PROJECT	**W9X**
TITLE	**Inspection protocol MAIN SHAFT COUPLING**
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VERSION	**1**
DOC. TYPE	TEST PROCEDURE

LEGAL NOTE

Translation of origin german document

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The document content describes iterative cases and results during the design process. Depending on status the present document is not finished. It may be not used as a product-accompanying document.

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Change Record

Version	Date	Change Description
1	28.08.2014	First issue

Content

Figures

1. Inspection of rotor coupling dimensions

The present document illustrates an amendment to the specification Main Shaft Coupling [1].

The defined values in the table below represent a basis of dimensions which should be included in an inspection protocol. Generally it has to be stated that the dimensions, position tolerances and form tolerances as well as information on surface finish defined in the technical drawing [2] have to be met and have to be controlled.

The layout of the inspection protocol can be designed differently than show exemplarily in the table below.

1.1. General information regarding the inspection

In order to check the surface roughness at minimum 10 measurement points distributed over the entire surface have to be measured.

1.2. Measurement of the axial run-out at the rotor bearing flange

For the length of the lifetime of the rotor bearing the axial run out of the main bearing surface at the main shaft is extremely important.

In case the defined value is exceeded, the corresponding surface has to be reworked as long as all tolerances and dimensions are met.

For the measurement of the axial run-out the flange surface of the main bearing at the main shaft should be divided evenly in 30 segments. In order to detect tilting or twisting of the surface, this surface shall be divided in an inner and outer ring as it can be seen in Figure 1. As a result of this 60 inspection points have to be defined for measuring the axial run-out.

The inspection points and corresponding values have to be provided in a separate protocol to the purchaser until no later than the delivery of the main shaft.

Component Main Shaft Coupling	Date of inspection:
Drawing no.: W0402-N042-000-001-001-01-DMDR-W2E	Inspector:
Revision:	Component no.:
	Page 1/1

Position GS	Detail/ Cut	Inspection criteria	Nominal dimension	Tolerance		Actual dimen-sion	Deviation	Comment
				LTL	UTL			
H-6	CUT A-A	BCDø	2010,00	-0,200	0,200			
H-9		BCDø	1180,00	-0,100	0,100			
H-6		ø	1935,00	-0,3	-0,1			
J-8		Length	673	-0,100	0,100			
A-6	Detail X	Angle	64	-0,100	0,100			
A-8		Angle	26	-0,100	0,100			
A-7		Length	261,3	-0,200	0,200			
B-6		Length	126,3	-0,200	0,200			
B-8		ø	202	0,000	1,0			
D-8		ø	132	0,000	0,100			
C-9		Length	120	0,000	0,100			
C-10		H7	128	0,000	0,040			
B-6		Axial run-out	0,1/ B					
C-10		Perpendiculaity	0,01/A					
B-7		Position	0,2/ B					
C-10		Position	0,1/ B					
B-7		Roughness	Ra3,2					
A-7		Roughness	Ra6,3					
C-8		Roughness	Ra6,3					
D-9		Roughness	Ra6,3					

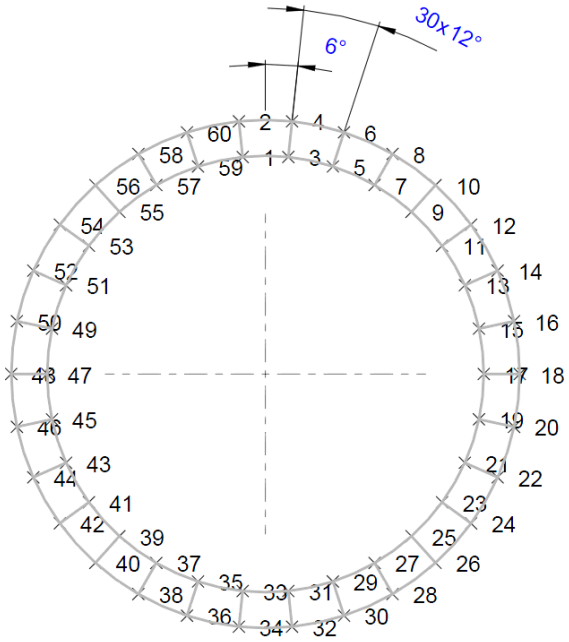

Figure 1: Distribution measurement point main frame

2. Abbreviation

Long form	Short form
Lower tolerance limit	LTL
Upper tolerance limit	UTL
Grid square	GS
Bolt circle diameter	BCD

3. Cross references

The technical data which are specified in this document will be extended by references to additional technical documents or drawings. The referenced documents are named via unique file names. They are named in a table below. This document will be updated to change a several modifications. The licenser has the discretionary authority for updates.

For following developments especially for components production the current state of development respectively of the referenced documents the licenser has to be requested.

References, dealing with product supporting documents of suppliers / manufacturers, are only used as exemplary explanation. The valid product documentation is part of the delivery.

No.	Document no. W2E, title	Classifikation	Additional information
[1]	W0402-N042-DASH-304-W2E-001	Customer	*Main Shaft Coupling*
[2]	W0402-N042-000-001-001-01-DMDR-W2E	Customer	*Rotor Coupling (low speed shaft)*