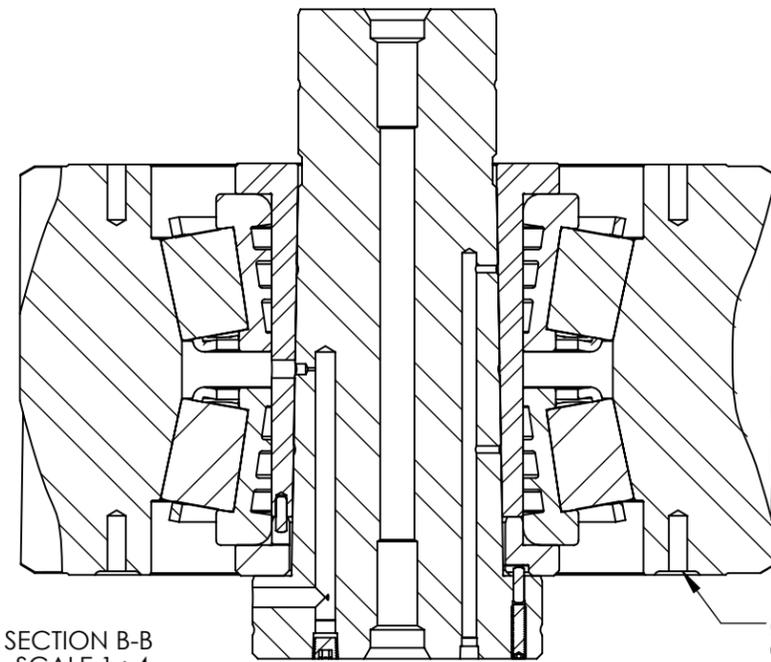


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	254504	PLANET GEAR	1
2	254710	SLEEVE ASS'Y, PLANET PIN BEARING	1
3	254711	RETAINER ASS'Y, PLANET PIN BEARING	1
4	254712	PIN ASS'Y, PLANET CARRIER	1
5	254786	BEARING ASS'Y, PLANET GEAR (CARRIER)	1



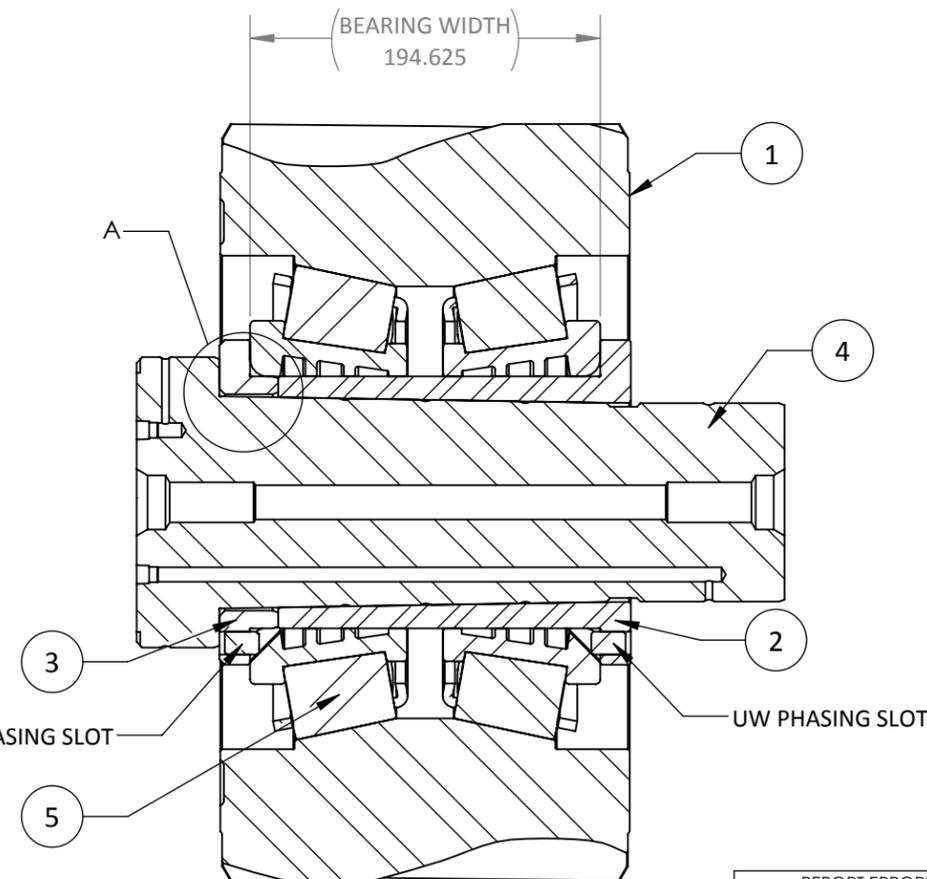
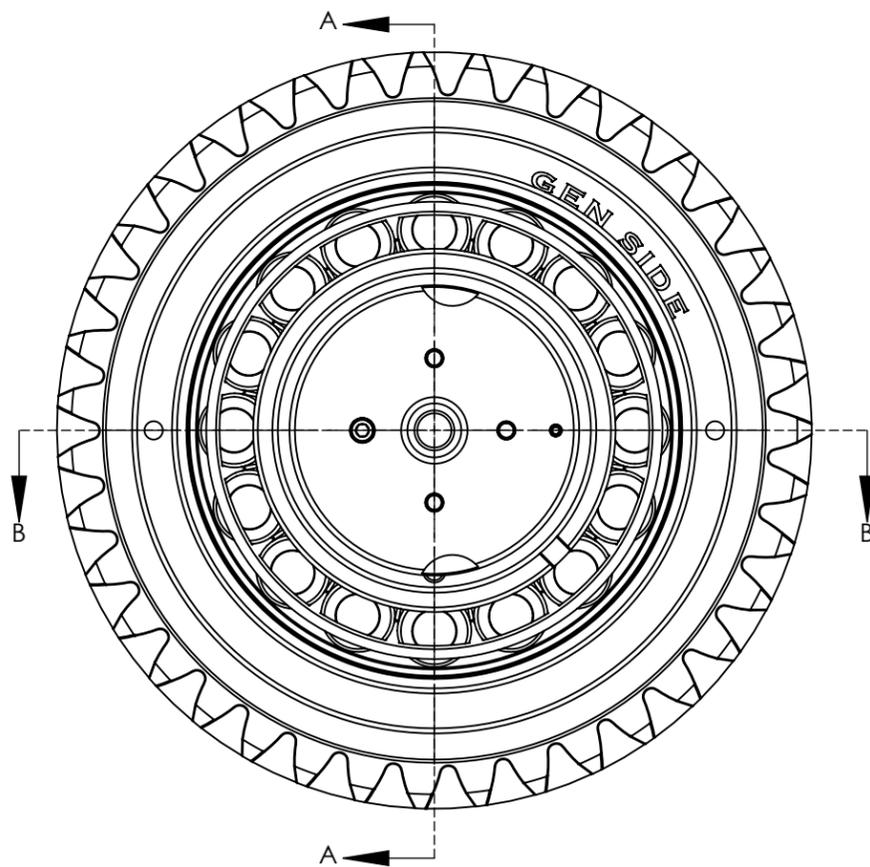
BRG LUB OIL CIRCUIT FEATURES

NOTES

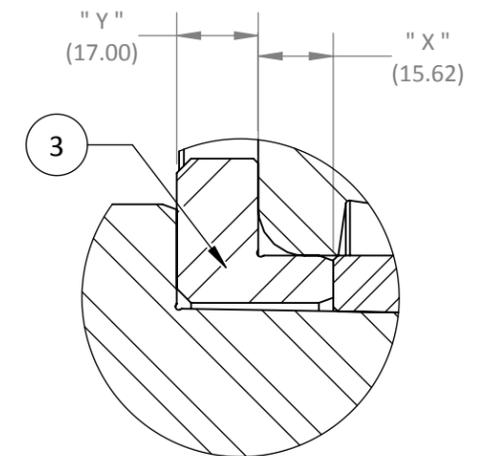
- THREE UNIQUE ASSEMBLIES REQUIRED - A, B & C - EACH WILL HAVE BESPOKE SETTINGS FOR FACES "X" AND "Y" ON ITEM #3 TO ACHIEVE PROPER BEARING PRE-LOAD BASED ON MFG RECOMMENDATION.
- FOR ASSEMBLY, SEE DOCUMENT 1509-DC-035 PLANET STAGE ASSEMBLY PROCEDURE.
- ITEMS IN EACH ASSY WILL REQUIRE A UNIQUE IDENTIFYING CODE.
- INSTRUMENTATION TO BE COMPLETED PRIOR TO ASSEMBLY PER LAYOUT DRAWINGS 1551-LY-201, 1551-LY-202, 1551-LY-203, AND 1551-LY-204.
- THE PLANET GEAR ASSEMBLY WITH THE MOST INSTRUMENTATION SHALL BE DESIGNATED AS UNIQUE ASSEMBLY "B" AND MUST BE INSTALLED INTO PLANET STATION "B" OF THE CARRIER.

SECTION B-B
SCALE 1 : 4

(2X) M12 THREADS THIS SIDE
ONLY FOR GEAR PULLER



SECTION A-A
SCALE 1 : 4



DETAIL A
SCALE 1 : 1.5

MAKE FROM MODEL 1509-AS-009-B

REV	CHANGED FROM	BY	DATE	APRD
B	CHANGES PER NREL DRW REVIEW, UPDATE BORDER	CPS	3/12/13	
C	RELEASE FOR PRODUCTION	CPS	4/19/13	
D	CHANGES PER MANUFACTURER REVIEW AND INSTRUMENTATION	CPG	3/19/14	
E	CHANGES PER MFG REVIEW	CPG	1/18/16	

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

X. ±1.0 6.3 $\sqrt{\mu\text{m Ra}}$ $\leq \pm 0.5^\circ$
.X ±0.5
.XX ±0.25

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OTHER DRAWINGS OR MACHINERY

DRAWN CPS DATE: 1/14/13
CHECKED NJB THIRD ANGLE PRJ

National Renewable Energy Laboratory

TITLE: **PLANET GEAR ASS'Y (CARRIER)**

SIZE **B** DWG. NO. **254595** REV **E**

SCALE: 1:4 WEIGHT: 198.95 kgs SHEET 1 OF 1