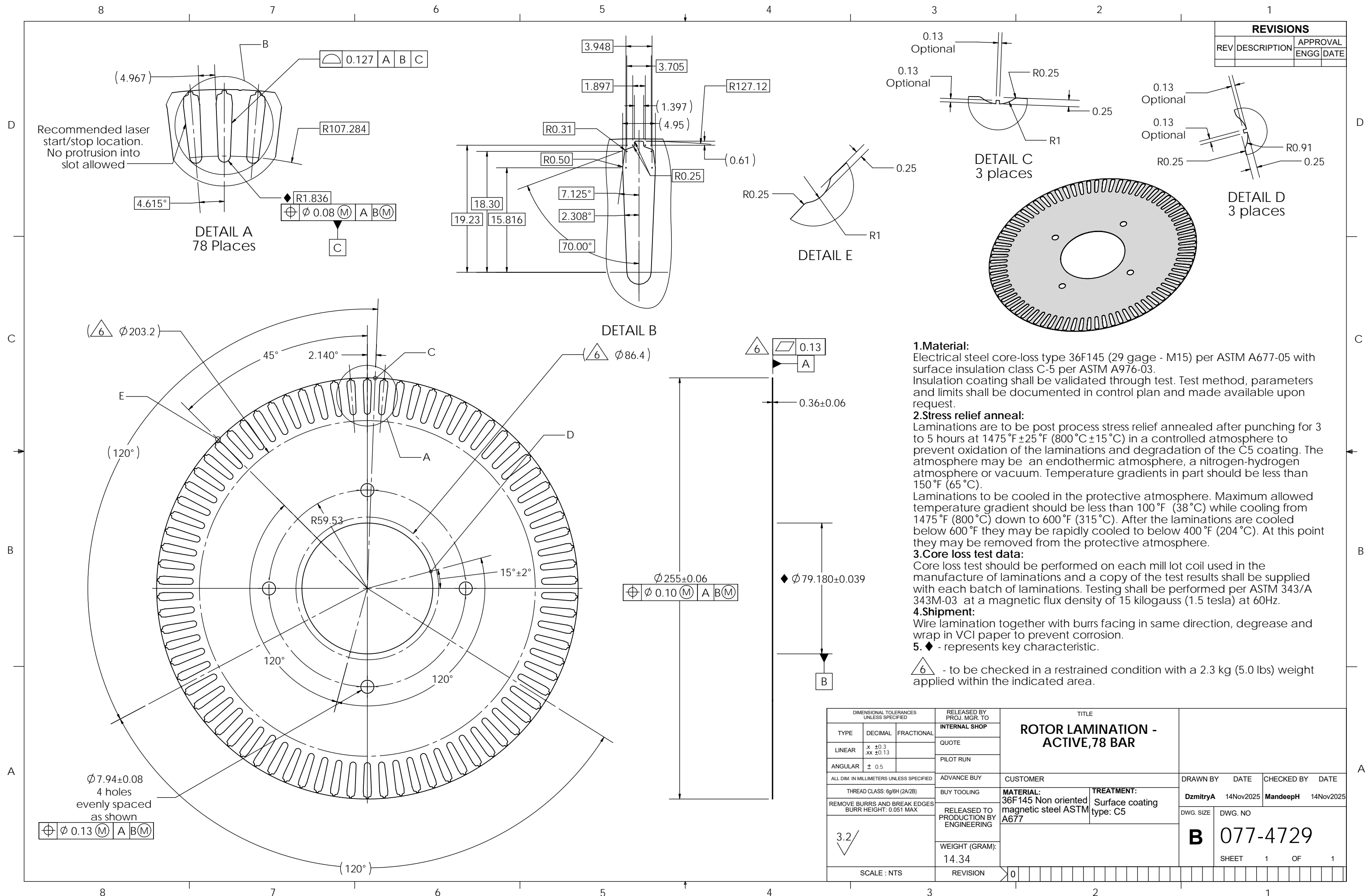


REVISIONS			
REV	DESCRIPTION	APPROVAL	ENG/DATE



**1. Material:**  
 Electrical steel core-loss type 36F145 (29 gage - M15) per ASTM A677-05 with surface insulation class C-5 per ASTM A976-03. Insulation coating shall be validated through test. Test method, parameters and limits shall be documented in control plan and made available upon request.

**2. Stress relief anneal:**  
 Laminations are to be post process stress relief annealed after punching for 3 to 5 hours at 1475 °F ±25 °F (800 °C ±15 °C) in a controlled atmosphere to prevent oxidation of the laminations and degradation of the C5 coating. The atmosphere may be an endothermic atmosphere, a nitrogen-hydrogen atmosphere or vacuum. Temperature gradients in part should be less than 150 °F (65 °C). Laminations to be cooled in the protective atmosphere. Maximum allowed temperature gradient should be less than 100 °F (38 °C) while cooling from 1475 °F (800 °C) down to 600 °F (315 °C). After the laminations are cooled below 600 °F they may be rapidly cooled to below 400 °F (204 °C). At this point they may be removed from the protective atmosphere.

**3. Core loss test data:**  
 Core loss test should be performed on each mill lot coil used in the manufacture of laminations and a copy of the test results shall be supplied with each batch of laminations. Testing shall be performed per ASTM 343/A 343M-03 at a magnetic flux density of 15 kilogauss (1.5 tesla) at 60Hz.

**4. Shipment:**  
 Wire lamination together with burrs facing in same direction, degrease and wrap in VCI paper to prevent corrosion.

**5. ♦ -** represents key characteristic.

△6 - to be checked in a restrained condition with a 2.3 kg (5.0 lbs) weight applied within the indicated area.

DIMENSIONAL TOLERANCES UNLESS SPECIFIED			RELEASED BY PROJ. MGR. TO		TITLE		DRAWN BY		DATE		CHECKED BY		DATE	
TYPE	DECIMAL	FRACTIONAL	INTERNAL SHOP		ROTOR LAMINATION - ACTIVE, 78 BAR		DzmitryA		14Nov2025		MandeepH		14Nov2025	
LINEAR	x ±0.3 xx ±0.13		QUOTE				Dwg. Size		Dwg. No		B		077-4729	
ANGULAR	± 0.5		PILOT RUN				MATERIAL:		TREATMENT:		SHEET		1 OF 1	
ALL DIM. IN MILLIMETERS UNLESS SPECIFIED			ADVANCE BUY		CUSTOMER		36F145 Non oriented magnetic steel ASTM A677		Surface coating type: C5		14		1	
THREAD CLASS: 6g/6H (2A/2B)			BUY TOOLING		RELEASED TO PRODUCTION BY ENGINEERING		WEIGHT (GRAM):		14.34		REVISION		0	
REMOVE BURRS AND BREAK EDGES BURR HEIGHT: 0.051 MAX					SCALE: NTS									