

## Safety Bulletin

No.: SB050

Rev: 2

Date: 03 June 2010

### 350/400-EXI-600 Blower Motor Upgrade Assembly Kit



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#### BACKGROUND INFORMATION:

An incident occurred where the mounting bolts securing the blower motor and fan housing to the main motor body sheared (Figure 3) during top drive operation, resulting in the blower motor assembly (Figure 1) becoming detached from the Ward Leonard 600HP induction motor (Figure 2) on the EXI-600 top drive assembly. This creates a high possibility of the motor falling onto the rig floor and causing serious injury to personnel and equipment damage.

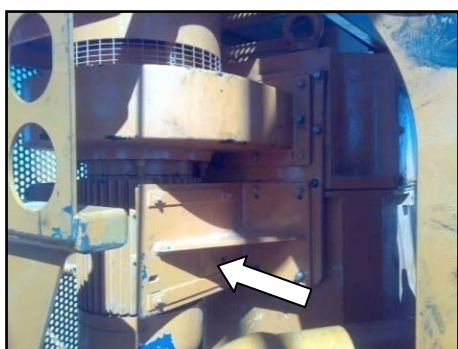


Figure 1: Blower motor assembly

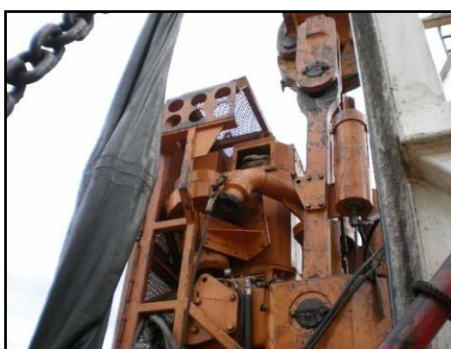


Figure 2: Blower motor assembly detached due to mounting bolts shearing



Figure 3: Sheared mounting bolts on 600HP induction motor air intake

#### AFFECTED PRODUCT:

All 350/400T-EXI-600 Top Drives.

#### ACTION REQUIRED:

TESCO has identified that the size and grade of the blower motor assembly mounting bolts is insufficient for its application, therefore upgrade kits have been created for all TESCO EXI-600 top drives. All customers operating EXI-600 top drives are to cease operations immediately and visually inspect for any sheared or loose bolts. Contact a local TESCO representative to obtain the applicable blower motor upgrade assembly kit, supplying the TESCO representative with the 600HP induction motor serial number.

Please note that the EXI-600 top drives have different Ward Leonard 600HP motor configurations. To assist TESCO in ensuring the proper upgrade kit is ordered, customers should verify whether the current motor has 8-bolt or 16-bolt configuration (Figure 3) securing the blower motor assembly, in addition to supplying TESCO with the motor serial number.

The following blower motor upgrade assembly kits are available from TESCO:

1. TPN 5001985 Kit, Upgrade, blower motor, MK1 (original 16-bolt configuration)
2. TPN 5001986 Kit, Upgrade, blower motor, MK2 (original 16-bolt configuration)
3. TPN 5001964 Kit, Upgrade, blower motor, MK3 (original 8-bolt configuration)

If drilling operations must resume, TESCO strongly recommends that all 5/16” Grade 5 mounting bolts be replaced with 5/16” Grade 8 mounting bolts, loctite and lock-wired, as a temporary solution while waiting on the upgrade kit. In addition, the blower motor assembly shall be secured via secondary retention (Figure 4) in the event the higher grade bolts shear, thus preventing any possibility of the blower motor assembly from falling to the rig floor.

**NOTE:** This is only temporary solution to secure the blower motor assembly. Reference step 13, Appendix A, on how to permanently secure the blower motor assembly using a lanyard.



Figure 4: Securing the blower motor assembly using a wire rope sling as a secondary retention

#### ADDITIONAL INFORMATION:

- For blower motor upgrade installation instructions, reference Appendix A
- For cross-referencing upgrade kit to 600HP induction motor serial number, reference Table 1, Appendix A
- For detailed Bill of Materials, reference Appendix B
- For blower motor assembly fabrication drawings, reference Appendix C

Version	Date (D/M/Y)	Description of Changes
Rev 0	12/05/2010	Initial release of document
Rev 1	25/05/2010	Revised installation instructions; added reference chart for ordering blower motor upgrade assembly kit; updated bill of materials
Rev 2	03/06/2010	Added torque values for tightening bolts; added lanyard reference to secure motor blower assembly; updated bill of materials

Contact your local TESCO Parts and Service Center for further information regarding this bulletin and or supply of affected components noted above.

## APPENDIX A: Installation Instructions

1. Lock out the top drive as per the EXI-600 Maintenance Manual.
2. Remove all blower motor electrical wiring.
3. Remove the blower motor assembly complete with blower motor adapter plate and blower motor mount (Figure 5).

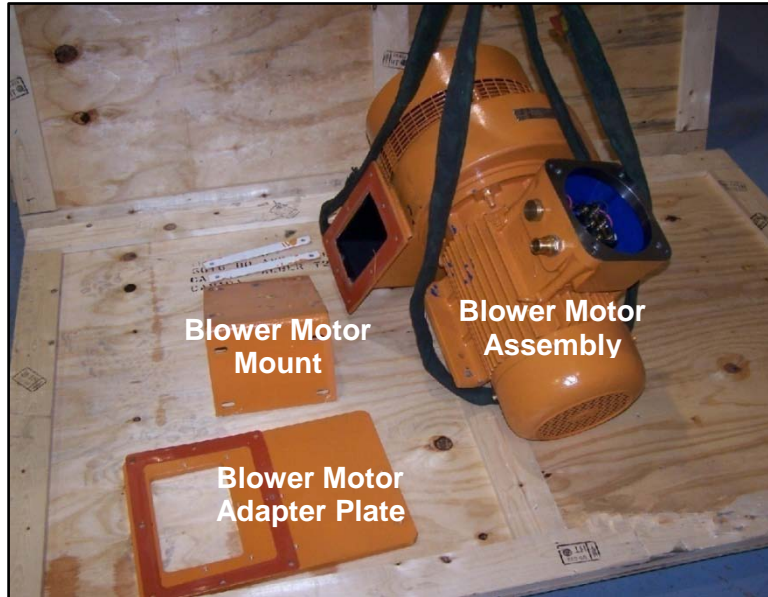


Figure 5: Blower motor assembly, blower motor mount, and blower motor adapter plate shown

4. Drill seven of eight holes in the blower motor plenum mounting plate to drill size W with the exception of one hole as shown in Figure 6, which remains the same size.
5. Most existing blower motors will accommodate the 3/8" bolts; if required, enlarge the blower motor mounting feet to accommodate the 3/8" bolts with a size W drill bit.

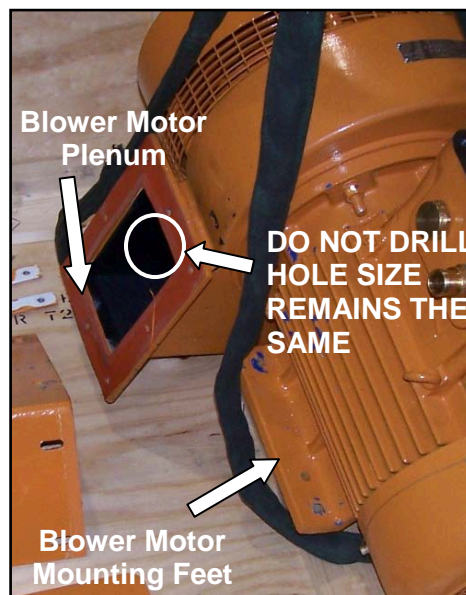


Figure 6: Blower motor plenum and mounting feet

6. a) Drill two holes on the induction motor air intake to 5/16", utilizing the adjustable drill stop (PN 5001962) set to 1" from the tip of the drill bit (Figure 8). Use a rare earth magnet (PN 15524) to reduce the likelihood of metal filings entering the motor while drilling. TESCO recommends drilling holes in the opposite corners as shown in Figure 7.



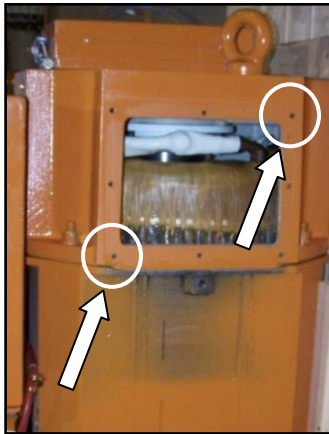


Figure 7: Induction motor air intake



Figure 8: Adjustable drill stop

- b) Tap the two 5/16" holes to 3/8" utilizing the UNC bottom tap (PN 4199).
7. a) Secure the blower motor adapter plate to the induction motor air intake with two 3/8" bolts.  
 b) With the blower motor adapter plate as a template (Figure 9), drill the remaining 14 holes to 5/16" on the induction motor air intake using a magnetic base drill press and a rare earth magnet to reduce the likelihood of metal filings entering the motor while drilling. Utilize the adjustable drill stop set to 1" as in step 6.  
 c) Remove the blower motor adapter plate and tap the 5/16" holes to 3/8" using the UNC bottom tap.

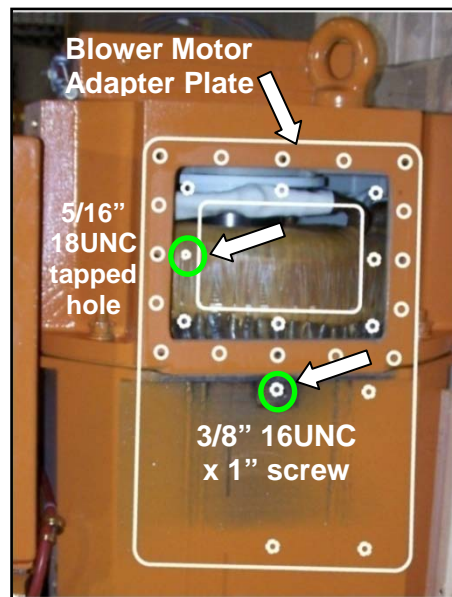
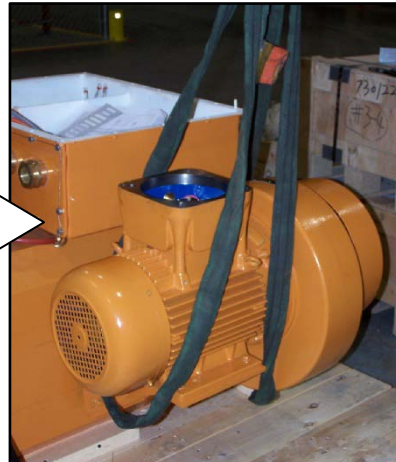


Figure 9: Motor and new adapter plate  
 (plate is shown as a white outline for reference only)

8. Use RTV sealant (PN 9119) (DO NOT utilize a gasket) to seal and install the new blower motor adapter plate onto the induction motor air intake (Figure 9) utilizing 3/8" x 1-1/4" Grade 8 drilled head bolts and 3/8" washers. Loctite with blue 242 loctite and install safety wire.
9. Use RTV sealant (DO NOT utilize a gasket) to seal and install the blower motor assembly (Figure 10) onto the new blower motor adapter plate (Figure 11) utilizing seven 3/8" x 1" Grade 8 drilled head bolts and 3/8" washers and one 5/16" x 1" Grade 8 drilled head bolt and 5/16" washer. Loctite with blue 242 loctite and install safety wire.

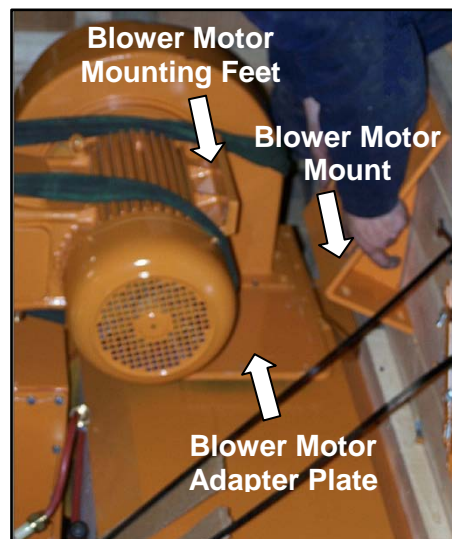


**Figure 10: Blower motor assembly (blower motor adapter plate not shown)**



**Figure 11: Blower motor assembly with new blower motor adapter plate installed**

10. a) Install the new blower motor mount (PN 5001963/5001983) to the new blower motor adapter plate using three 3/8" x 1-1/4" and one 3/8" x 1" (Figure 9) Grade 8 drilled head bolts and 3/8" washers. Do not tighten.
- b) Install four 3/8" x 2-1/2" drilled thread bolts (with nut and cotter pin) and 3/8" washers securing the blower motor mounting feet to the blower motor mount. Do not tighten.
- c) Re-position and align the blower motor mount and tighten all bolts. Torque all bolts according to the following:
  - One 5/16"-18UNC (blower motor to blower motor adapter plate) = 19 ft-lb
  - Sixteen 3/8"-16UNC (blower motor adapter plate to 600HP induction motor) = 33-35 ft-lb
  - Fifteen 3/8"-16UNC (all remaining bolts) = 40 ft-lb
 Loctite with blue 242 loctite and install safety wire and cotter pins. See Figure 12.



**Figure 12: Blower motor mount installed to the new blower motor adapter plate**

11. Ensure all safety wire has been installed or install now, prior to going to step 12.
12. Re-wire the blower motor and test for correct clockwise rotation (from bottom).
13. Remove the 600HP induction motor lifting lug and blower motor lifting lug and apply blue 242 loctite to the threads of each lifting lug and re-install. Install the lanyard (PN 5002235) and the two shackles (PN 341009 for induction motor and PN 16764 for the blower motor) onto the respective induction motor and blower motor lifting lugs. It is not necessary to choke the motor using the lanyard.

**TABLE 1: Cross-Reference Chart for Ordering Blower Motor Upgrade Assembly Kit**

<b>600HP Induction Motor Serial Number</b>	<b>8-Bolt Configuration</b>	<b>Blower Motor Upgrade Kit Required (TESCO Part Number)</b>
0101M119420	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0102M119420	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0103M119420	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0201M119420	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0202M119420	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0101M119199	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0102M119199	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0201M119199	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0301M119199	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0302M119199	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0401M119199	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0402M119199	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0101M119757	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
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0101M119764	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0102M119764	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0101M119765	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0102M119765	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0101M119766	8	TPN 5001964 Kit,Upgrade,blower motor,MK3
0102M119766	8	TPN 5001964 Kit,Upgrade,blower motor,MK3

<b>600HP Induction Motor Serial Number</b>	<b>16-Bolt Configuration</b>	<b>Blower Motor Upgrade Kit Required (TESCO Part Number)</b>
0101M118181	16	TPN 5001985 Kit,Upgrade,blower motor,MK1
0102M118181	16	TPN 5001985 Kit,Upgrade,blower motor,MK1
0101M118491	16	TPN 5001986 Kit,Upgrade,blower motor,MK2
0102M118491	16	TPN 5001986 Kit,Upgrade,blower motor,MK2
0201M118491	16	TPN 5001986 Kit,Upgrade,blower motor,MK2
0202M118491	16	TPN 5001986 Kit,Upgrade,blower motor,MK2
0301M118491	16	TPN 5001986 Kit,Upgrade,blower motor,MK2
0302M118491	16	TPN 5001986 Kit,Upgrade,blower motor,MK2
0401M118491	16	TPN 5001986 Kit,Upgrade,blower motor,MK2
0402M118491	16	TPN 5001986 Kit,Upgrade,blower motor,MK2

**APPENDIX B: Detailed Bill of Materials for Blower Motor Upgrade Assembly Kit**

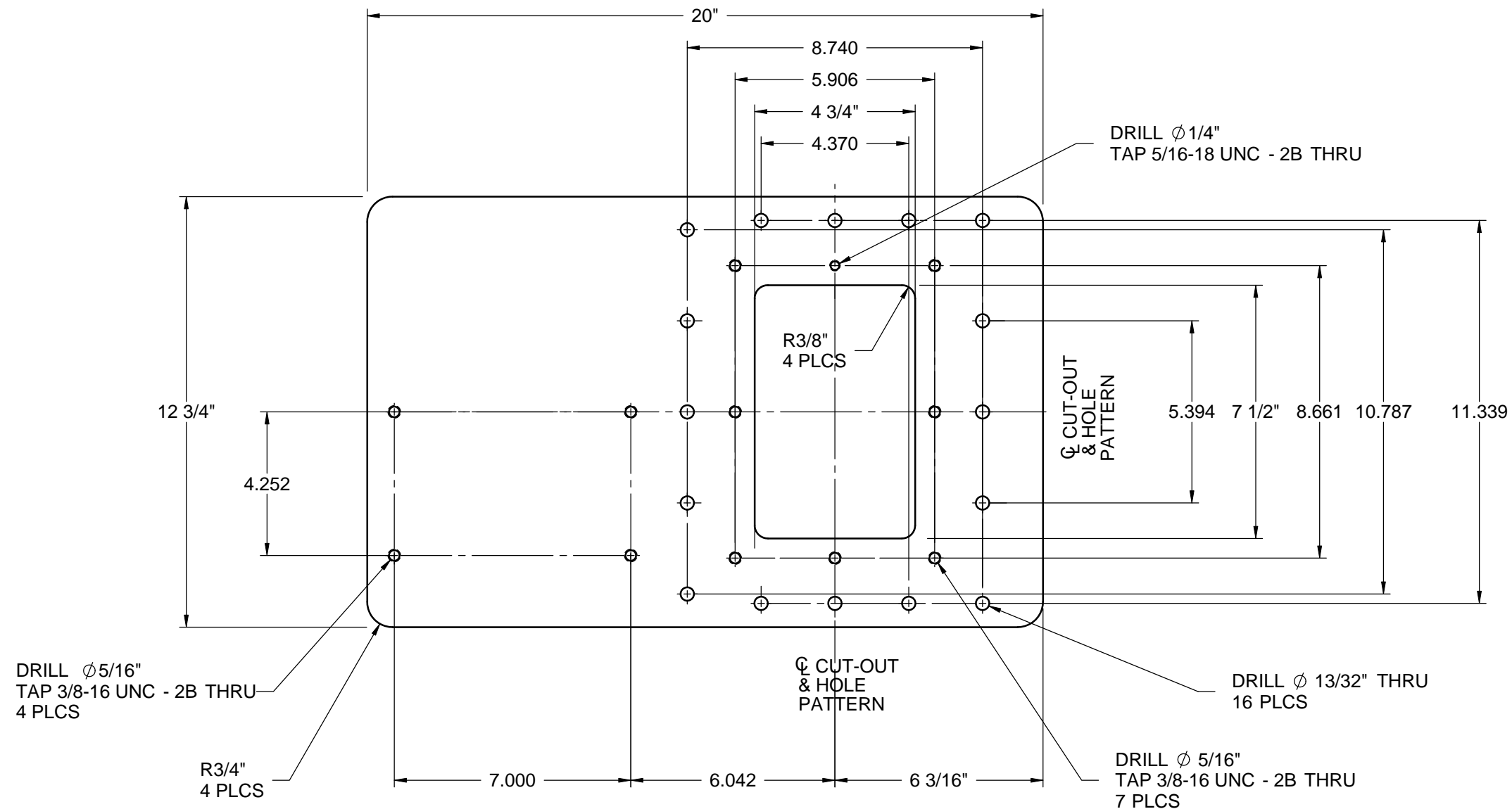
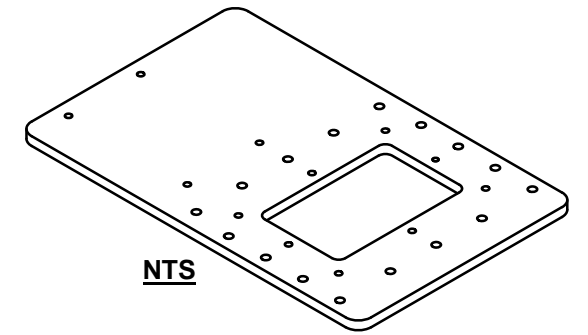
- TPN 5001985 Kit,Upgrade,Blower Motor,MK1 (original 16-bolt configuration)
- TPN 5001986 Kit,Upgrade,Blower Motor,MK2 (original 16-bolt configuration)
- TPN 5001964 Kit,Upgrade,Blower Motor,MK3 (original 8-bolt configuration)

Assembly Kit	TESCO PN	Quantity	TESCO Description
5001964	5001960	1	Plate,Adapter,Blower Motor,EXI-600,MK3
5001964/5001986	5001963	1	Mount,Blower Motor,EXI-600,MK2 & MK3
5001985	5001982	1	Plate,Adapter,Blower Motor,EXI-600,MK1
5001985	5001983	1	Mount,Blower Motor,EXI-600,MK1
5001986	5001961	1	Plate,Adapter,Blower Motor,EXI-600,MK2
5001964/5001985/5001986	2861	1	BIT,JOBBER,DRILL,HSS,A150,5/16
5001964/5001985/5001986	17604	1	Bit,Drill,Straight Shank,Twist Drill,Size W
5001964/5001985/5001986	15524	1	Magnet,1"ODx1/4Thick
5001964/5001985/5001986	4199	1	TAP,BOTTOM,NC,3/8B
5001964/5001985/5001986	5001962	1	Drill Stop,Adjustable
5001964/5001985/5001986	9119	1	Silicone,Clear,RTV
5001964/5001985/5001986	5965	20	Screw,Cap,Hex Hd,3/8"-16UNCx1-1/4",Gr8,Pld,Dr Hd
5001964/5001985/5001986	3725	10	Screw,Cap,Hex Hd,3/8"-16UNCx1",Gr8,Pld,Dr Hd
5001964/5001985/5001986	970132	4	Screw,Cap,Hex Hd,3/8"-16UNCx2-1/2",Gr8,Pld,Dr Thd
5001964/5001985/5001986	4333	4	Nut,Hex,Lock,Nylon,3/8"-16UNC,Gr8,Pld
5001964/5001985/5001986	15608	4	Pin,Cotter,3/32"ODx3/4"Lg,Pld
5001964/5001985/5001986	1649	1	SEALANT,LOCTITE,BLUE,T-LOCK242,REMV,50ML
5001964/5001985/5001986	4398	1	Wire,Lock,18Ga(0.0403"Dia),100-ft Spool
5001964/5001985/5001986	10632	40	Washer,Flat,Type A,Narrow,3/8",Hardened,Pld
5001964/5001985/5001986	341009	1	Shackle,Screw Pin Anchor,S-209,5/8",3-1/4 Ton
5001964/5001985/5001986	13566	1	Screw,Cap,Hex Hd,5/16"-18UNCx1",Gr8,Pld,Dr Hd
5001964/5001985/5001986	16585	1	Washer,Flat,Type A,Narrow,5/16",Hardened,Pld
5001964/5001985/5001986	5002235	1	Lanyard,Wire Rope,3/16",Coated,840lb,Loop Fitting,4ft
5001964/5001985/5001986	16764	1	Shackle,Anchor,Bolt-Type,G-2130,3/8",1 Ton




**APPENDIX C: Fabrication Drawings for Blower Motor Upgrade Assembly Kit**

Part/DWG No.	Drawing Title
5001960	Plate,Adapter,Blower Motor,EXI-600,MK3
5001963	Mount,Blower Motor,EXI-600,MK2 & MK3
5001982	Plate,Adapter,Blower Motor,EXI-600,MK1
5001983	Mount,Blower Motor,EXI-600,MK1
5001961	Plate,Adapter,Blower Motor,EXI-600,MK2

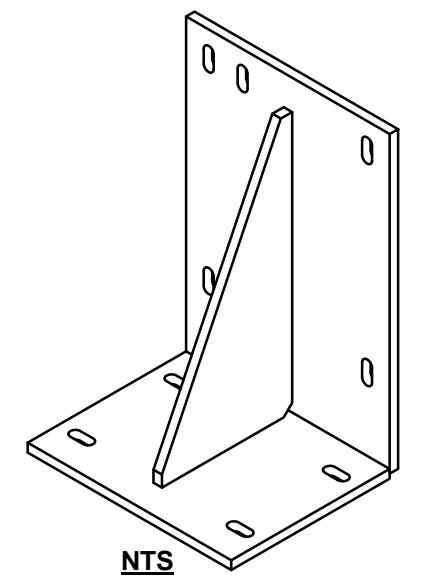
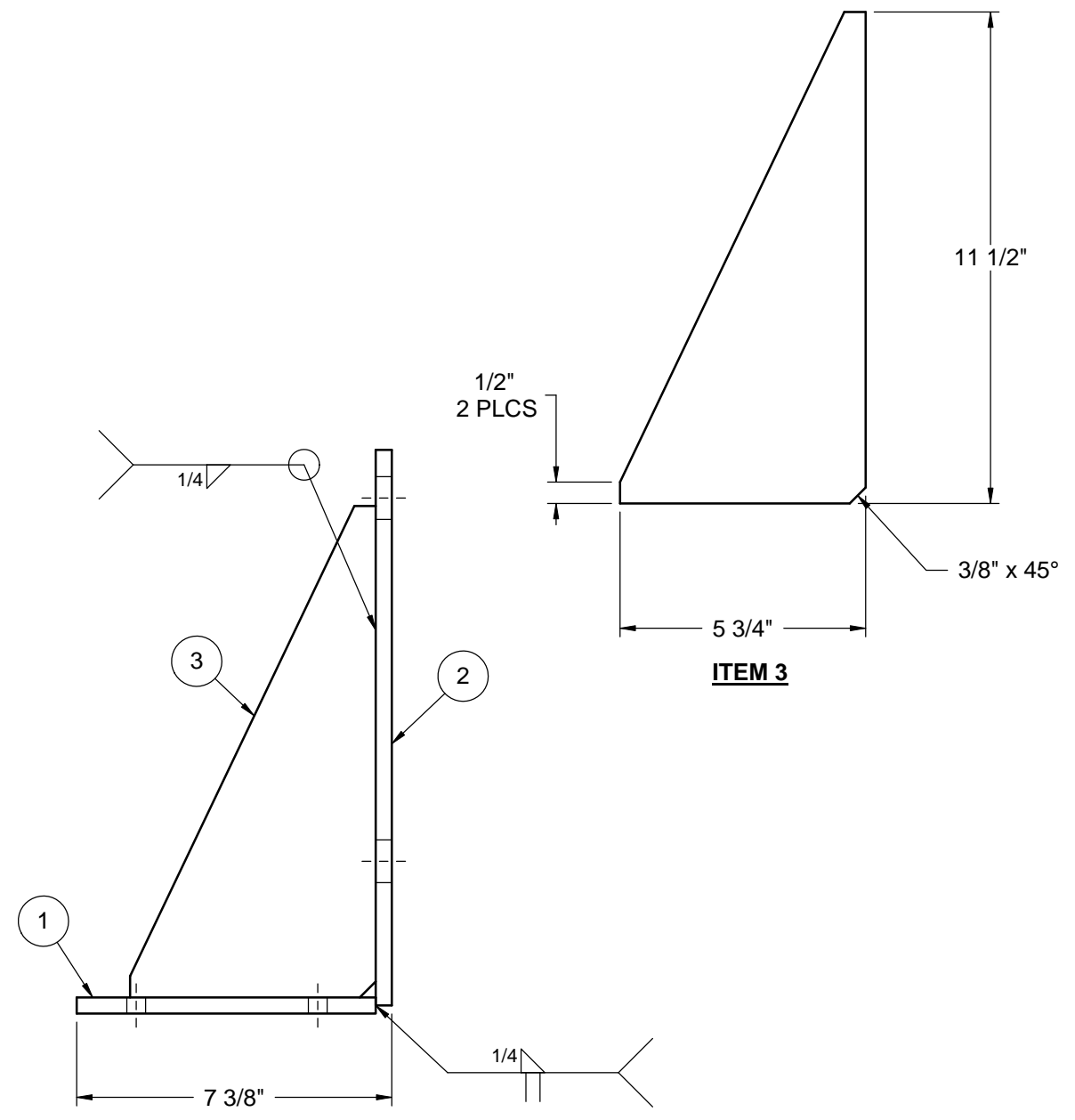
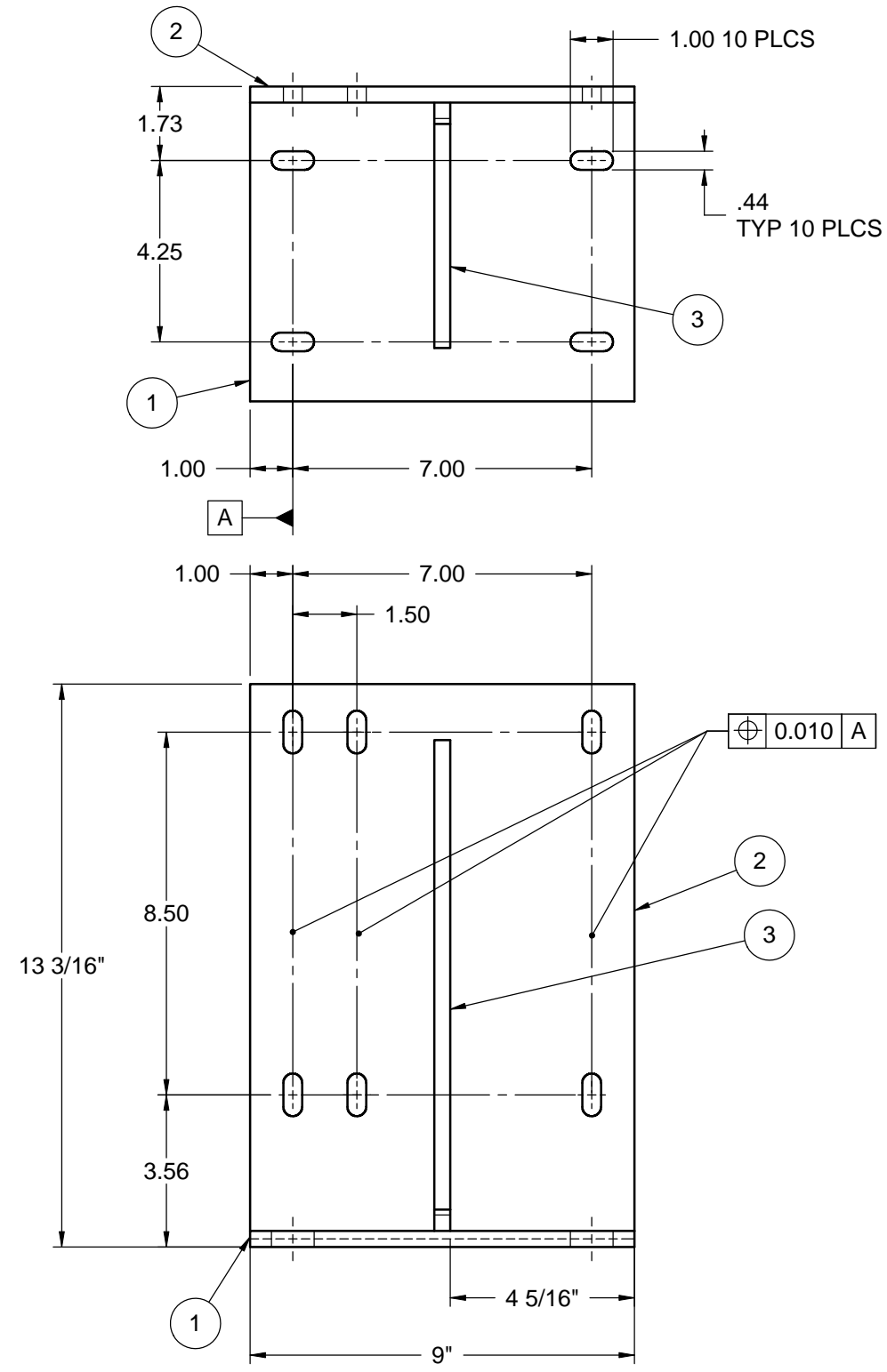


REFERENCE:  
WL ADAPTOR PLATE FOR BLOWER  
DRAWING NO. 344.342 REV C,D,E

NOTE:  
1. PAINT TESCO YELLOW AS PER  
TESCO SPEC. STD-0009.

NOTES: 1. UNLESS NOTED, ALL PARTS SHALL BE PERMANENTLY IDENTIFIED:  -MACHINED PARTS: STAMP, ETCH OR ENGRAVE DRAWING NUMBER, REVISION, AND PURCHASE ORDER NUMBER. -WELDMENTS: APPLY DRAWING NUMBER AND REVISION USING LOW STRESS STAMPS. -FABRICATED PARTS AND SHAPES: APPLY DRAWING NUMBER AND REVISION USING PAINT MARKER.  2. ALL PRINTS AND COPIES SHALL BE RETURNED UPON JOB COMPLETION UNLESS OTHERWISE SPECIFIED IN WRITING BY TESCO CORPORATION.					 TESCO COPYRIGHT TESCO CORPORATION. ALL INFORMATION IN THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL, AND SHALL REMAIN THE SOLE PROPERTY OF TESCO CORPORATION. THIS DOCUMENT SHALL NOT BE USED, COPIED OR REPRODUCED IN WHOLE OR IN PART, NOR SHALL BE REVEALED IN ANY MANNER TO OUTSIDE PARTIES WITHOUT PRIOR WRITTEN PERMISSION FROM TESCO CORPORATION.	MATERIAL SPECIFICATIONS: PLATE, 1/2" THK, 44W  HEAT TREATMENT/SPECIAL PROCESS: N/A  ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED  TOLERANCES UNLESS OTHERWISE NOTED: MACHINING: .X = $\pm$ .030   ANGULAR DIMENSIONS $\pm$ 1/2° .XX = $\pm$ .010   CONCENTRICITY .005 T.I.R. .XXX = $\pm$ .005   SURFACE FINISH 125 RMS BREAK EDGES .015 X 45°   MINIMUM RADIUS R.010 FABRICATION: 0° TO 24° : $\pm$ 1/16   > 24° : $\pm$ 1/8	TITLE: <b>PLATE, ADAPTER, BLOWER MOTOR, 350 EXI 600,MK3</b>			
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							ENG CHECK:		10MAY2010	SHEET SIZE: (SLDDRW) B
							PART/DWG NO.:	REV.:	10MAY2010	WEIGHT: 31 lbs
	0	141-0206	ISSUED FOR MANUFACTURE	10MAY2010			PAGE: 1 OF 1			
REV	ECN		DESCRIPTION	DATE						

ITEM	PART No.	QTY	DESCRIPTION	SIZE	MATL	WT
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2	-	1	PLATE, 3/8"	9" x 13"	44W	12
3	-	1	PLATE, 3/8"	5 3/4" x 11 1/2"	44W	4



FOR WL BLOWER ADAPTOR PLATE  
DRAWING NO. 344.342 REV B,C,D,E

BLOWER SUPPORT  
DRAWING NO. 333.3595 REV E

NOTE:  
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MATERIAL SPECIFICATIONS:  
SEE BOM

HEAT TREATMENT/SPECIAL PROCESS:  
N/A

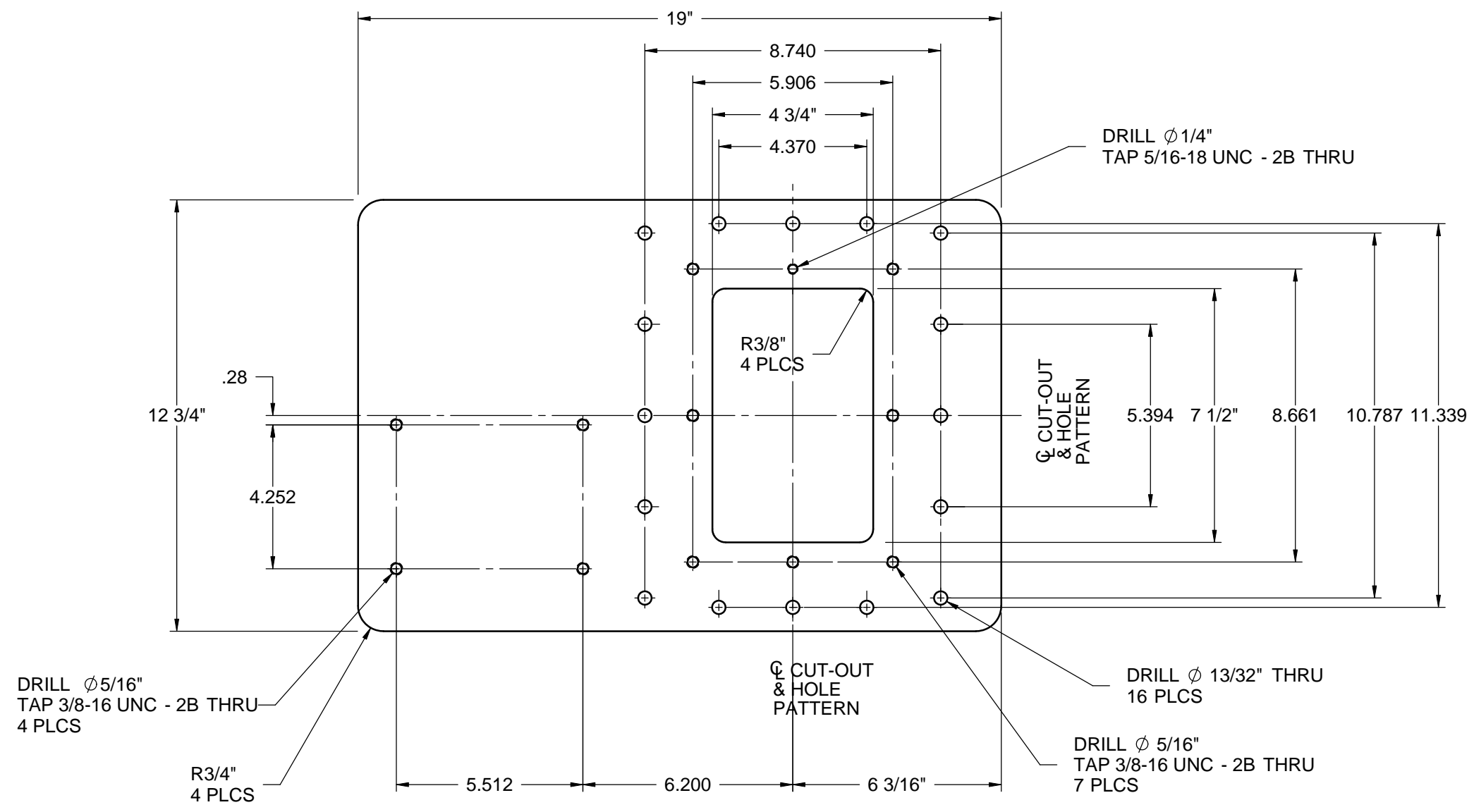
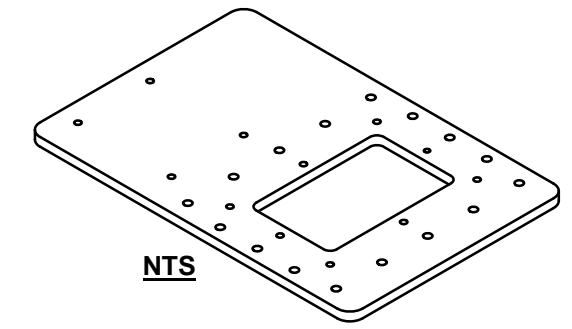
ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED

TOLERANCES UNLESS OTHERWISE NOTED:  
MACHINING:  
.X = ±.030 | ANGULAR DIMENSIONS ±1/2°  
.XX = ±.010 | CONCENTRICITY .005 T.I.R.  
.XXX = ±.005 | SURFACE FINISH 125 RMS

BREAK EDGES .015 X 45° | MINIMUM RADIUS R.010

FABRICATION:  
0° TO 24° : ±1/16 | >24° : ±1/8

TITLE: <b>MOUNT, BLOWER MOTOR, 350 EXI 600, MK2 &amp; MK3</b>		
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ENG CHECK:	DATE: 10MAY2010	PAGE: 1 OF 1
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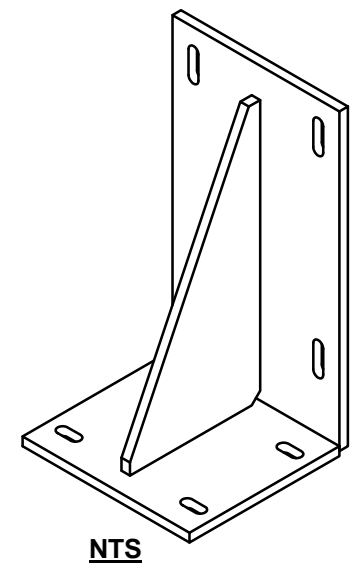
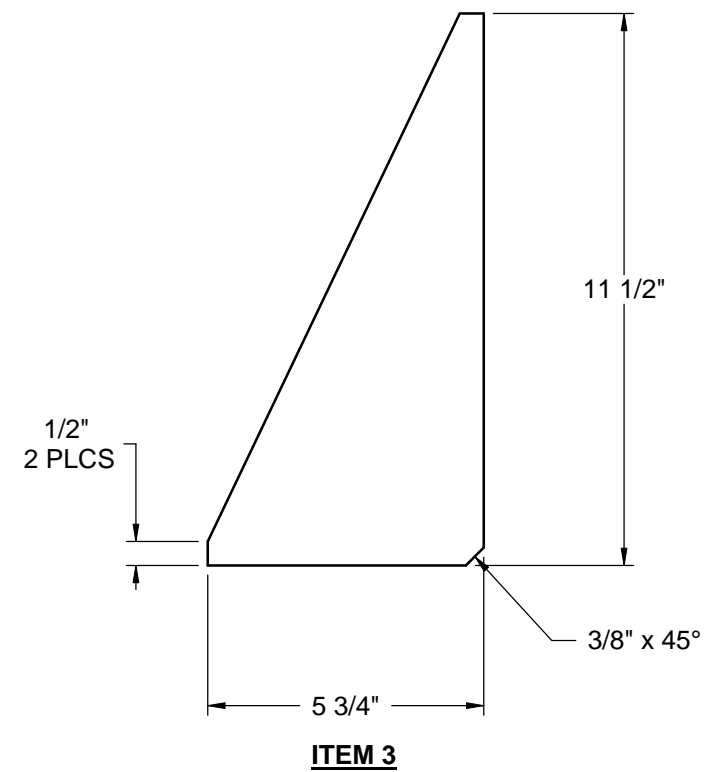
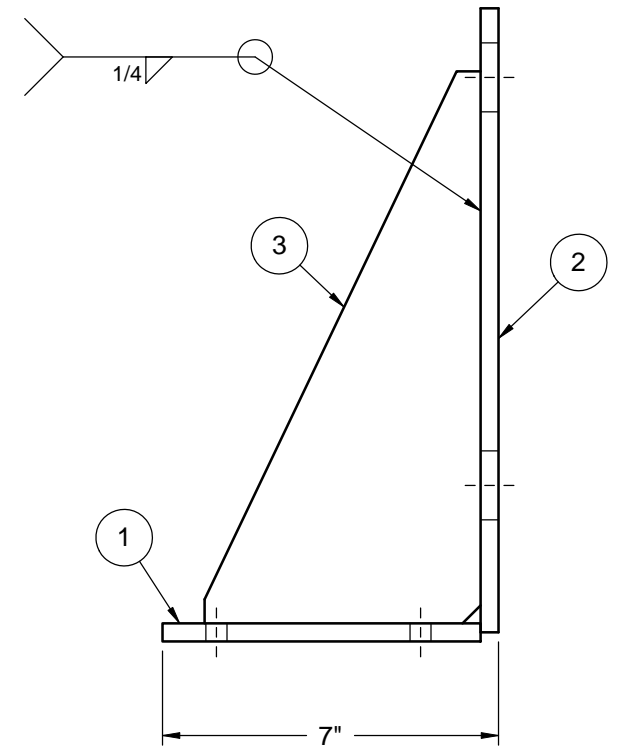
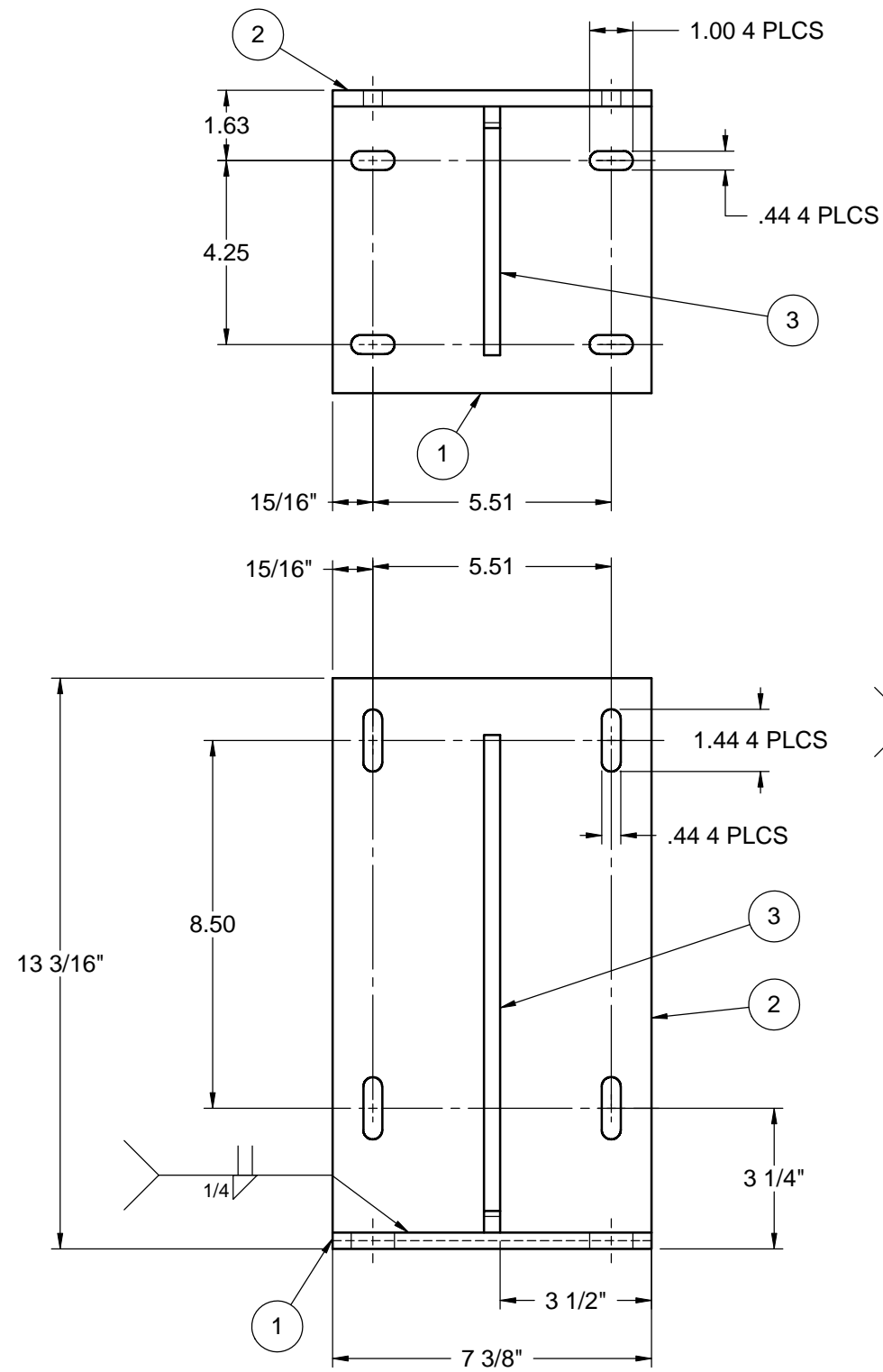
REFERENCE:  
WL ADAPTOR PLATE FOR BLOWER  
DRAWING NO. 344.342 REV A

NOTE:  
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TESCO SPEC. STD-0009.

NOTES: 1. UNLESS NOTED, ALL PARTS SHALL BE PERMANENTLY IDENTIFIED: -MACHINED PARTS: STAMP, ETCH OR ENGRAVE DRAWING NUMBER, REVISION, AND PURCHASE ORDER NUMBER. -WELDMENTS: APPLY DRAWING NUMBER AND REVISION USING LOW STRESS STAMPS. -FABRICATED PARTS AND SHAPES: APPLY DRAWING NUMBER AND REVISION USING PAINT MARKER. 2. ALL PRINTS AND COPIES SHALL BE RETURNED UPON JOB COMPLETION UNLESS OTHERWISE SPECIFIED IN WRITING BY TESCO CORPORATION.					<p>TESCO</p> <p>COPYRIGHT TESCO CORPORATION. ALL INFORMATION IN THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL, AND SHALL REMAIN THE SOLE PROPERTY OF TESCO CORPORATION. THIS DOCUMENT SHALL NOT BE USED, COPIED OR REPRODUCED IN WHOLE OR IN PART, NOR SHALL BE REVEALED IN ANY MANNER TO OUTSIDE PARTIES WITHOUT PRIOR WRITTEN PERMISSION FROM TESCO CORPORATION.</p>	MATERIAL SPECIFICATIONS: PLATE, 1/2" THK, 44W HEAT TREATMENT/SPECIAL PROCESS: N/A ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED TOLERANCES UNLESS OTHERWISE NOTED: MACHINING: .X = $\pm$ .030   ANGULAR DIMENSIONS $\pm$ 1/2° .XX = $\pm$ .010   CONCENTRICITY .005 T.I.R. .XXX = $\pm$ .005   SURFACE FINISH 125 RMS BREAK EDGES .015 X 45°   MINIMUM RADIUS R.010 FABRICATION: 0° TO 24° : $\pm$ 1/16   >24° : $\pm$ 1/8	TITLE: <b>PLATE, ADAPTER, BLOWER MOTOR, 350 EXI 600, MK1</b>			
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							PART/DWG NO.:		10MAY2010	WEIGHT: 29 lbs
	0	141-0206	ISSUED FOR MANUFACTURE	10MAY2010				PAGE: 1 OF 1		
REV	ECN		DESCRIPTION	DATE						



ITEM	PART No.	QTY	DESCRIPTION	SIZE	MATL	WT
1	-	1	PLATE, 3/8"	6 5/8" x 7 3/8"	44W	5
2	-	1	PLATE, 3/8"	7 3/8" x 13"	44W	10
3	-	1	PLATE, 3/8"	5 3/4" x 11 1/2"	44W	4



FOR WL BLOWER ADAPTOR PLATE  
DRAWING NO. 344.342 REV A

NOTE:  
1. PAINT TESCO YELLOW AS PER  
TESCO SPEC. STD-0009.

NOTES:  
1. UNLESS NOTED, ALL PARTS SHALL BE PERMANENTLY IDENTIFIED:  
-MACHINED PARTS: STAMP, ETCH OR ENGRAVE DRAWING NUMBER, REVISION, AND PURCHASE ORDER NUMBER.  
-WELDMENTS: APPLY DRAWING NUMBER AND REVISION USING LOW STRESS STAMPS.  
-FABRICATED PARTS AND SHAPES: APPLY DRAWING NUMBER AND REVISION USING PAINT MARKER.  
2. ALL PRINTS AND COPIES SHALL BE RETURNED UPON JOB COMPLETION UNLESS OTHERWISE SPECIFIED IN WRITING BY TESCO CORPORATION.

REV	ECN	DESCRIPTION	DATE
0	141-0206	ISSUED FOR MANUFACTURING	10MAY2010

**TESCO**

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MATERIAL SPECIFICATIONS:  
**SEE BOM**

HEAT TREATMENT/SPECIAL PROCESS:  
**N/A**

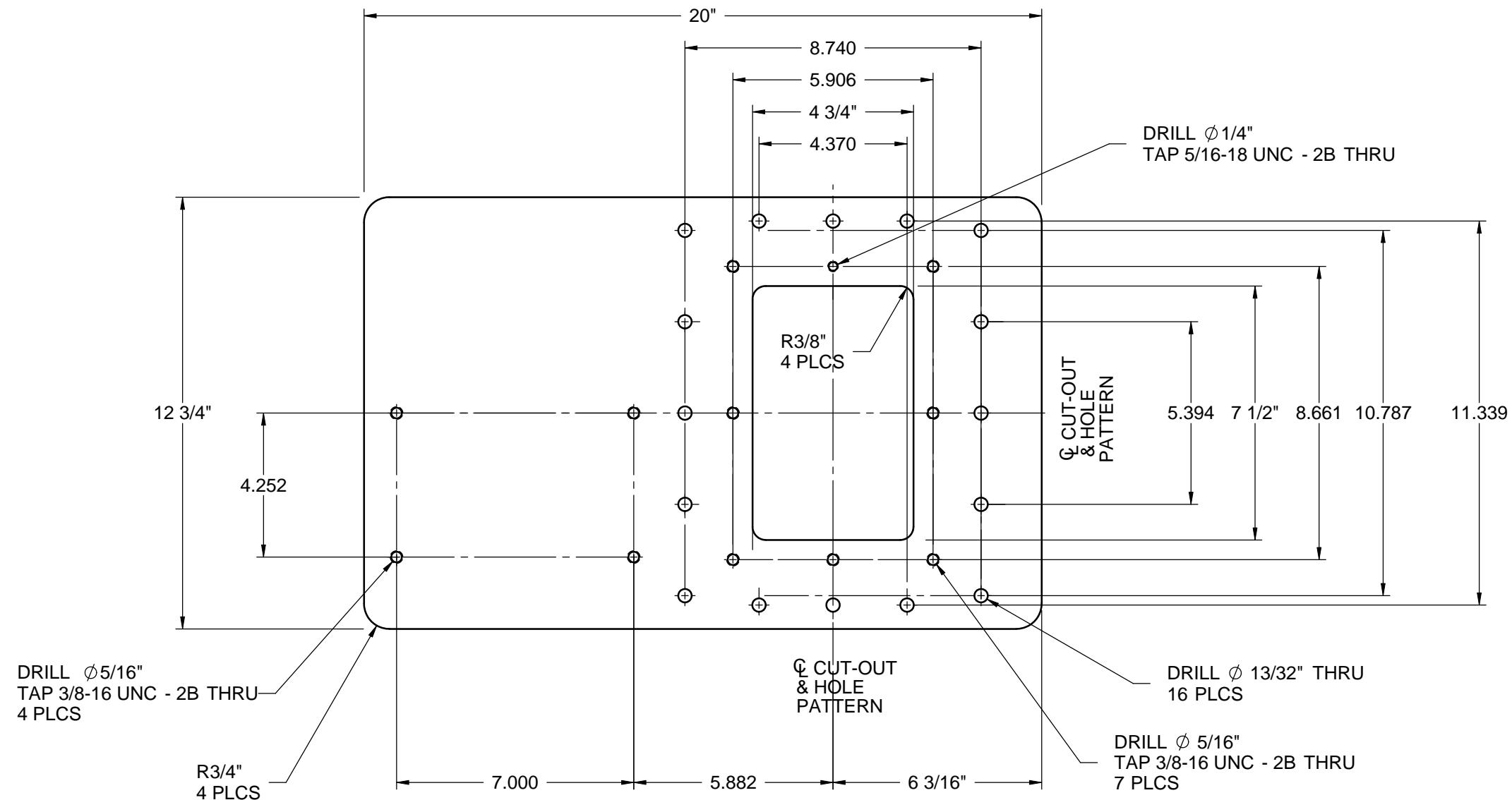
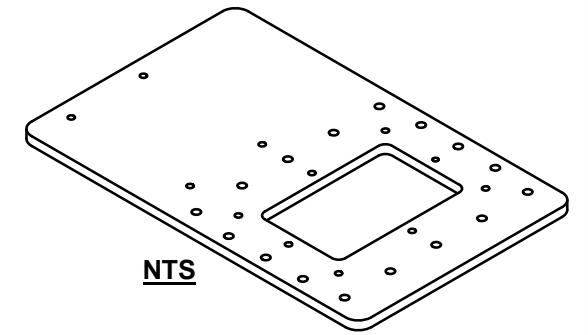
ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED

TOLERANCES UNLESS OTHERWISE NOTED:  
MACHINING:  
.X = ±.030 | ANGULAR DIMENSIONS ±1/2°  
.XX = ±.010 | CONCENTRICITY .005 T.I.R.  
.XXX = ±.005 | SURFACE FINISH 125 RMS

BREAK EDGES .015 X 45° | MINIMUM RADIUS R.010

FABRICATION:  
0° TO 24° : ±1/16 | > 24° : ±1/8

TITLE: <b>MOUNT, BLOWER MOTOR, 350 EXI 600,MK1</b>		
PROJECT:	DATE: 10MAY2010	SCALE: 1:4
DRAFTED: QW	DATE: 10MAY2010	SHEET SIZE: (SLDDRW) B
DFTG CHECK:	DATE: 10MAY2010	WEIGHT: 19 lbs
ENG CHECK:	DATE: 10MAY2010	PAGE: 1 OF 1
PART/DWG NO.: <b>5001983</b>	REV.: <b>0</b>	



REFERENCE:

WL ADAPTOR PLATE FOR BLOWER  
DRAWING NO. 344.342 REV B

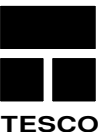
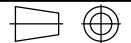
NOTE:

1. PAINT TESCO YELLOW AS PER  
TESCO SPEC. STD-0009.

NOTES:

- UNLESS NOTED, ALL PARTS SHALL BE PERMANENTLY IDENTIFIED:
  - MACHINED PARTS: STAMP, ETCH OR ENGRAVE DRAWING NUMBER, REVISION, AND PURCHASE ORDER NUMBER.
  - WELDMENTS: APPLY DRAWING NUMBER AND REVISION USING LOW STRESS STAMPS.
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REV	ECN	DESCRIPTION	DATE
0	141-0206	ISSUED FOR MANUFACTURE	10MAY2010

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 THIRD ANGLE PROJECTION DO NOT SCALE DRAWING			

MATERIAL SPECIFICATIONS: <b>PLATE, 1/2" THK, 44W</b>	
HEAT TREATMENT/SPECIAL PROCESS: N/A	
ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED	
TOLERANCES UNLESS OTHERWISE NOTED: MACHINING: .X = ±.030      ANGULAR DIMENSIONS ±1/2° .XX = ±.010      CONCENTRICITY .005 T.I.R. .XXX = ±.005      SURFACE FINISH 125 RMS	
BREAK EDGES .015 X 45°      MINIMUM RADIUS R.010	
FABRICATION: 0° TO 24° : ±1/16      > 24° : ±1/8	

TITLE: <b>PLATE, ADAPTER, BLOWER MOTOR, 350 EXI 600, MK2</b>		
PROJECT:		
DRAFTED:	DATE:	SCALE:
QW	10MAY2010	1:4
DFTG CHECK:	DATE:	SHEET SIZE:
	10MAY2010	(SLDDRW) B
ENG CHECK:	DATE:	WEIGHT:
	10MAY2010	31 lbs
PART/DWG NO.:	REV.:	PAGE:
<b>5001961</b>	<b>0</b>	1 OF 1