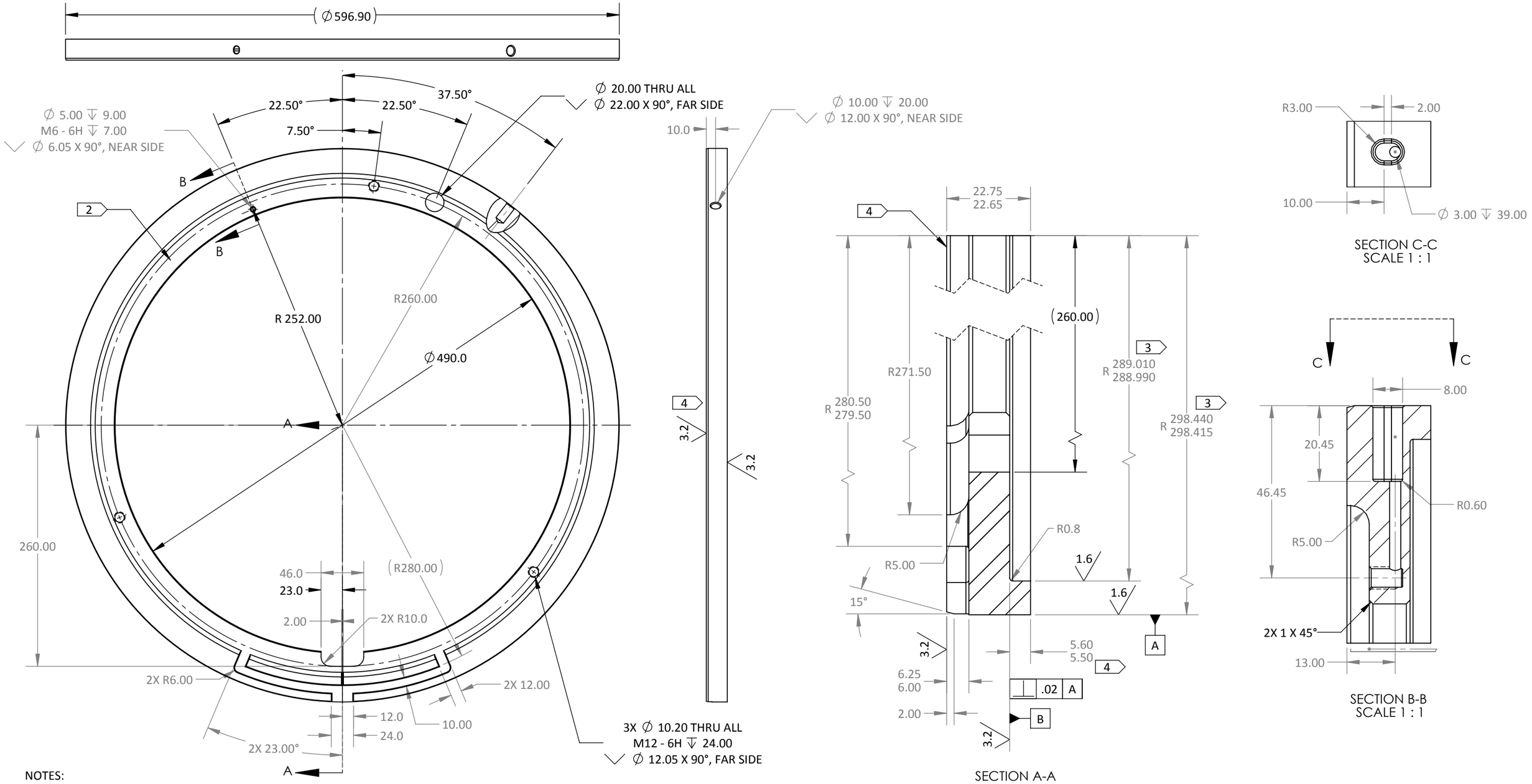

NOTES:

1. MATERIAL: AISI 4140H QUENCH AND TEMPER 32 - 37 Rc BAR OR FORGING, TEMPER 565 °C
2. IDENTIFY WITH PART NUMBER, REV LEVEL, SUPPLIER INITIALS, JOB NUMBER, AND SHOP ORDER NUMBER
3. STRESS RELIEVE AFTER ROUGH MACHINING, FINISH MACHINE
4. STOCK ALLOWANCE ON FACE AS SHOWN, TO BE GROUND OFF DURING TRB SET AT ASSEMBLY
5. NITRIDE ALL OVER EXCEPT THREADS, .2 - .3 EFFECTIVE DEPTH, MAX WHITE LAYER .007, MAX NITRIDING TEMPERATURE 553 °C. MASK ALL THREADS.

REV	CHANGED FROM	BY	DATE	APRD
B	MODIFIED DRAIN OPENINGS, ADDED RELIEF	JFC	10/26/12	
C	REVIEWED & UPDATED PER 1509-ENC-004	CPS	1/18/13	
D	REVIEWED & UPDATED PER 1509-DDS-016-D	CPS	2/25/13	
E	REQUESTED CHANGES AND RELEASE FOR PRODUCTION	CPS	4/22/13	
F	REPAIR DANGLING DIMENSION LEADER	JMG	10/17/13	
G	CHANGES REQUESTED PER MANUFACTURER DRW REVIEW	CPG	11/27/13	
H	CHANGED PER MFG REVIEW	CPG	1/19/16	

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	6.3 $\sqrt{}$ µm Ra	± 0.5°

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DRAWN	JFC	DATE: 8/27/12
CHECKED	NJB	THIRD ANGLE PRJ

National Renewable Energy Laboratory

TITLE: PLC BEARING OIL FEED / PRELOADER

SIZE	DWG. NO.	REV
B	254503	H

SCALE: 1:4	WEIGHT: 10.37 kgs	SHEET 1 OF 1