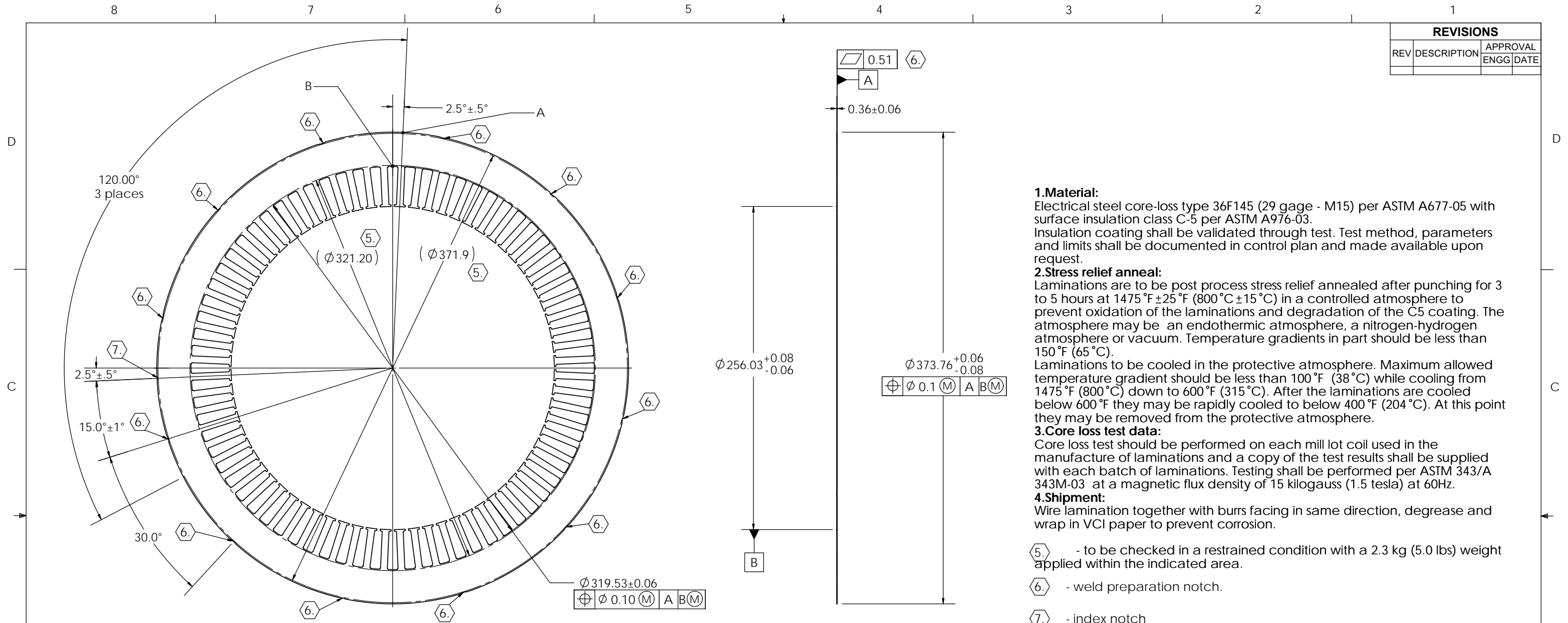


REVISIONS			
REV	DESCRIPTION	APPROVAL	DATE



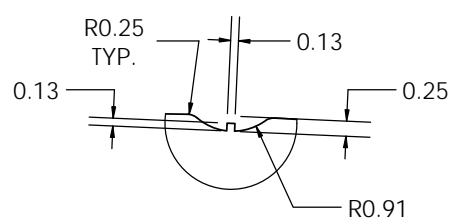
**1. Material:**  
Electrical steel core-loss type 36F145 (29 gage - M15) per ASTM A677-05 with surface insulation class C-5 per ASTM A976-03. Insulation coating shall be validated through test. Test method, parameters and limits shall be documented in control plan and made available upon request.

**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.

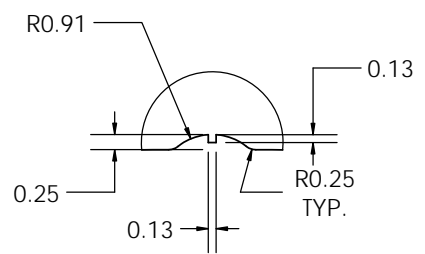
**3. Core loss test data:**  
Core loss test should be performed on each mill lot coil used in the manufacture of laminations and a copy of the test results shall be supplied with each batch of laminations. Testing shall be performed per ASTM 343/A 343M-03 at a magnetic flux density of 15 kilogauss (1.5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

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

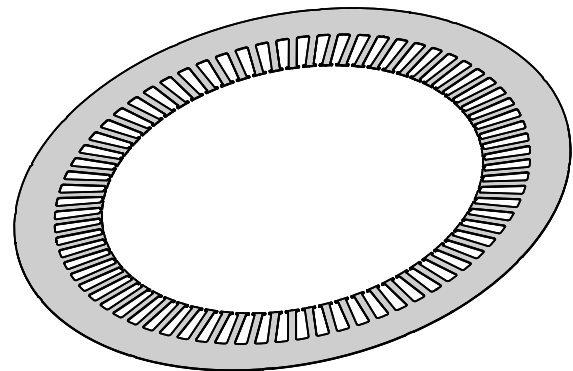
- 5. - to be checked in a restrained condition with a 2.3 kg (5.0 lbs) weight applied within the indicated area.
- 6. - weld preparation notch.
- 7. - index notch



DETAIL A  
3 places 120° apart

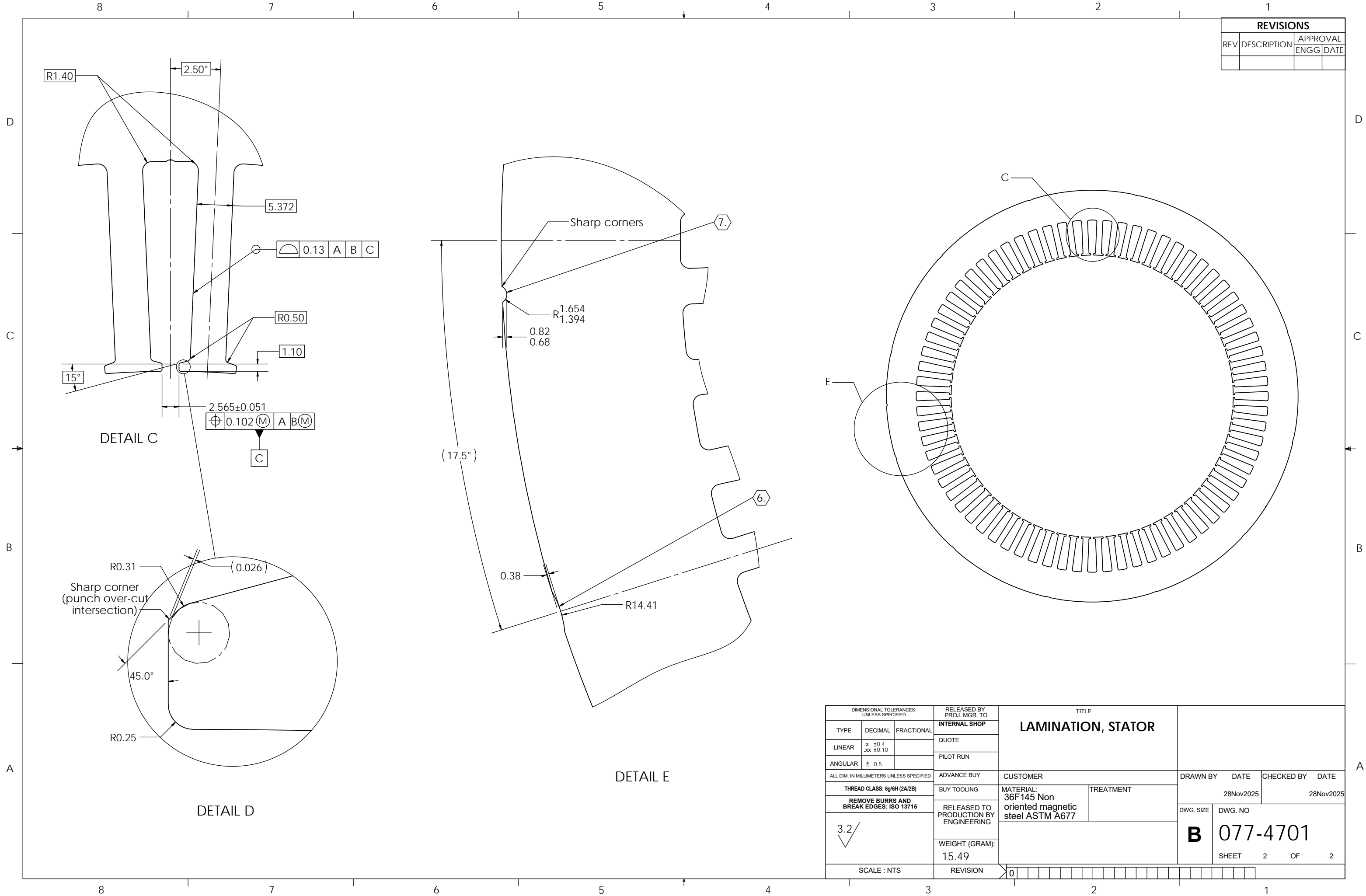


DETAIL B  
3 places 120° apart



DIMENSIONAL TOLERANCES UNLESS SPECIFIED			RELEASED BY PROJ. MGR. TO		TITLE		DRAWN BY DATE		CHECKED BY DATE	
TYPE	DECIMAL	FRACTIONAL	INTERNAL SHOP		LAMINATION, STATOR		28Nov2025		28Nov2025	
LINEAR	x ±0.4 xx ±0.10		QUOTE							
ANGULAR	± 0.5		PILOT RUN							
ALL DIM. IN MILLIMETERS UNLESS SPECIFIED			ADVANCE BUY		CUSTOMER		DWG. SIZE		DWG. NO	
THREAD CLASS: 6g/6H (2A/2B)			BUY TOOLING		MATERIAL: 36F145 Non oriented magnetic steel ASTM A677		TREATMENT		B 077-4701	
REMOVE BURRS AND BREAK EDGES: ISO 13715			RELEASED TO PRODUCTION BY ENGINEERING						SHEET 1 OF 2	
3.2/			WEIGHT (GRAM): 15.49							
SCALE: NTS			REVISION		0					

REVISIONS			
REV	DESCRIPTION	APPROVAL	
		ENGG	DATE



DIMENSIONAL TOLERANCES UNLESS SPECIFIED			RELEASED BY PROJ. MGR. TO		TITLE		DRAWN BY DATE		CHECKED BY DATE	
TYPE	DECIMAL	FRACTIONAL	INTERNAL SHOP		LAMINATION, STATOR		28Nov2025		28Nov2025	
LINEAR	x ±0.4		QUOTE							
ANGULAR	± 0.5		PILOT RUN							
ALL DIM. IN MILLIMETERS UNLESS SPECIFIED			ADVANCE BUY		CUSTOMER		DRAWN BY DATE		CHECKED BY DATE	
THREAD CLASS: 6g/6H (2A/2B)			BUY TOOLING		MATERIAL:		TREATMENT		DWG. NO	
REMOVE BURRS AND BREAK EDGES: ISO 13715			RELEASED TO PRODUCTION BY ENGINEERING		36F145 Non oriented magnetic steel ASTM A677				077-4701	
3.2			WEIGHT (GRAM):		15.49		SHEET		2 OF 2	
SCALE : NTS			REVISION		0					