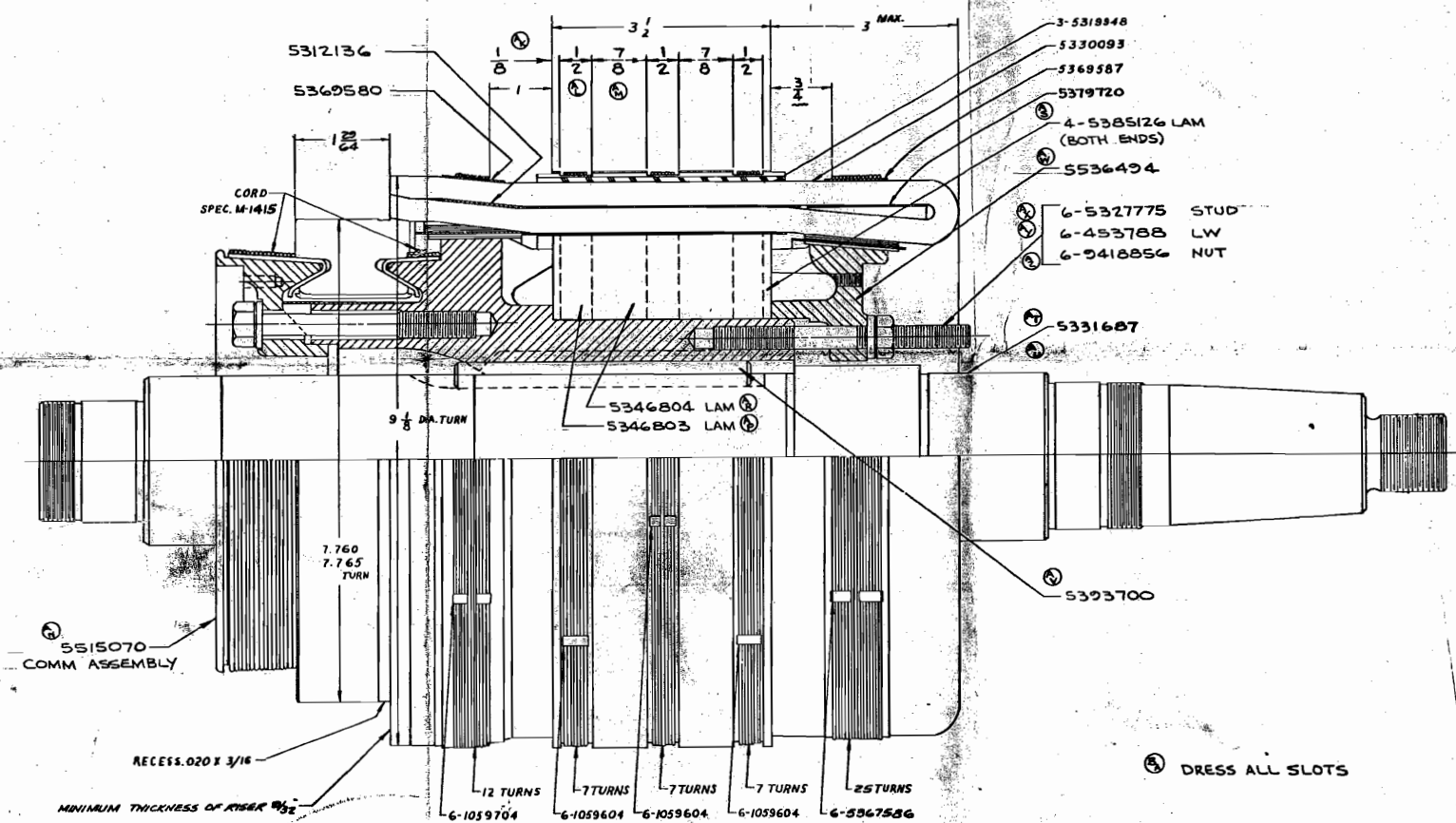


NOTE - BUILD-UP COIL SUPPORTS AS FOLLOWS -

- ON COMMUTATOR END
 1- WIND 1 LAYER OF 1/2 X .010 TAPE SPEC. M-1135 (DOUBLED) OVER MIDDLE OF COIL SUPPORT
 2- WIND 1 LAYER OF 1/2 X .010 TAPE SPEC. M-1135
 3- WRAP INSULATOR 5357492
 4- WIND 4 LAYERS OF 1/2 X .010 TAPE SPEC. M-1135 ON FAN END
 ON FAN END
 1- WIND 2 LAYERS OF 1/2 X .010 TAPE SPEC. M-1135 (DOUBLED) ON FRONT END OF COIL SUPPORT
 2- WIND 2 LAYERS OF 1/2 X .010 TAPE SPEC. M-1135
 3- WRAP INSULATOR 5357492
 4- WIND 2 LAYERS OF 1/2 X .010 TAPE SPEC. M-1135
 5- WIND 1 LAYER OF 1/2 X .010 TAPE (DOUBLED) ON FRONT END OF COIL SUPPORT
 SHELLAC EACH LAYER IN PLACE ON BOTH SUPPORTS

NOTE - FOR SERVICE ARMATURES HAVING FAN END COIL SUPPORT WITH 7/8 O.D. AT LARGEST DIAM. OF TAPER USE BUILD-UP AS LISTED ABOVE. ON ARMATURES HAVING A FAN END COIL SUPPORT WITH 6 3/8 O.D. AT LARGEST DIAM. OF TAPER, USE THE FOLLOWING BUILD-UP -

- 1- WIND 1 LAYER OF 1/2 X .010 TAPE SPEC. M-1135
 2- WIND 2 LAYERS OF 1/2 X .010 TAPE SPEC. M-1135 (DOUBLED) OVER FRONT END OF COIL SUPPORT
 3- WIND 2 LAYERS OF 1/2 X .010 TAPE SPEC. M-1135 (DOUBLED) OVER BACK END OF COIL SUPPORT
 4- WRAP INSULATOR 5357492
 5- WIND 8 LAYERS OF 1/2 X .010 TAPE SPEC. M-1135
 6- WIND 2 LAYERS OF 1/2 X .010 TAPE SPEC. M-1135 (DOUBLED) OVER FRONT END OF COIL SUPPORT
 SHELLAC EACH LAYER IN PLACE

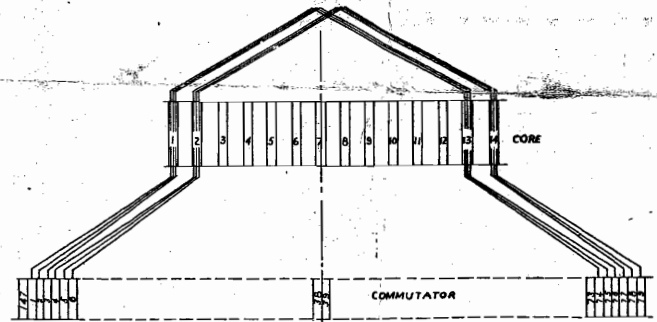


Ø40 DIA. WIRE SPEC. M-2376 - WIND WITH 150 LBS. TENSION
 FLOW SOLDER AS PER PROC. SPEC. P-1162 COMPLETELY AROUND BANDING AND CLIPS
 USE 2 BANDING CLIPS AT THE START AND FINISH POINT. THE REMAINDER TO BE EQUALLY SPACED AROUND CORE.

PROCESS SPEC. P-1400-D SECTION "B"
 ITEM NO. 2 - 3200 VOLTS TO GROUND 1 MINUTE

FOR SERVICE: MIN SERVICEABLE
 COMMUTATOR DIA 7/8"

1073428	REVISE
SAME AS DWG.	DATE



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