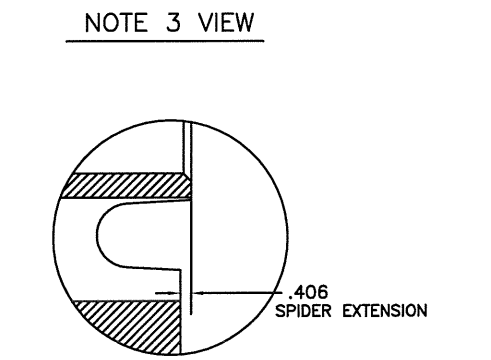
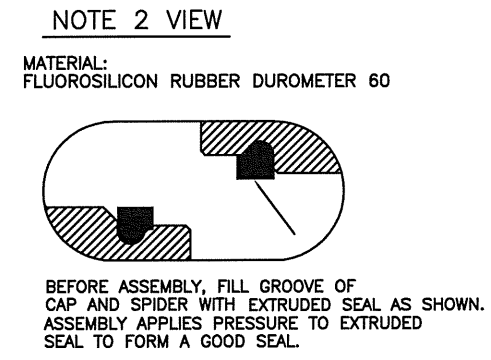
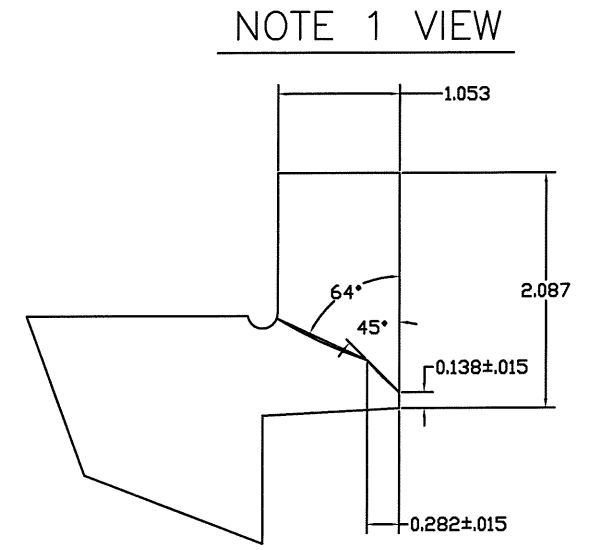
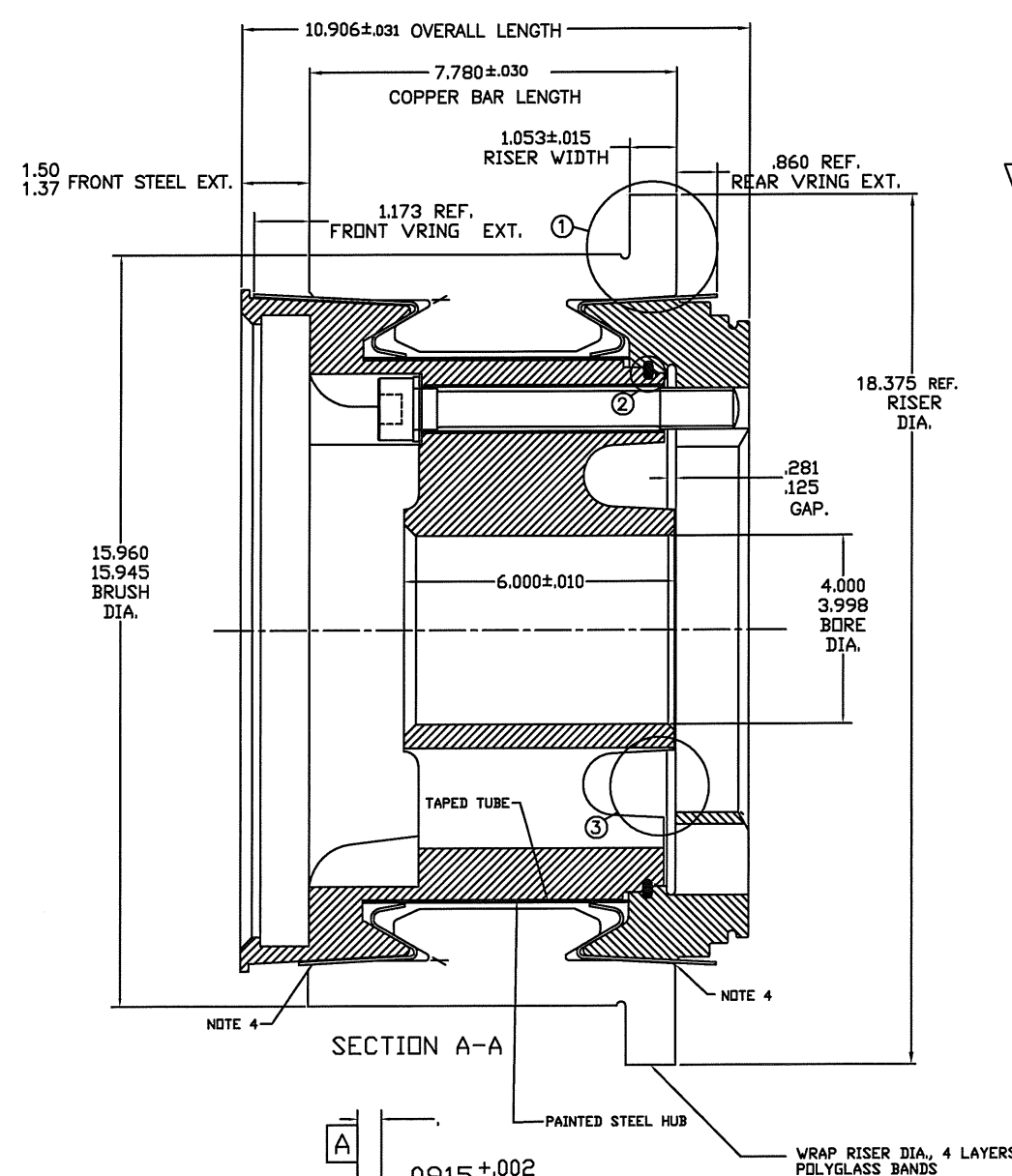
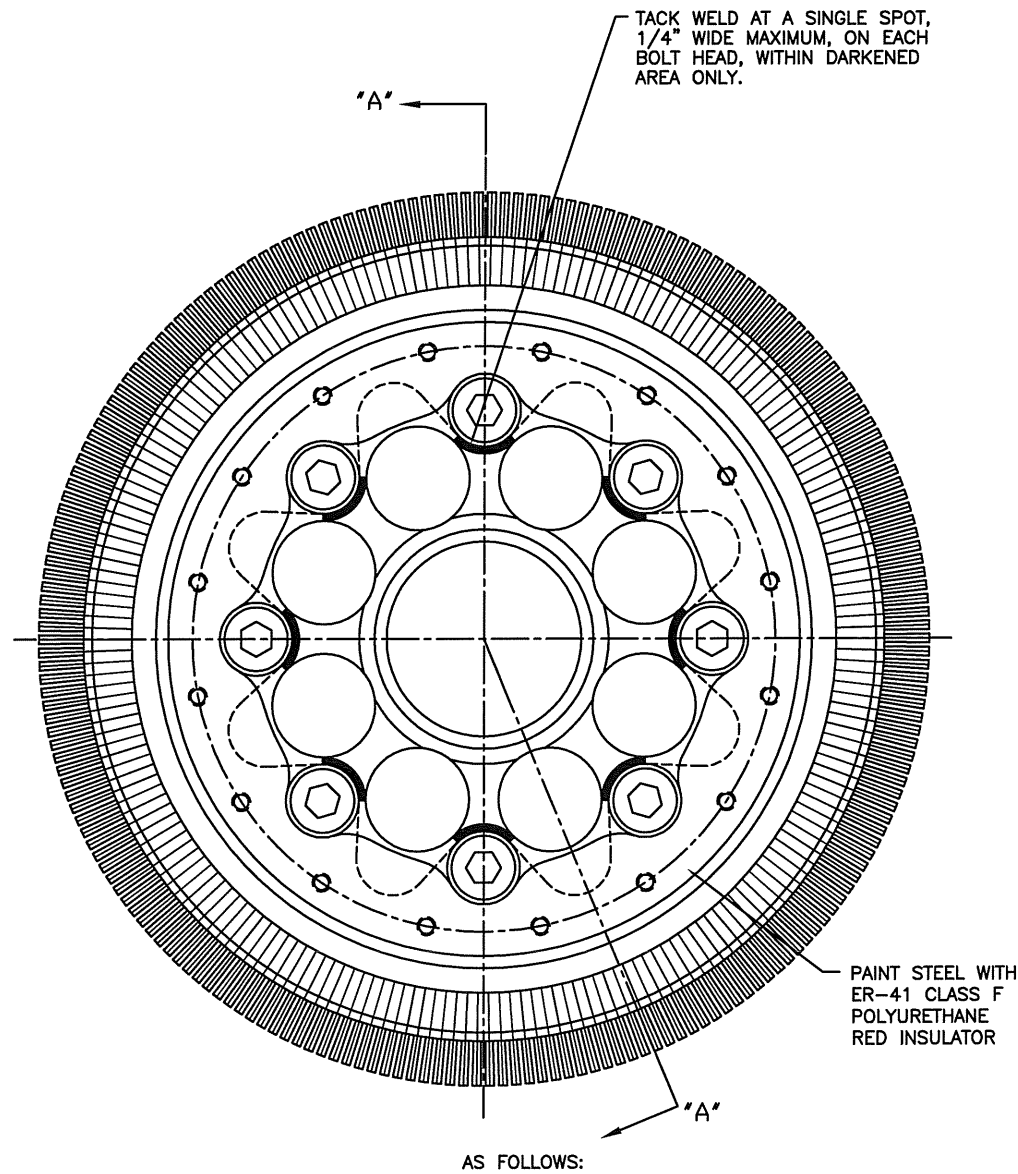


SUPCO

APP'VD BY:

SIGNATURE:

DATE:



NOTES:

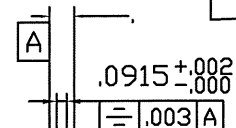
1. MATERIAL SPECIFICATION

- COPPER SEGMENT TO BE A COPPER/SILVER ALLOY MEETING A MINIMUM SPECIFICATION OF C11400 (10-16 OZ SILVER/TON). ALTERNATIVE MATERIAL: C11600 (25-30 OZ SILVER/TON "H02 TEMPER (1/2 HARD)")
- MICA SEGMENTS AND MICA V-RINGS
- MICA TUBE MADE FROM .030" THICK SHELLAC MOULD MICA
- D90 STEEL AS PER DRAWING 9523518 AND 40034410

2. ELECTRICAL TEST

- BAR TO BAR: 600 VAC
- BAR TO GROUND: 5000 VAC HIGHPOT FOR 1 MIN.

- 3. SLOT BURRS TO BE REMOVED.
- 4. NUMBER 588 CSL SILICONE OR EQUIVALENT TO BE USED AT 3" OPENING. SEAL TO EXTEND 1/4" MIN. INSIDE OPENING, BOTH ENDS OF COMMUTATOR
- 5. COMMUTATOR BAR SKEW TO BE WITHIN 0.015" MAX.
- 6. CHANGE IN T.I.R. NOT TO EXCEED .002".



**GM TRACTION MOTOR
D90 COMMUTATOR ASSEMBLY (LONG VRING)**

SCALE:	N.T.S.	DRAWN BY:	JUDY YANG
DATE:	08/30/11	PAGE 1 OF 1	
DRAWING APPROVED BY:		CAT. NO.	REV. NO. 000
DATE APPROVED:		DRAWING NUMBER D90-AV-N-SUPCO (LVR)	

REV.	DATE	BY	DESCRIPTION
000	08/30/11	JY	DRAWN