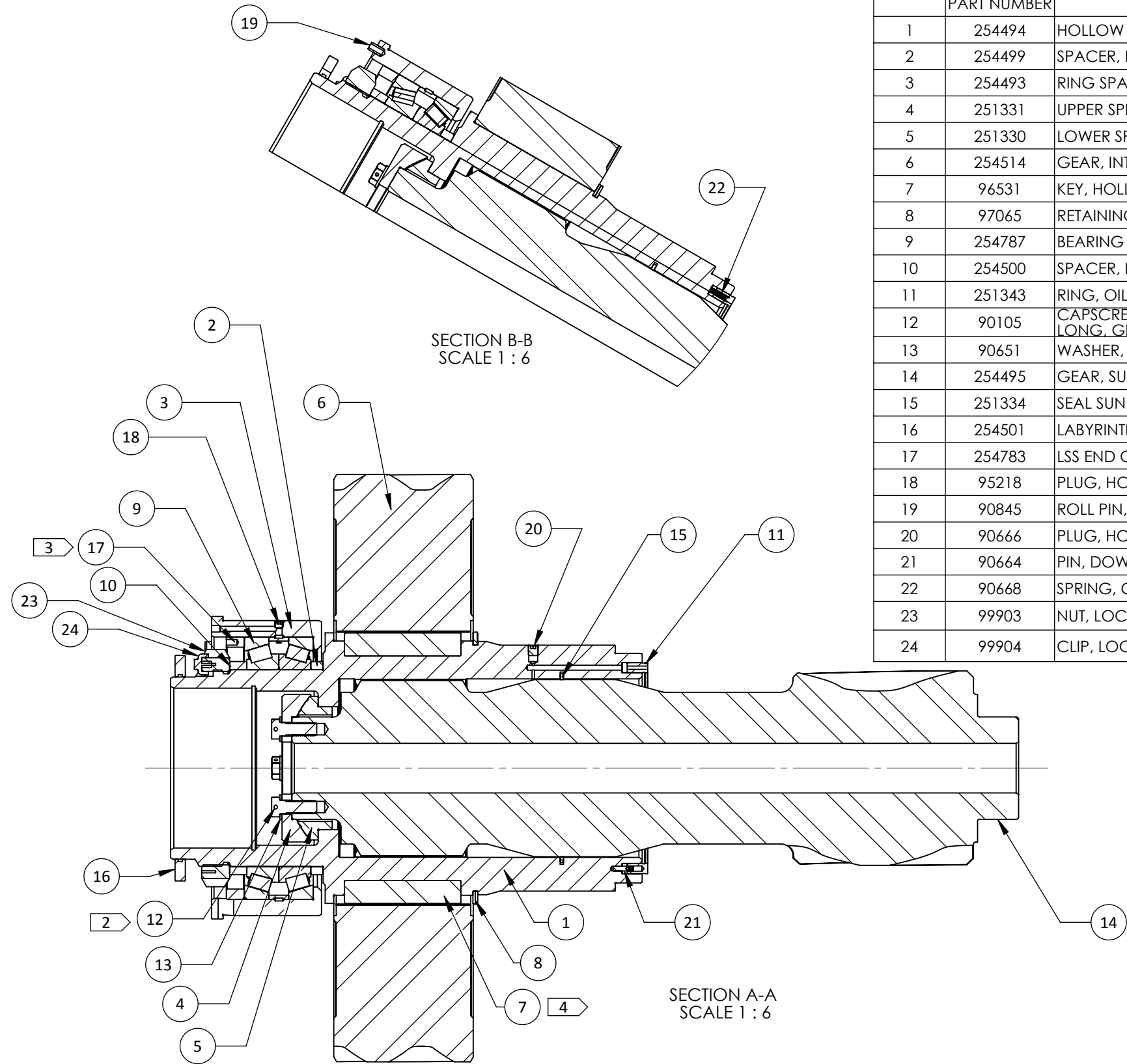


NOTES:

1. APPLY LOCTITE 577 THREAD SEALANT ON ALL THREADS PER MFG. INSTRUCTIONS.
2. WIRE TIE ITEM 1 AFTER APPLYING PROPER TORQUE TO BOLTS. USE \varnothing 1mm 302/304 STAINLESS STEEL WIRE.
3. ADJUST WIDTH OF 254783 SPACER, ITEM 18, AT FINAL ASSEMBLY TO SPECIFICATION ON DRAWING 254719.
4. FIT GEAR WHEEL TO KEYS ON FINAL ASSEMBLY
5. LUBRICATION SYSTEM TO BE FLUSHED CLEAN PRIOR TO ASSEMBLY.



	PART NUMBER	DESCRIPTION	QTY.
1	254494	HOLLOW SHAFT - REMACHINED	1
2	254499	SPACER, LS SHAFT (UW)	1
3	254493	RING SPACER, TRB LS SHAFT	1
4	251331	UPPER SPHERICAL THRUST RING	1
5	251330	LOWER SPHERICAL THRUST RING	1
6	254514	GEAR, INTERMEDIATE (HOLLOW SHAFT)	1
7	96531	KEY, HOLLOW SHAFT GEAR	2
8	97065	RETAINING RING, EXTERNAL SPIRAL	1
9	254787	BEARING ASS'Y, HOLLOW SHAFT	1
10	254500	SPACER, LS SHAFT DW	1
11	251343	RING, OIL SUPPLY	1
12	90105	CAPSCREW, DRILLED HEX HEAD, M16-2 x 45 LONG, GRADE 8.8	4
13	90651	WASHER, FLAT, PLAIN, STEEL, M16	4
14	254495	GEAR, SUN	1
15	251334	SEAL SUN SHAFT - HOLLOW SHAFT	1
16	254501	LABYRINTH SEAL	1
17	254783	LSS END COVER SPACER	1
18	95218	PLUG, HOLLOW HEX, .125 NPT, ZINC PLATED	1
19	90845	ROLL PIN, 10 DIA X 18 LG	2
20	90666	PLUG, HOLLOW HEX, 1/4 -18 NPT, ZINC PLATED	1
21	90664	PIN, DOWEL, PULL, M6 x 24L, FLAT VENTED	3
22	90668	SPRING, COMPRESSION, MMC#9434K44	6
23	99903	NUT, LOCK, HM 3048	1
24	99904	CLIP, LOCK, MS 3052-48	1

MADE FROM: 1509-AS-003-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	CPS	1/14/13		X. ± 1.0 .X ± 0.5 .XX ± 0.25 6.3 $\mu\text{m Ra}$ COPYRIGHT © NOT TO BE REPRODUCED OR USED TO MAKE OTHER DRAWINGS OR MACHINERY	TITLE: HOLLOW SHAFT ASSEMBLY		
B	RELEASE FOR PRODUCTION	CPS	4/19/13			SIZE B	DWG. NO. 254713	REV F
C	REMOVE BALANCING REQUIREMENT	CPS	5/20/13		DRAWN CPS	DATE: 1/14/13		
D	REPAIR DANGLING NOTES	JMG	10/18/13		CHECKED NJB	THIRD ANGLE PRJ	SCALE: 1:10	WEIGHT: 606.96 kgs
E	CHANGES REQUESTED PER MANUFACTURER DRW REVIEW	CPG	12/11/13					
F	CHANGES PER MFG REVIEW	CPG	3/14/16					

SHEET 1 OF 1