

목록

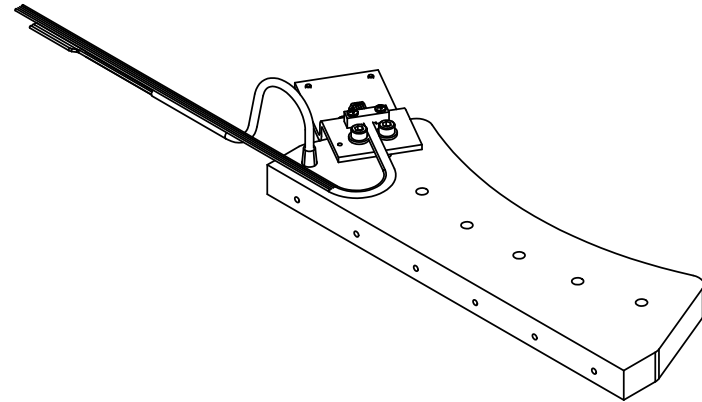
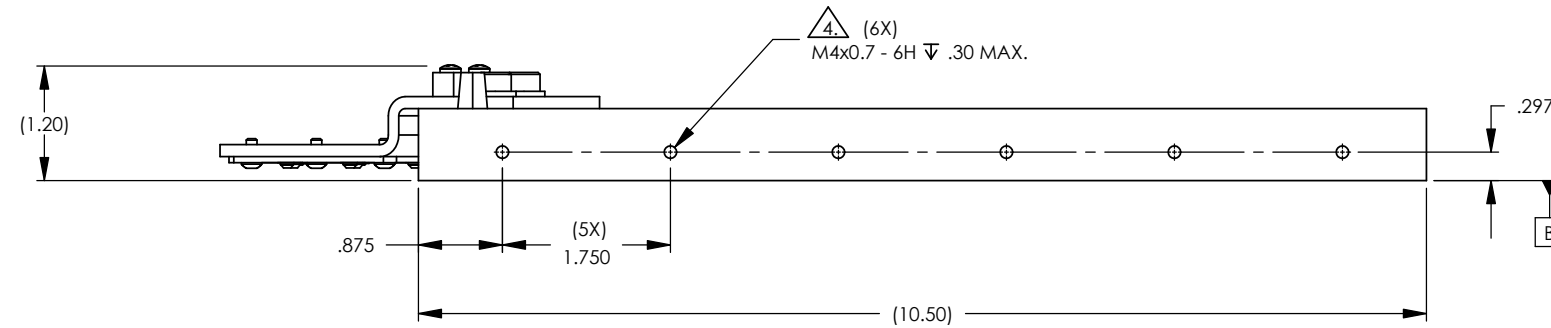
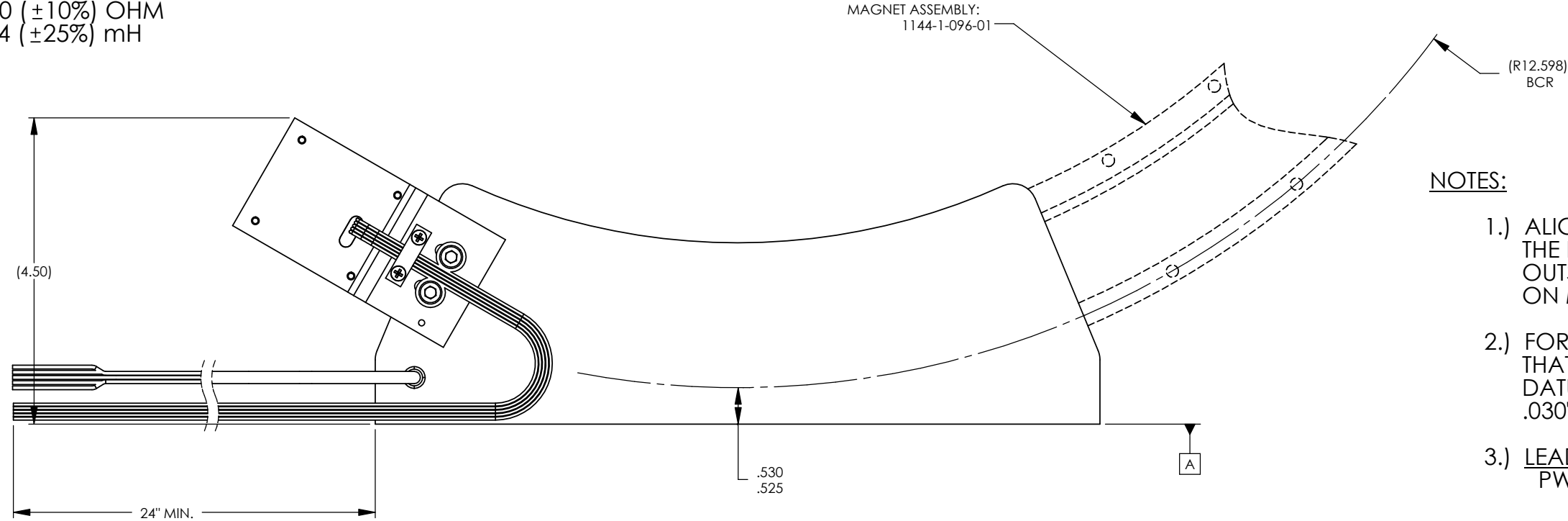
Infinity Series ARC 인터페이스 도면 - 1144	1
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FORCER ASSY P/N:
1144-1-090-01

PERFORMANCE WHEN MATED WITH
MAGNET ASSEMBLY IAW 1144-1-096-01:

Kt: 900 ($\pm 10\%$) OZ-IN/AMP.
Ke: 0.67 ($\pm 10\%$) Vpk/RPM
Res: 50 ($\pm 10\%$) OHM
L : 38.4 ($\pm 25\%$) mH

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
P1	000248	INITIAL DESIGN	30-NOV-2005	A.L.



MAGNET ASSEMBLY:
1144-1-096-01

(R12.598)
BCR

NOTES:

- 1.) ALIGN THE FORCER RADIALLY SO THE FORCER DATUM A IS $.525$ /. $.530$ " OUTSIDE OF BOLT CIRCLE ($\phi 12.598$ ") ON MAGNET ASSEMBLY: 1144-1-096-01.
- 2.) FORCER SHOULD BE MOUNTED SO THAT THE AIR GAP BETWEEN THE FORCER DATUM B AND THE MAGNET ASSEMBLY IS $.030$ " NOMINALLY.
- 3.) **LEAD COLOR CODE:**
PWR LEADS - 22 AWG, TEFLON COATED
RED - PHASE A
BLK - PHASE B
WHT - PHASE C

HALL LEADS - 28 AWG COLORED RIBBON
GRN - +5 VOLTS
YLW - GND
ORG - HALL 2
RED - HALL 1
BRN - HALL 3

TEMP. SWITCH - 22 AWG, TEFLON COATED
CANTHERM P/N: F1110025ACFA06E
NORMALLY CLOSED
BLU - TEMP SWITCH
BLU - TEMP SWITCH

4. MAX DEPTH $.300$ ", DO NOT DRILL.

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DWG. NO.: 1144-1-095-01	PROJECT: 1144	TITLE: FORCER INTERFACE		THIRD ANGLE PROJECTION:	UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE:
DRAWN BY: ARL	CHECKED BY:	APPROVED BY: SRP	SCALE: N1S	SHEET: 1 of 1	DECIMALS LINEAR ANGULAR
11/30/2005		12/08/2005	UNITS: INCH	SURFACE FINISH: 63	.X ± 0.020 $\pm 1^\circ$.XX ± 0.010 $\pm 0.2^\circ$.XXX ± 0.005 $\pm 0.01^\circ$
CONFIDENTIAL					

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
P1	003747	INITIAL RELEASE	13-JAN-29	JPC

APPLIMOTION PART NUMBER : 1144-1-100-01

PERFORMANCE WHEN MATED WITH TRACK 1144-1-200-01
(AIR GAP : 0.030 in)

Res: 50.0 (±10%) OHM
 Ke: 670 (±10%) V/KRPM
 Kt(TRAP): 900 (±10%) oz-in/AMP DC
 Kt(SINE): 780 (±10%) oz-in/AMP Pk
 L: 25.8 (±25%)mH

NUMBER OF MAGNET POLES: 64

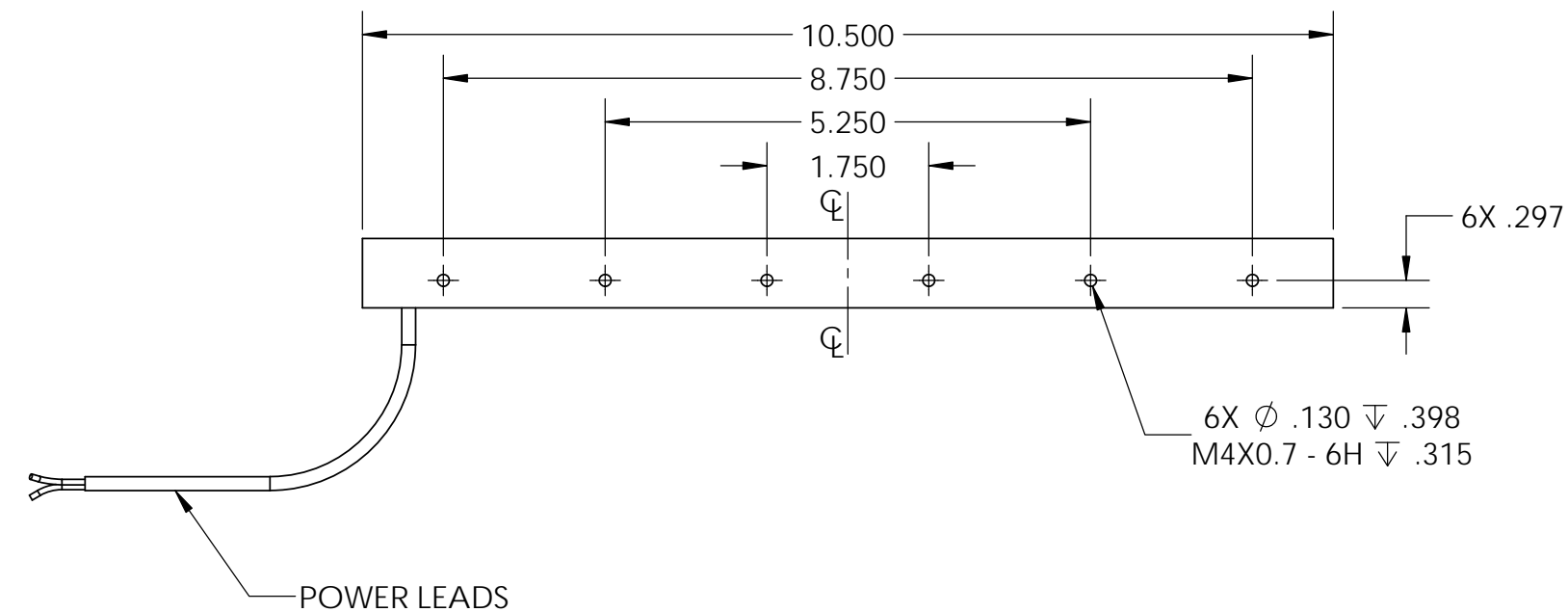
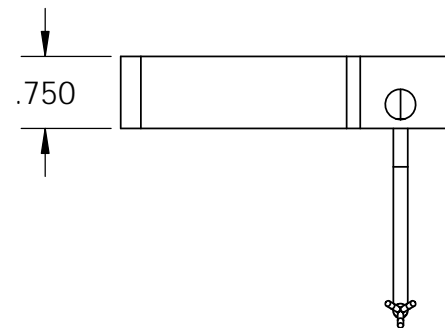
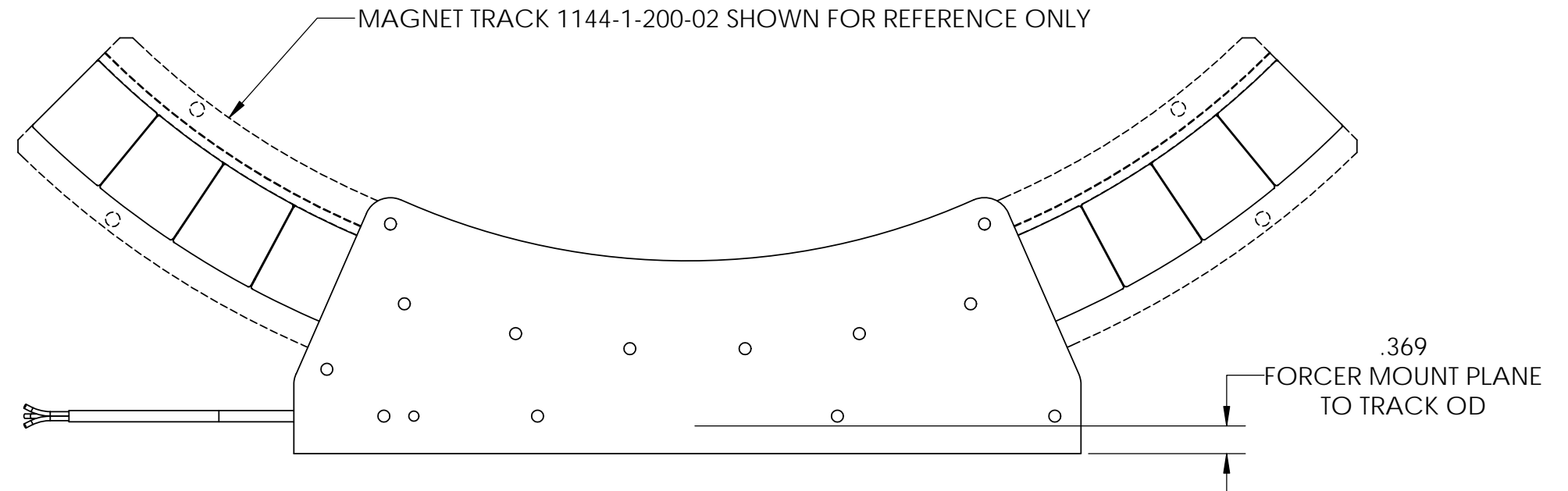
LEAD COLOR CODE

POWER LEADS

BELDEN 83334E MULTI-CONDUCTOR CABLE
 22 AWG, TEFLON COATED LEADS WITH BRAIDED SHIELD
 AND TEFLONG JACKET

24" MIN LENGTH

BLK - PHASE A
 RED - PHASE B
 WHT - PHASE C



INTERFACE CONTROL DRAWING

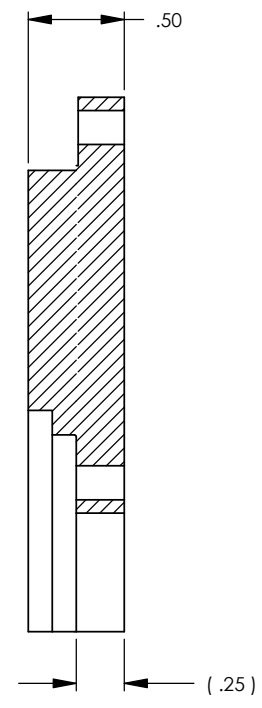
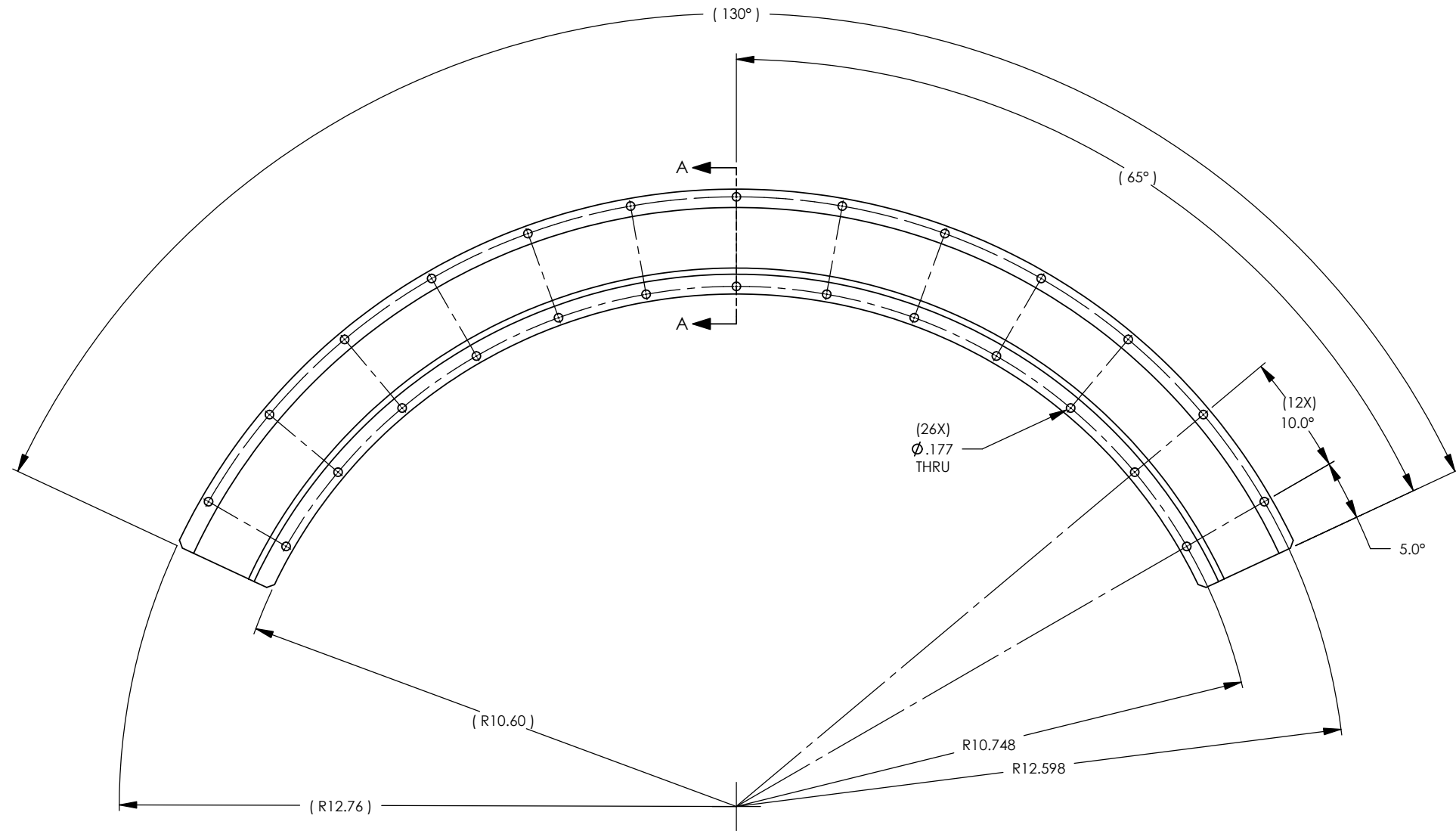
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DWG. NO: 1144-1-095-02	PROJECT: 1523	TITLE: FORCER INTERFACE		THIRD ANGLE PROJECTION:	UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE:
DRAWN BY: JPC	CHECKED BY: DML	COG ENGINEER: DML	SCALE: N/A	SHEET: 1 of 1	DECIMALS LINEAR ANGULAR X ±0.020 ±1° XX ±0.010 ±0.2° XXX ±0.005 ±0.01°
DATE: 1/29/2013			UNITS: INCH	SURFACE FINISH: N/A	

CONFIDENTIAL

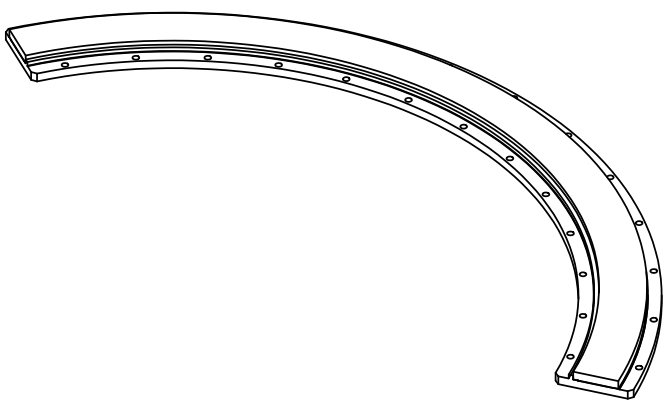
PRINTED COPIES OF THIS DOCUMENT ARE NOT CONTROLLED

MAGNET ASSEMBLY P/N:
1144-1-200-01

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
P1	000248	INITIAL DESIGN	30-NOV-2005	A.L.



SECTION A-A

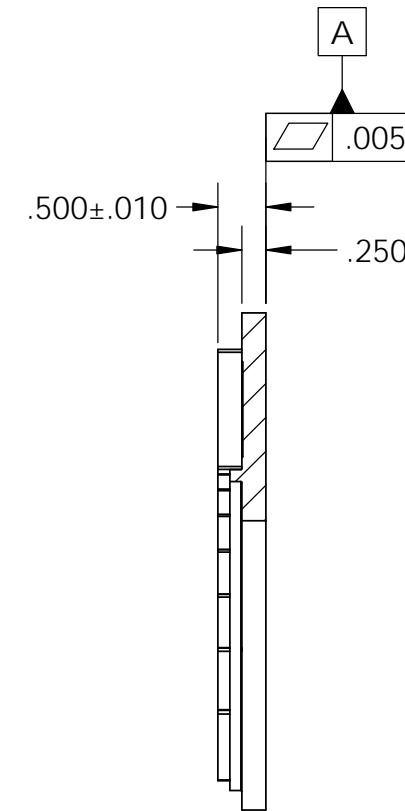
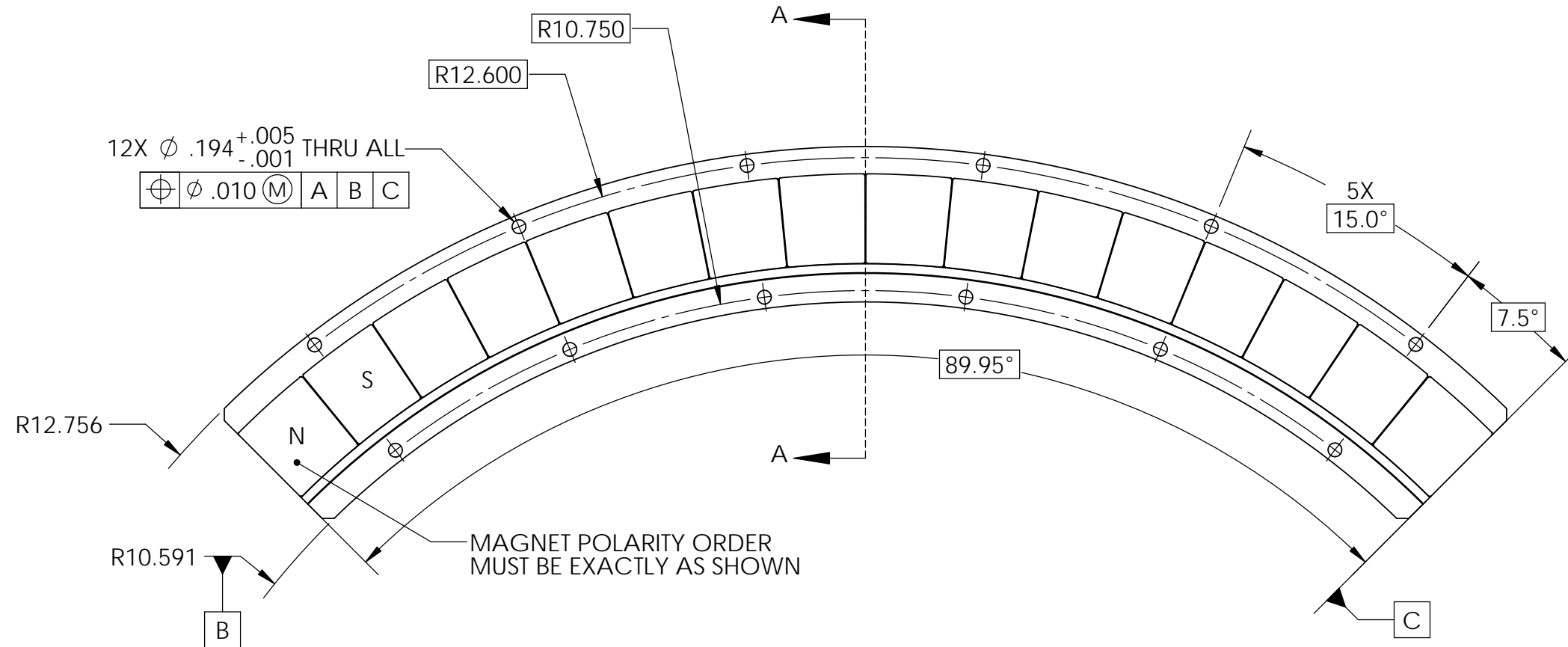


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CONFIDENTIAL

APPLIMOTION, INC.		CAGE CODE: 3DRL5	DRAWING SYMBOLS & TOLERANCE PER ANSI Y14.5
DWG. NO.: 1144-1-096-01	PROJECT: 1144	THIRD ANGLE PROJECTION:	UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE:
TITLE: MAGNET ASSEMBLY INTERFACE	SHEET 1 of 1	SCALE: N/A	DECIMALS LINEAR ANGULAR .X ±0.020 ±1° .XX ±0.010 ±0.2° .XXX ±0.005 ±0.01°
DRAWN BY: ARL 11/30/2005	CHECKED BY:	APPROVED BY: SRP 11/30/2005	SURFACE FINISH: N/A
UNITS: INCH			

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
P1	003728	INITIAL RELEASE	13-JAN-18	JPC



SECTION A-A

NOTES: (UNLESS OTHERWISE SPECIFIED)

- IDENTIFY PART WITH APPLIMOTION PART NUMBER: 1144-1-200-02

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DWG. NO: 1144-1-096-02	PROJECT: 1523		THIRD ANGLE PROJECTION:	UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE:	
TITLE: MAGNET TRACK ICD			SHEET 1 of 1	DECIMALS LINEAR ANGULAR	
DRAWN BY: JPC	CHECKED BY: DML	COG ENGINEER: DML	SCALE: N/A	X ±0.020 ±1°	
1/17/2013	1/17/2013	1/17/2013	UNITS: INCH	XX ±0.010 ±0.2°	
				XXX ±0.005 ±0.01°	

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FORCER ASSY P/N:

1160-1-090-01

**PERFORMANCE WHEN MATED WITH
MAGNET ASSEMBLY IAW 1160-1-096-01:**

Kt : 57.0 (±10%) OZ-IN/AMP
Ke : 35.0(±10%) Vpk/RPM
Res : 1.40 (±10%) OHM
L : .55 (±25%) mH

NUMBER OF MAGNET POLES: 64/360°

LEAD COLOR CODE:

POWER LEADS

22 AWG, 48" MIN LENGTH
TEFLON COATED, FLYING LEADS

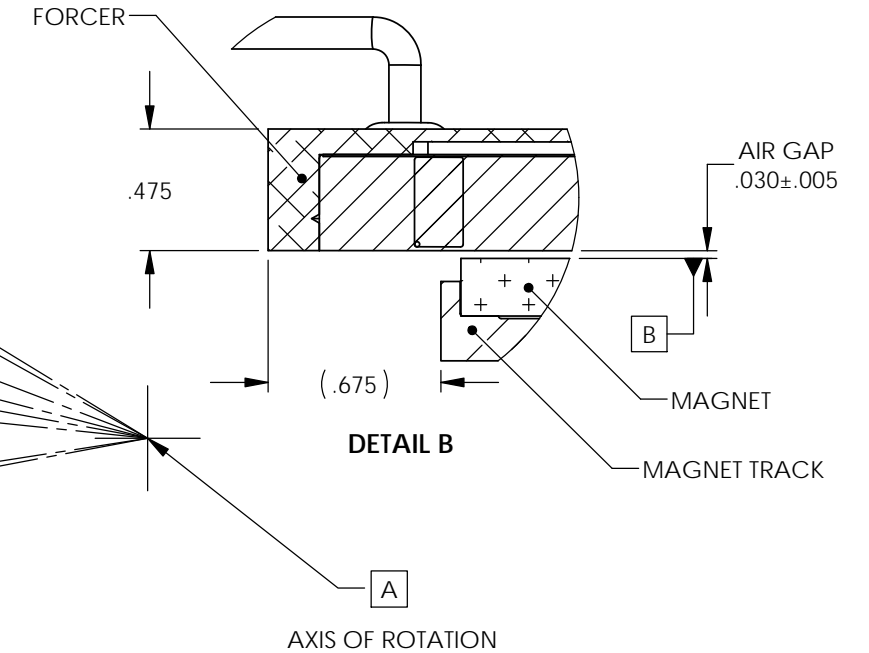
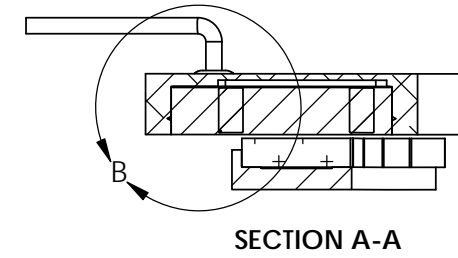
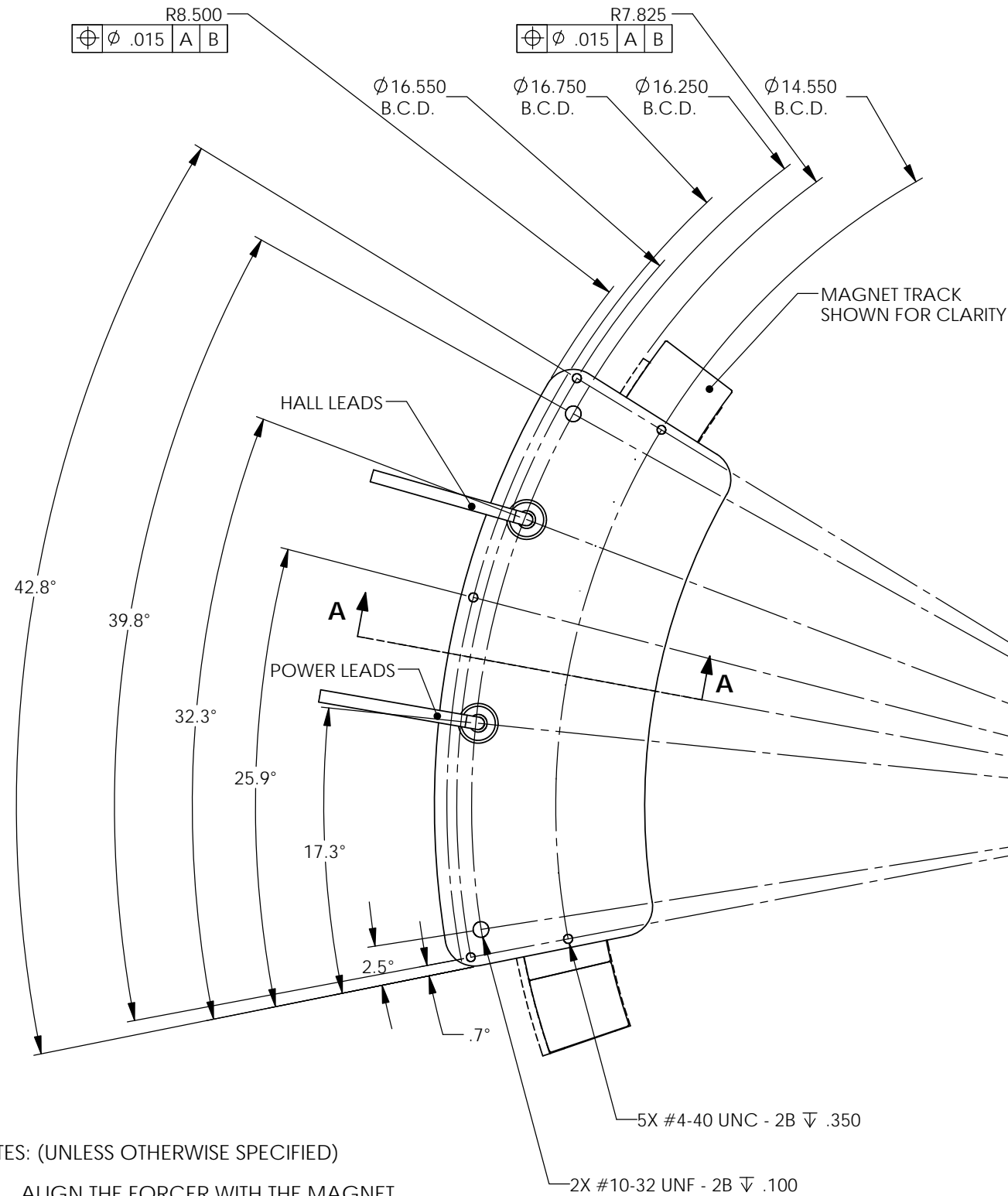
RED - PHASE A
BLK - PHASE B
WHT - PHASE C

HALL LEADS

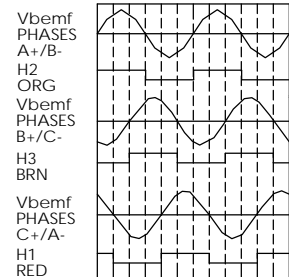
26 AWG, 48" MIN LENGTH
TEFLON COATED, FLYING LEADS

GRN - +5 VOLTS
YLW - GND
RED - HALL 1
ORG - HALL 2
BRN - HALL 3

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
B	000446	CHANGED NOTES	24-OCT-06	A.L.
C	001574	ADDED SPECIFICATION NUMBER OF MAGNET POLES	29-MAR-10	GSM
D	002953	ADDED PHASE DIAGRAM UPDATED DIMENSIONS	13-APR-12	ADR



PHASE RELATION OF BACK EMF
PHASE-TO-PHASE VOLTAGES AND HALL
OUTPUTS DURING CW MOVEMENT OF FORCER
VIEWED FROM LEAD END



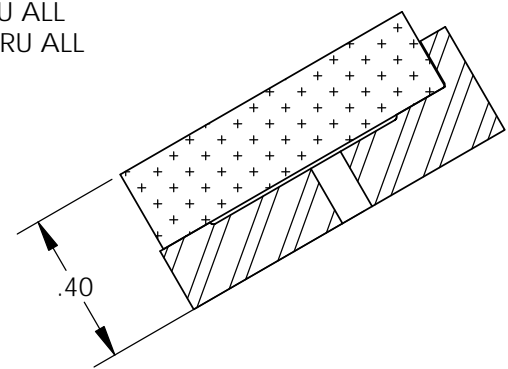
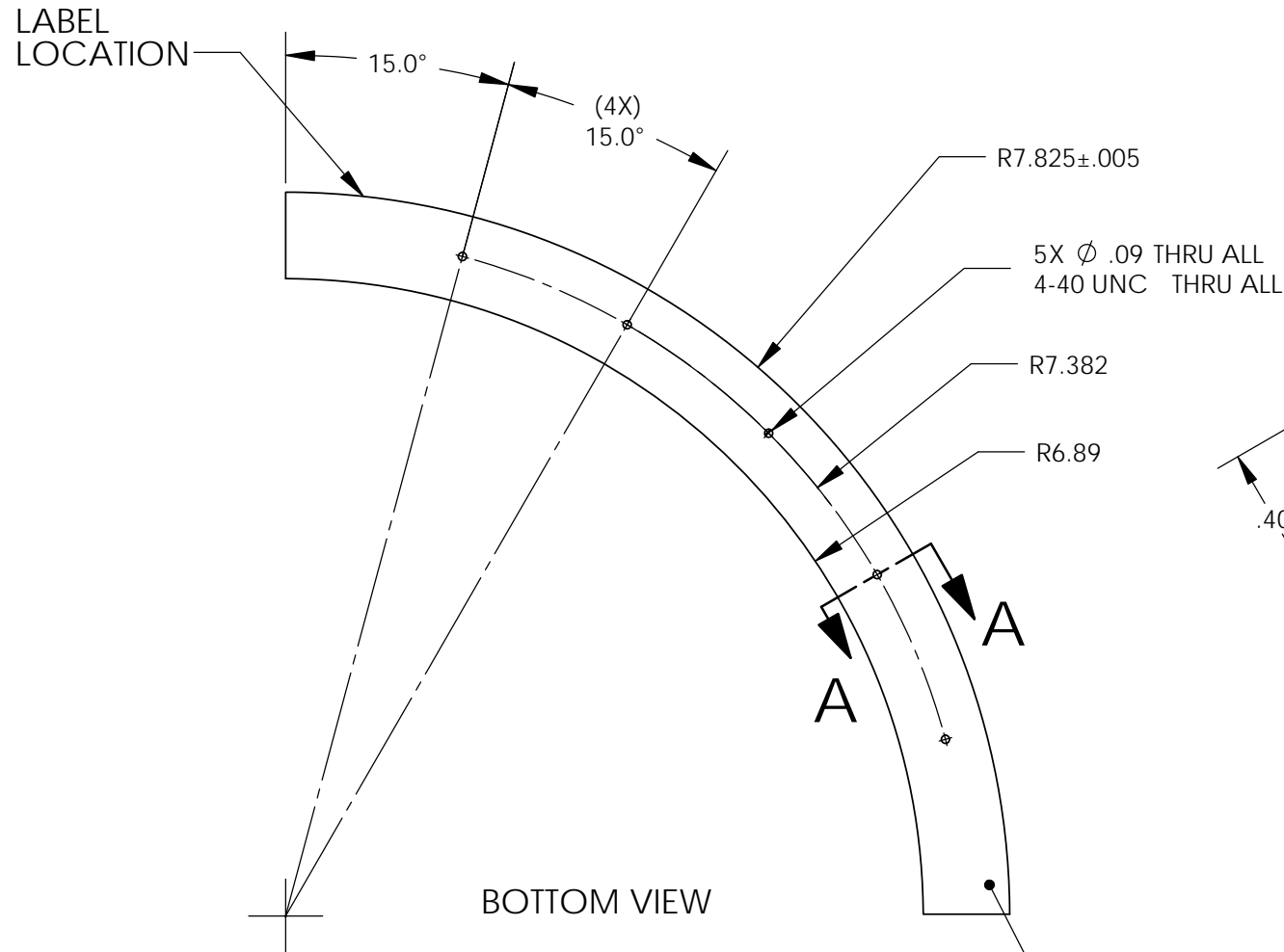
NOTES: (UNLESS OTHERWISE SPECIFIED)

- ALIGN THE FORCER WITH THE MAGNET TRACK SO THE FORCER AXIS OF ROTATION IS CONCENTRIC WITH THE MAGNET TRACK AXIS OF ROTATION.
- FORCER SHOULD BE MOUNTED SO THAT THE AIR GAP BETWEEN THE FORCER'S DATUM B AND THE MAGNET ASSEMBLY IS .030" NOMINALLY.

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DWG. NO.: 1160-1-095-01	PROJECT: 1160	SHEET 1 of 1		THIRD ANGLE PROJECTION:	UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE:	
TITLE: FORCER INTERFACE	SCALE: N/A	UNITS: INCH	SURFACE FINISH: N/A	DECIMALS	LINEAR	ANGULAR
DRAWN BY: ARL 07/05/2006	CHECKED BY:	APPROVED BY: SRP 07/05/2006		X XX XXX	±0.020 ±0.010 ±0.005	±1° ±0.2° ±0.01°
CONFIDENTIAL						

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
A	001575	INITIAL RELEASE	29-MAR-10	GSM
B	004170	ADDED LABELS	2014-MAY-02	AMS

APPLIMOTION, INC	P/N 1160-1-096-02	S/N YYMMDD-NNN
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.005

BOTTOM VIEW

SECTION A-A

NOTES (UNLESS OTHERWISE SPECIFIED)

3 LABELS ON EDGE

LABEL 1. APPLIMOTION, INC.
 LABEL 2. P/N 1160-1-096-02
 LABEL 3. S/N YYMMDD-NNN

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APPLIMOTION, INC.

DWG NO: 1160-1-096-02 PROJECT: 1160

TITLE: MAGNET ASSEMBLY INTERFACE SHEET 1 of 1

DRAWN BY: GSM CHECKED BY: SRP COG ENGINEER: DML SCALE: NTS

UNITS: INCH

CAGE CODE: 3DRL5

THIRD ANGLE PROJECTION:

SURFACE FINISH: N/A

DRAWING SYMBOLS & TOLERANCE PER ANSI Y14.5-2009

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE:

DECIMALS	LINEAR	ANGULAR
.X	±0.020	±1°
.XX	±0.010	±0.2°
.XXX	±0.005	±0.01°

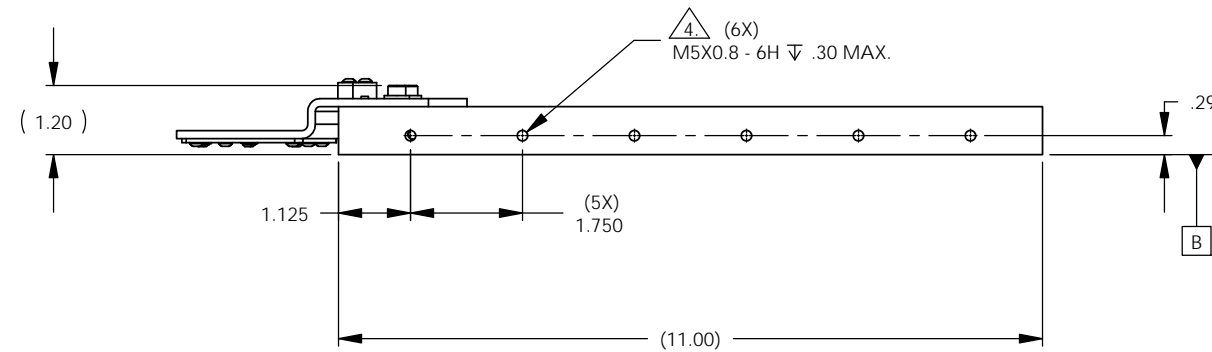
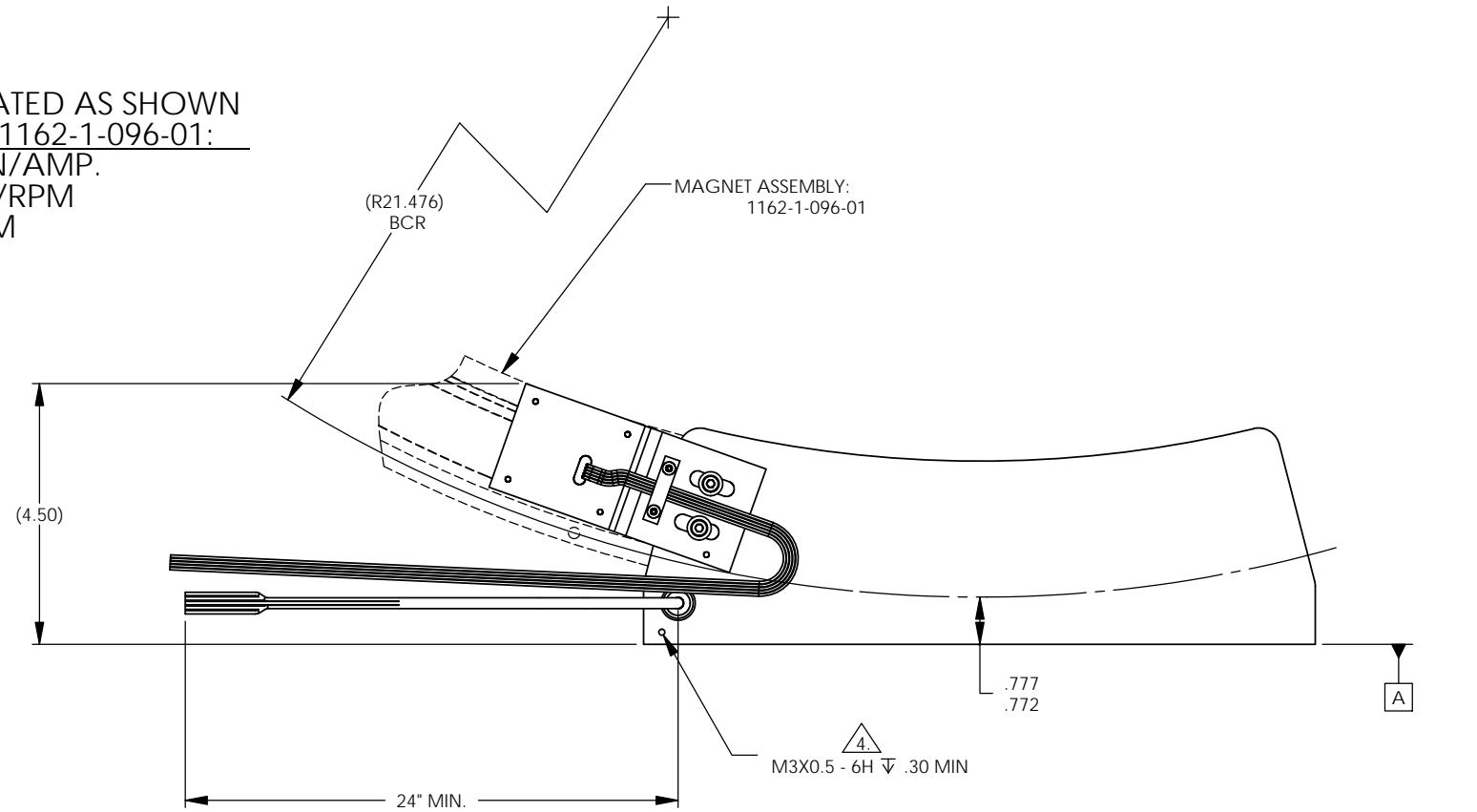
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FORCER ASSY P/N:
1162-1-090-01

PERFORMANCE WHEN MATED AS SHOWN
WITH MAGNET ASSEMBLY 1162-1-096-01:

Kt: 1600 ($\pm 10\%$) OZ-IN/AMP.
Ke: 1250 ($\pm 10\%$) Vpk/RPM
Res: 57.0 ($\pm 10\%$) OHM
L : 32.0 ($\pm 25\%$) mH

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
A	000370	INITIAL RELEASE	21-JUL-2006	A.L.
B	002674	CHANGED NOTE 1. WAS $\phi 21.476$	28-OCT-11	ADR



NOTES:

1.) ALIGN THE FORCER RADIALLY SO THE FORCER DATUM A IS .777" / .772" OUTSIDE OF BOLT CIRCLE (R21.476") ON MAGNET ASSEMBLY: 1162-1-096-01.

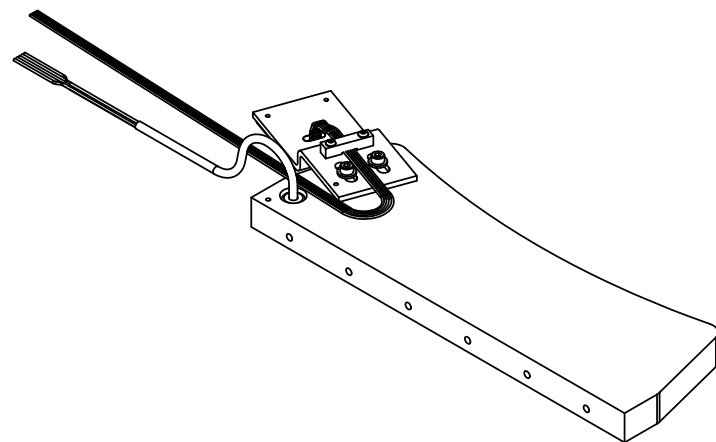
2.) FORCER SHOULD BE MOUNTED SO THAT THE AIR GAP BETWEEN THE FORCER DATUM B AND THE MAGNET ASSEMBLY IS .030" NOMINALLY.

3.) LEAD COLOR CODE:
PWR LEADS - 22 AWG, TEFLON COATED
RED - PHASE A
BLK - PHASE B
WHT - PHASE C

HALL LEADS - 28 AWG COLORED RIBBON
GRN - +5 VOLTS
YLW - GND
ORG - HALL 2
RED - HALL 1
BRN - HALL 3

TEMP. SWITCH - 22 AWG, TEFLON COATED
CANTHERM P/N: F1110025ACFA06E
NORMALLY CLOSED
BLU - TEMP SWITCH
BLU - TEMP SWITCH

4. DEPTH .300", DO NOT DRILL.



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CONFIDENTIAL

APPLIMOTION, INC.

DWG. NO: 1162-1-095-01
PROJECT: 1162
TITLE: FORCER INTERFACE
SHEET 1 of 1

DRAWN BY: ARL
CHECKED BY:
APPROVED BY: SRP
UNITS: INCH
SCALE: NTS
DATE: 07/21/2006

CAGE CODE: 3DRL5
DRAWING SYMBOLS & TOLERANCE PER ANSI Y14.5
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
DECIMALS LINEAR ANGULAR
X ±0.020 ±1°
XX ±0.010 ±0.2°
XXX ±0.005 ±0.01°

6

5

4

3

2

1

FORCER ASSY P/N:
1162-1-100-01

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
A	002439	INITIAL RELEASE	18-JUL-11	JPC

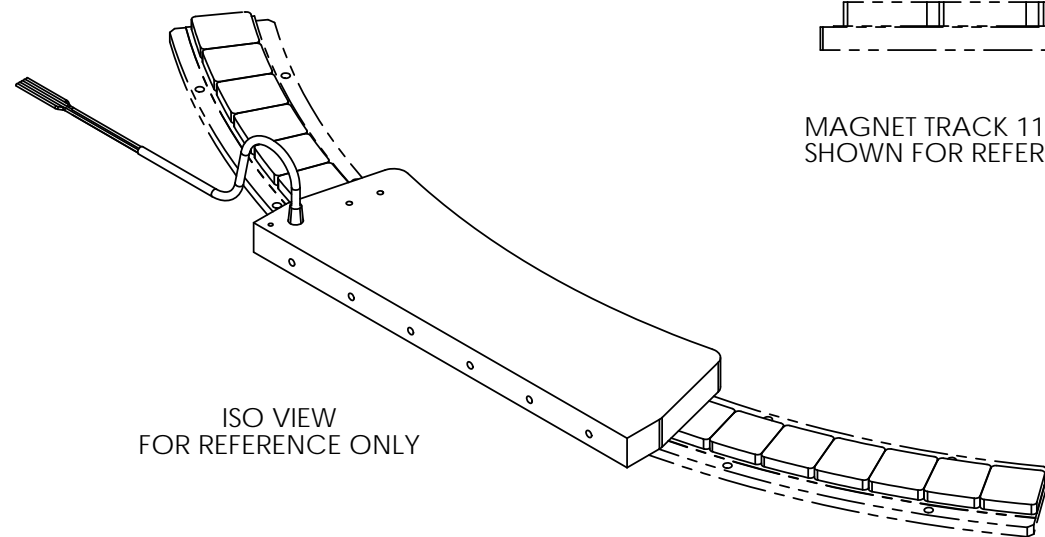
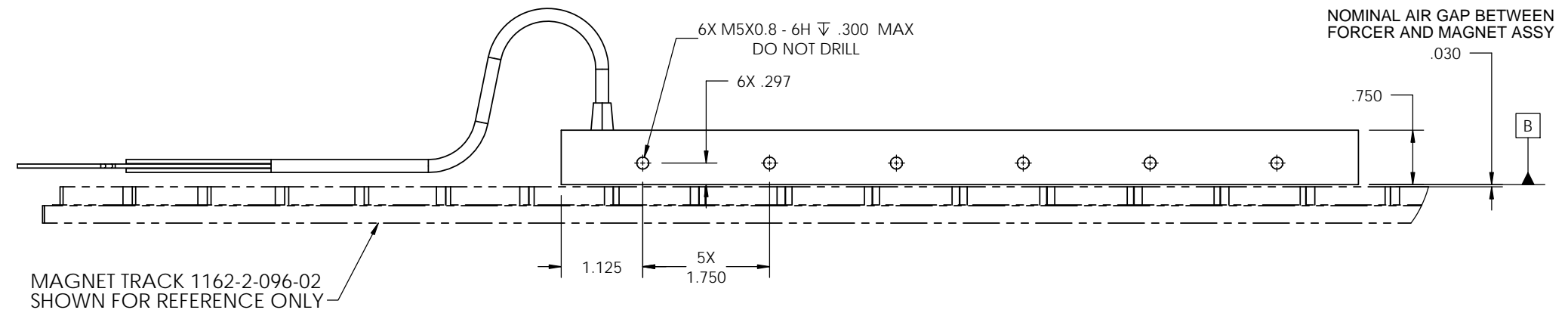
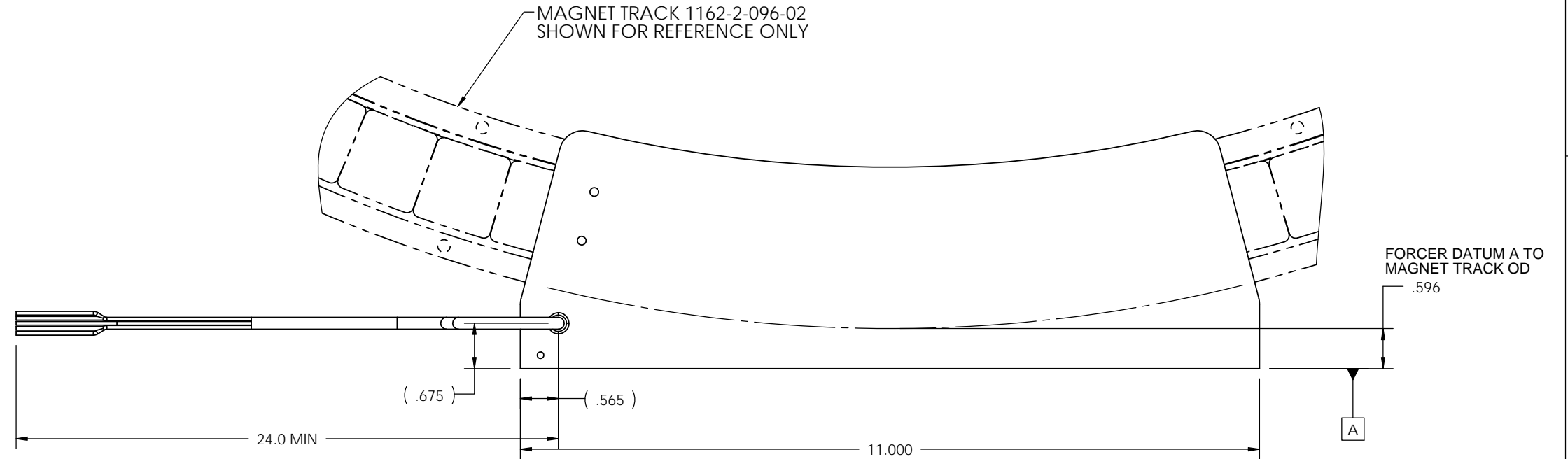
PERFORMANCE WHEN MATED AS SHOWN
WITH MAGNET ASSEMBLY 1162-2-096-02:

Kt: 1600 ($\pm 10\%$) OZ-IN/AMP.
Ke: 1250 ($\pm 10\%$) Vpk/RPM
Res: 57.0 ($\pm 10\%$) OHM
L : 32.0 ($\pm 25\%$) mH

LEAD COLOR CODE:

PWR LEADS - 22 AWG, TEFLON COATED
RED - PHASE A
BLK - PHASE B
WHT - PHASE C

TEMP. SWITCH - 22 AWG, TEFLON COATED
CANTHERM P/N: F1110025ACFA06E
NORMALLY CLOSED
BLU - TEMP SWITCH
BLU - TEMP SWITCH



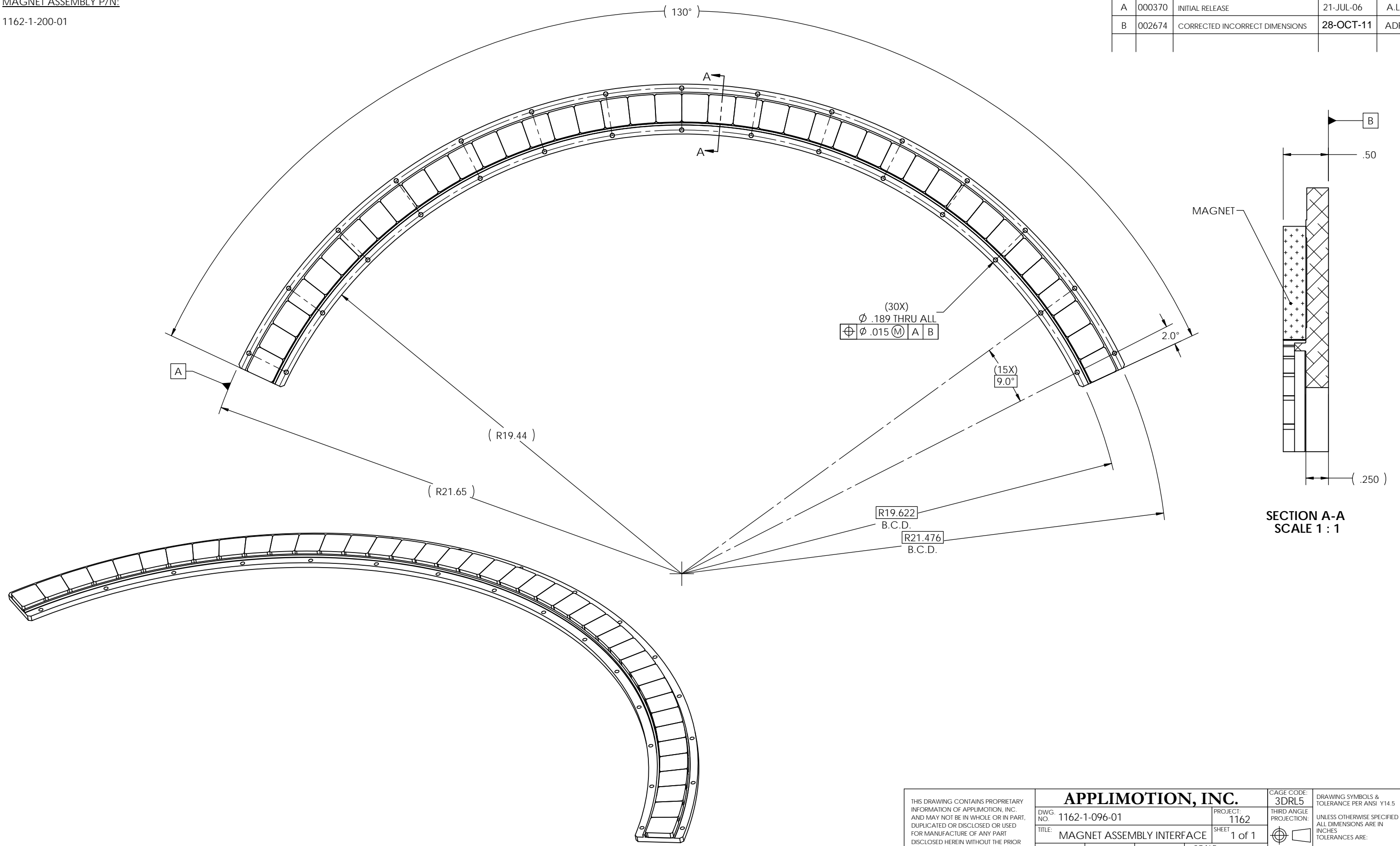
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DWG. NO: 1162-1-095-02	PROJECT: 1162	TITLE: FORCER INTERFACE		THIRD ANGLE PROJECTION:	UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE:
SCALE: N/A	UNITS: INCH	DRAWN BY: JPC	CHECKED BY: DML	COG ENGINEER: DML	DECIMALS LINEAR ANGULAR X ± 0.020 $\pm 1^\circ$ XX ± 0.010 $\pm 0.2^\circ$ XXX ± 0.005 $\pm 0.01^\circ$
DATE: 7/18/2011		DATE: 7/18/2011		DATE: 7/18/2011	
SURFACE FINISH: N/A					

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MAGNET ASSEMBLY P/N:
1162-1-200-01

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
A	000370	INITIAL RELEASE	21-JUL-06	A.L.
B	002674	CORRECTED INCORRECT DIMENSIONS	28-OCT-11	ADR

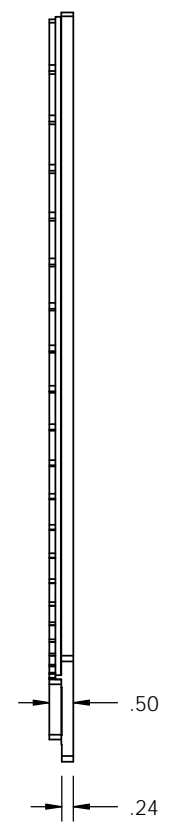
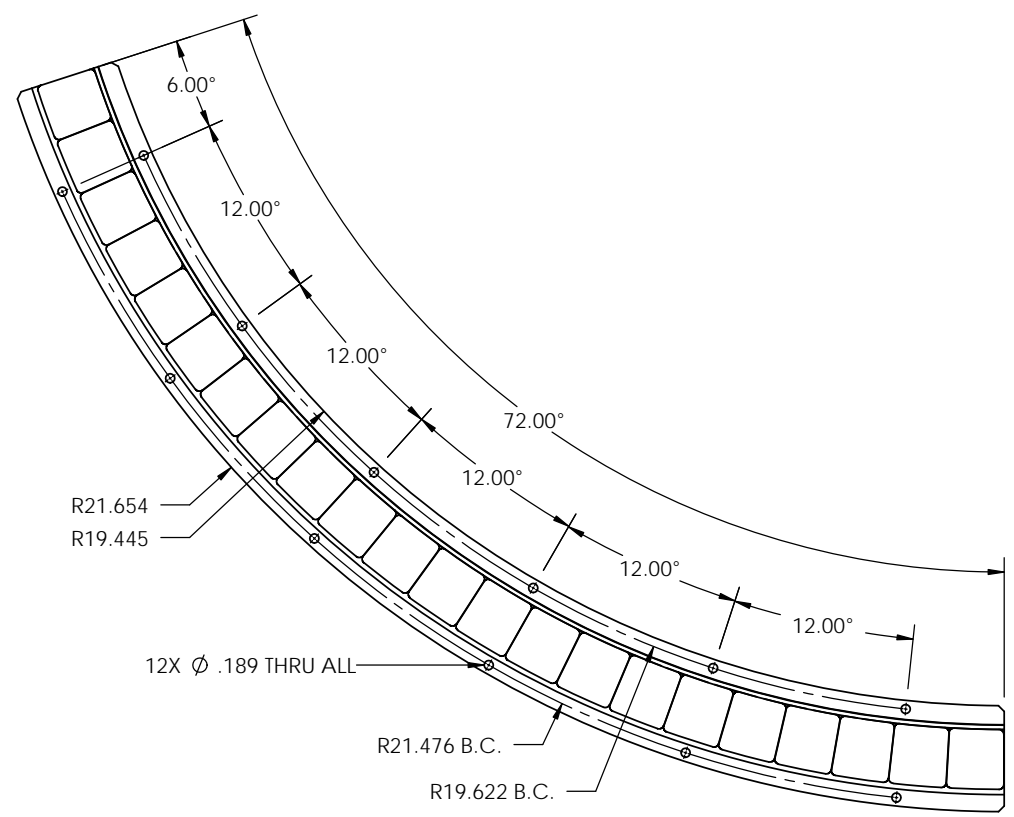


SECTION A-A
SCALE 1 : 1

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DWG. NO.: 1162-1-096-01	PROJECT: 1162	THIRD ANGLE PROJECTION:	SHEET 1 of 1	SURFACE FINISH: N/A	DECIMALS LINEAR ANGULAR X ±0.020 ±1° XX ±0.010 ±0.2° XXX ±0.005 ±0.01°
TITLE: MAGNET ASSEMBLY INTERFACE	DRAWN BY: ARL 07/07/06	CHECKED BY:	COG ENGINEER SRP 07/21/06	SCALE: NIS UNITS: INCH	PRINTED COPIES OF THIS DOCUMENT ARE NOT CONTROLLED

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REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
A	002375	INITIAL RELEASE	21-JUN-11	JPC



NOTES: (UNLESS OTHERWISE SPECIFIED)
 1. MAGNET ASSY P/N: 1162-1-200-02

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CONFIDENTIAL

APPLIMOTION, INC.		CAGE CODE: 3DRL5	DRAWING SYMBOLS & TOLERANCE PER ANSI Y14.5
DWG NO: 1162-1-096-02	PROJECT: 1162	THIRD ANGLE PROJECTION: 	UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE:
TITLE: MAGNET TRACK INTERFACE DWG		SHEET 1 of 1	DECIMALS LINEAR ANGULAR .X ±0.02 ±.5° .XX ±0.01 ±0.2° .XXX ±0.005 ±0.01°
DRAWN BY: DML 6/13/11	CHECKED BY: JPC 6/21/11	COG ENGINEER DML 6/13/11	SCALE : NTS UNITS : INCHES
		SURFACE FINISH : N/A	

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FORCER ASSY P/N:
1257-1-100-01

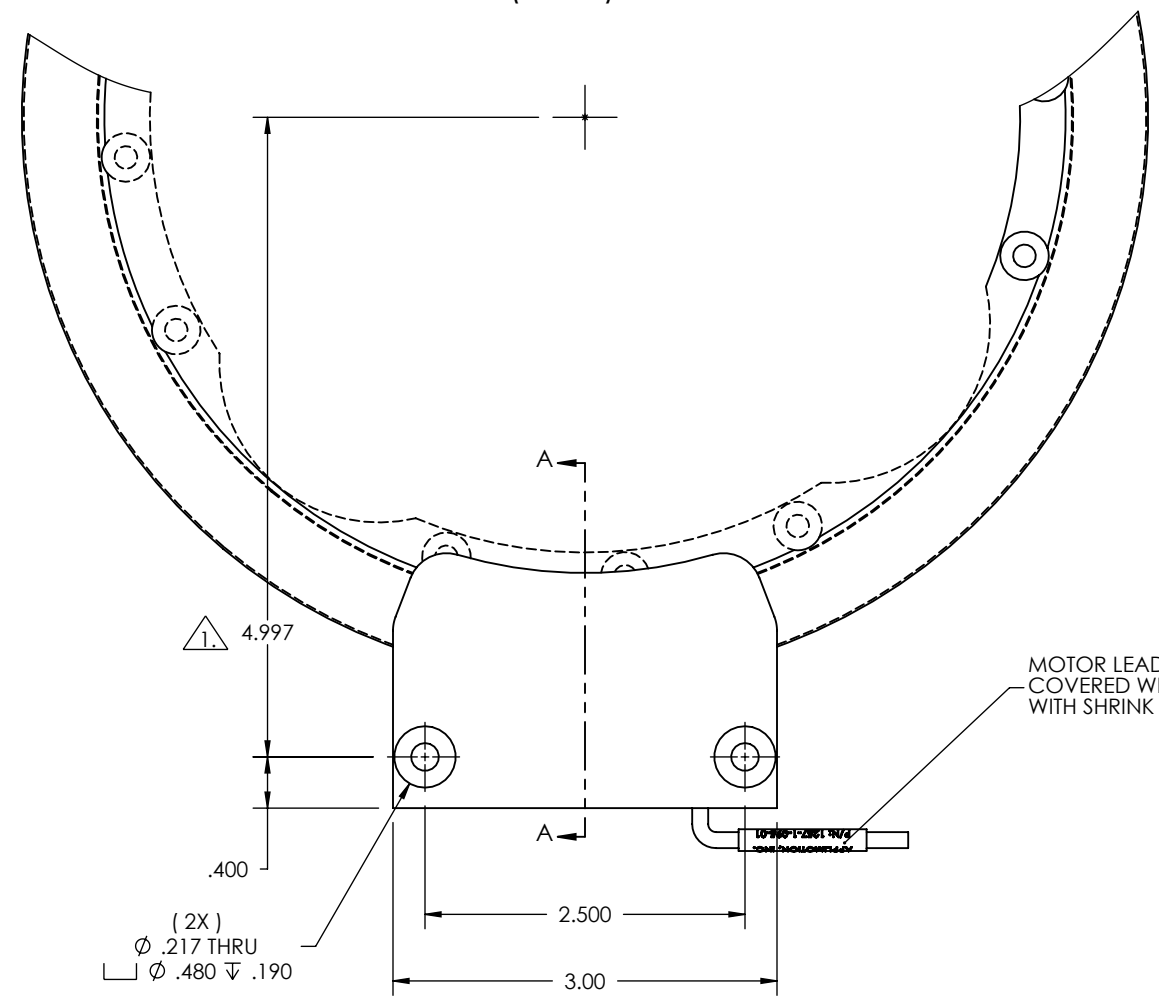
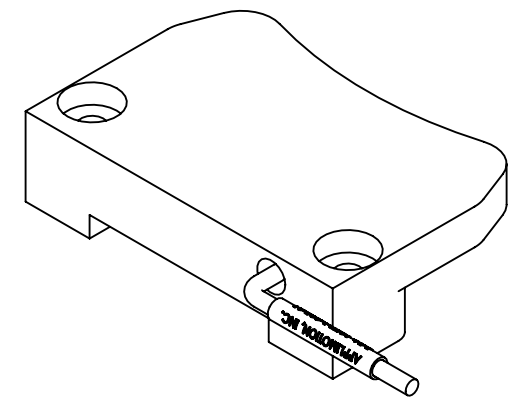
PERFORMANCE WHEN MATED AS SHOWN
WITH MAGNET ASSEMBLY 1257-1-096-01:

Kt: 27.3 (±10%) OZ-IN/AMP.
Ke: 20.2 (±10%) V/KRPM
Res: 5.3 (±10%) OHM
L: 1.1 (±25%) mH

NOTES:

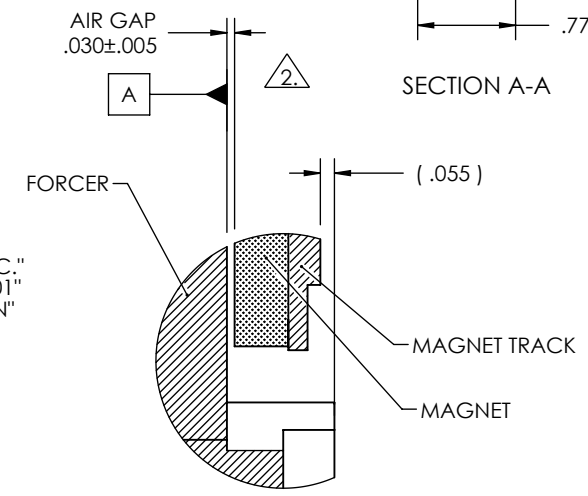
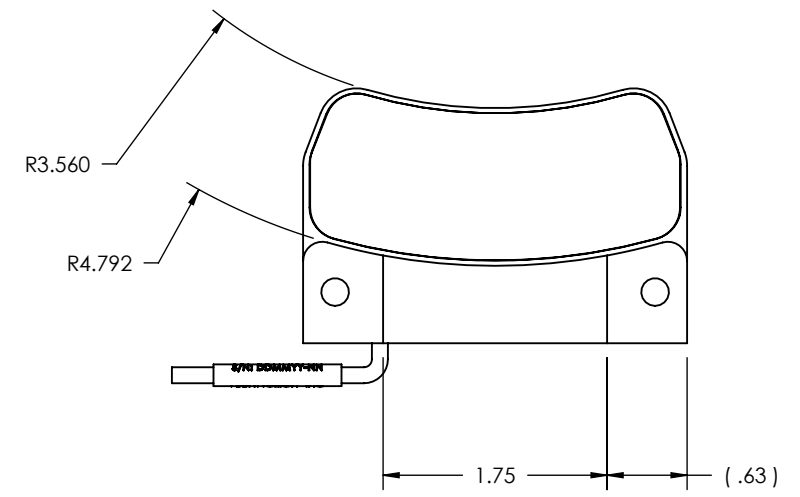
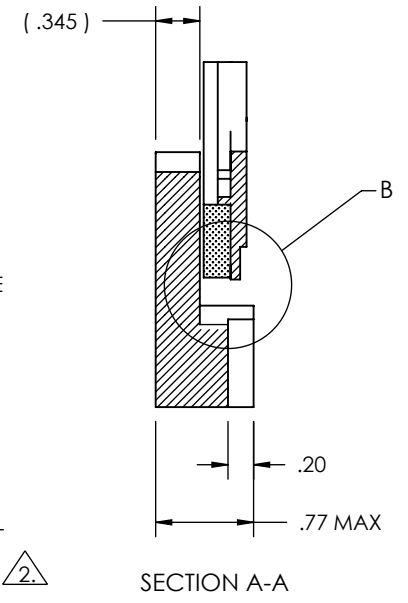
1. ALIGN THE FORCER RADIALLY SO THE FORCER ϕ .217" THRU HOLES IS 4.997" FROM THE CENTER OF THE MAGNET ASSEMBLY P/N: 1257-1-096-01.
2. FORCER SHOULD BE MOUNTED SO THAT THE AIR GAP BETWEEN THE FORCER DATUM A AND THE MAGNET ASSEMBLY IS .030" NOMINALLY.
- 3.) LEAD COLOR CODE:
PWR LEADS - 22 AWG, TEFLON COATED
BLK - PHASE A
RED - PHASE B
WHT - PHASE C

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
P1	000860	INITIAL RELEASE	22-FEB-2008	A.L.
A	000895	UPDATED NOTES AND PERFORMANCE DATA	04-ARP-2008	A.L.



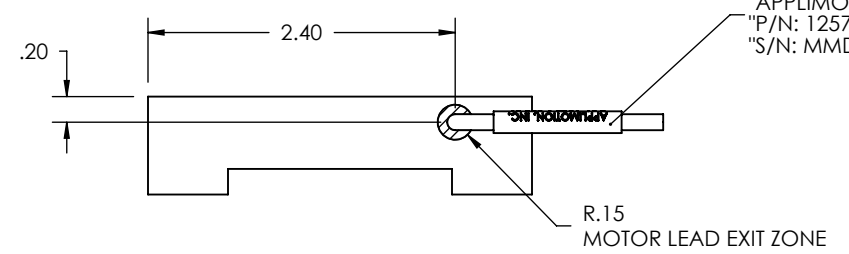
MOTOR LEADS 36" IN MIN. LENGTH COVERED WITH PET EXPANDABLE SLEEVE WITH SHRINK TUBING ON ENDS

(2X)
 ϕ .217 THRU
 ϕ .480 ∇ .190



AIR GAP
.030±.005

WIRE LABEL:
"APPLIMOTION INC."
"P/N: 1257-1-095-01"
"S/N: MMDDYY-NN"



R.15
MOTOR LEAD EXIT ZONE

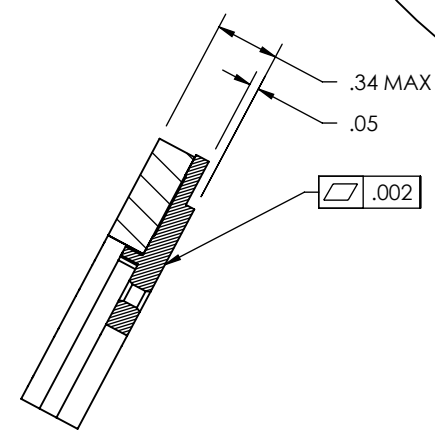
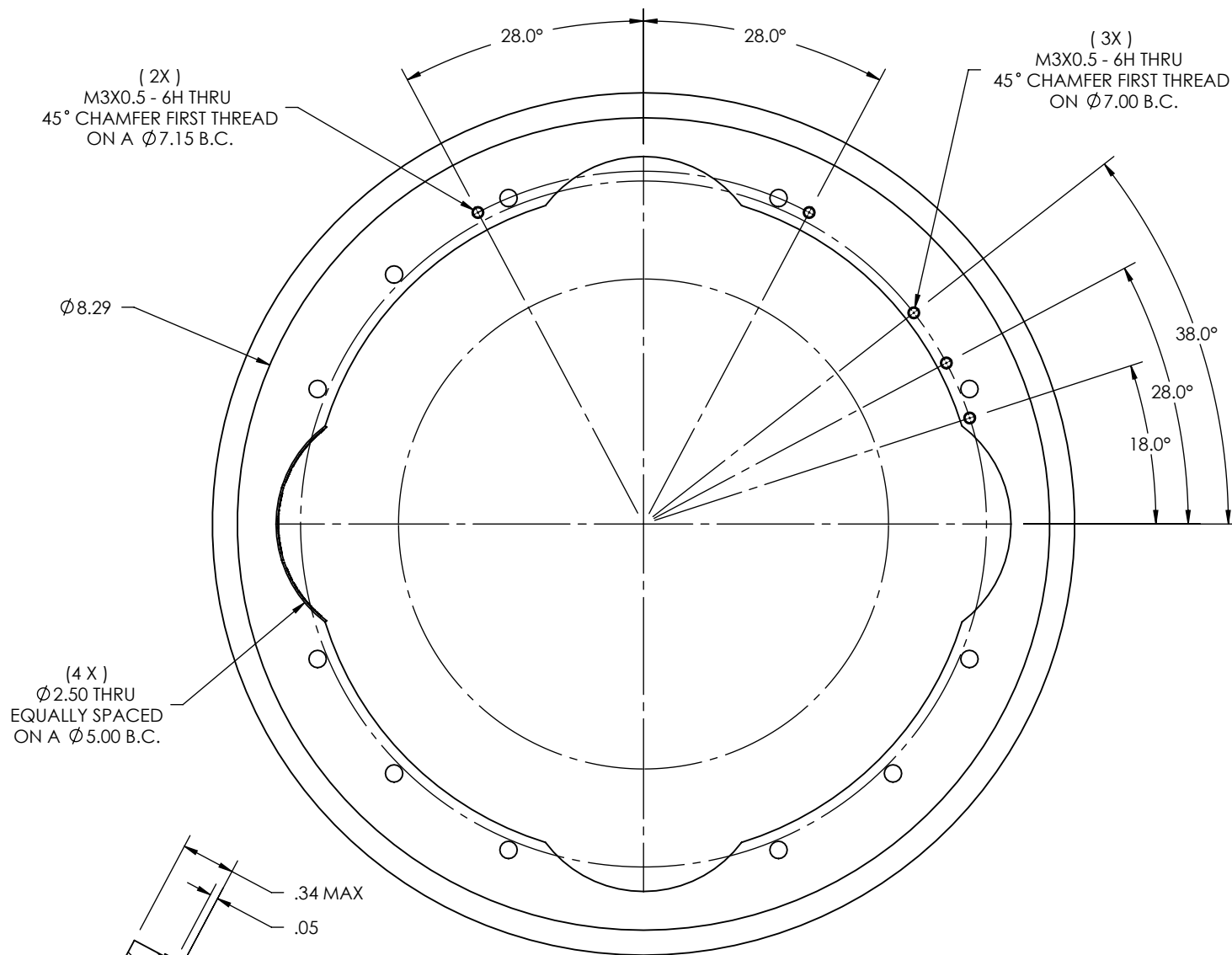
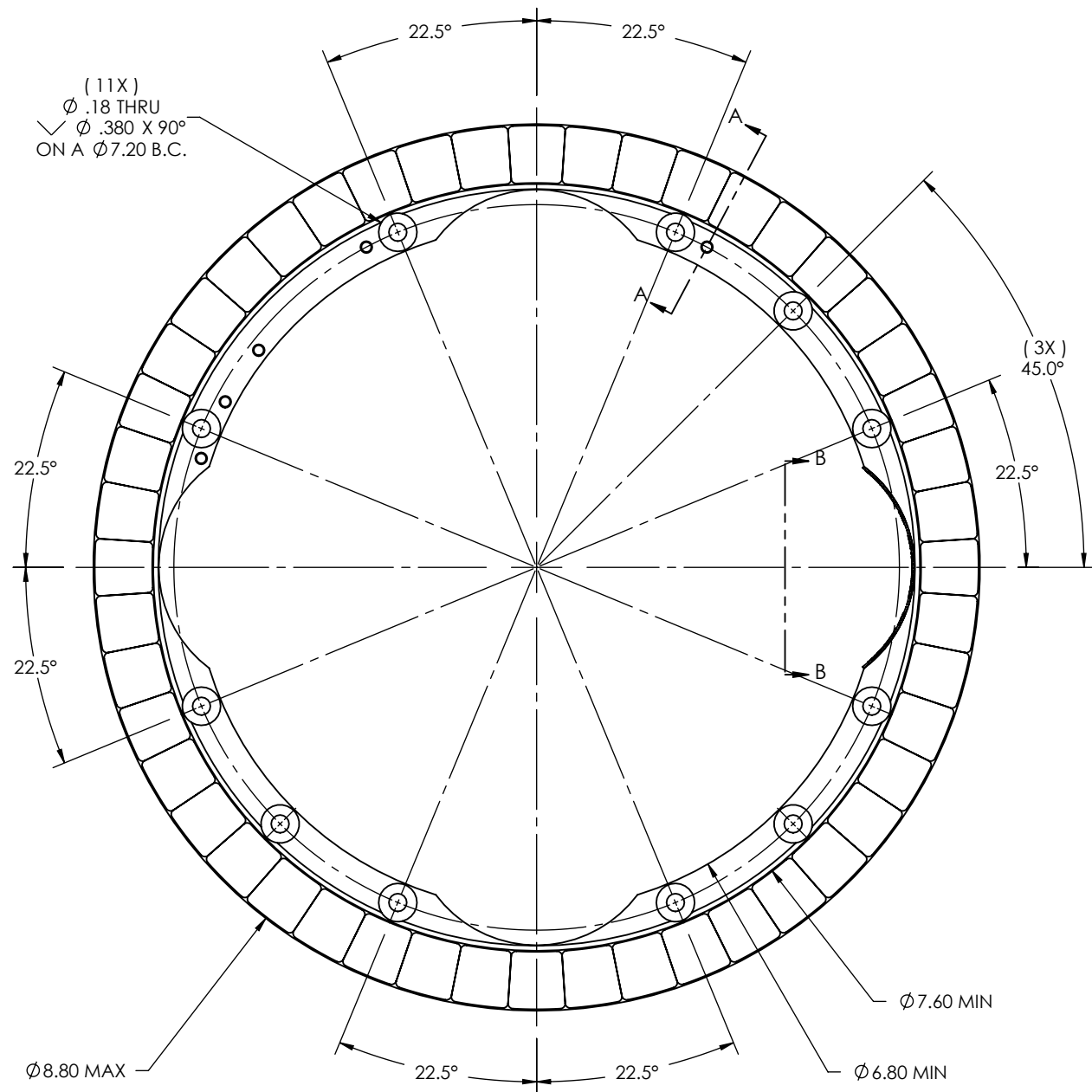
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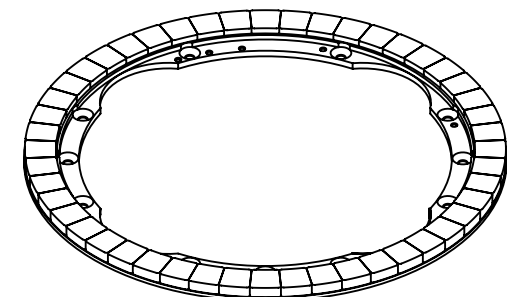
APPLIMOTION, INC.		CAGE CODE:	DRAWING SYMBOLS & TOLERANCE PER ANSI Y14.5
DWG. NO. 1257-1-095-01	PROJECT: 1257	3DRL5	UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE:
TITLE: COIL ASSEMBLY INTERFACE	SHEET 1 of 1	THIRD ANGLE PROJECTION:	DECIMALS LINEAR ANGULAR
DRAWN BY: ARL	CHECKED BY:	SCALE: NTS	.X ±0.020 ±1°
02/21/2008	APPROVED BY: SRP	UNITS: INCH	.XX ±0.010 ±0.2°
	02/22/2008		.XXX ±0.005 ±0.01°
		SURFACE FINISH: N/A	

MAGNET ASSEMBLY P/N:
1257-1-200-01

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
P1	000860	INITIAL RELEASE	22-FEB-2008	A.L.
A	000895	ADDED LABEL INFO	04-APR-2008	A.L.



SECTION A-A



APPLIMOTION, INC. P/N: 1257-1-096-01 S/N: MMDDYYNN

LABEL: "APPLMOTION, INC."

LABEL: "P/N: 1257-1-096-01"

LABEL: "S/N: MMDDYY-NN"

SECTION B-B

THIS DRAWING CONTAINS PROPRIETARY INFORMATION OF APPLIMOTION, INC. AND MAY NOT BE IN WHOLE OR IN PART, DUPLICATED OR DISCLOSED OR USED FOR MANUFACTURE OF ANY PART DISCLOSED HEREIN WITHOUT THE PRIOR WRITTEN PERMISSION OF APPLIMOTION INC.		APPLIMOTION, INC.		CAGE CODE: 3DRL5	DRAWING SYMBOLS & TOLERANCE PER ANSI Y14.5
DWG. NO.: 1257-1-096-01	PROJECT: 1257	SHEET: 1 of 1	THIRD ANGLE PROJECTION:	UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE:	
TITLE: MAGNET ASSEMBLY INTERFACE	SCALE: NTS	UNITS: INCH	SURFACE FINISH: N/A	DECIMALS .X ±0.020 ±1* .XX ±0.010 ±0.2* .XXX ±0.005 ±0.01*	
DRAWN BY: ARL 01/31/2008	CHECKED BY:	APPROVED BY: SRP 02/22/2008	SCALE: NTS		
CONFIDENTIAL					

REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
P1	004203	INITIAL RELEASE	2013-SEPT-20	GSM

APPLIMOTION PART NUMBER : 1554-1-000-01(FORCER & TRACK ASSY)

PERFORMANCE WHEN MATED WITH TRACK 1554-1-096-01
(AIR GAP : 0.030 in)

Res: 10.9 (±10%) OHM
Ke: 389 (±10%) V/KRPM
Kt(TRAP): 525 (±10%) oz-in/AMP DC
L: 9.14 (±25%)mH

NUMBER OF MAGNET POLES: 48

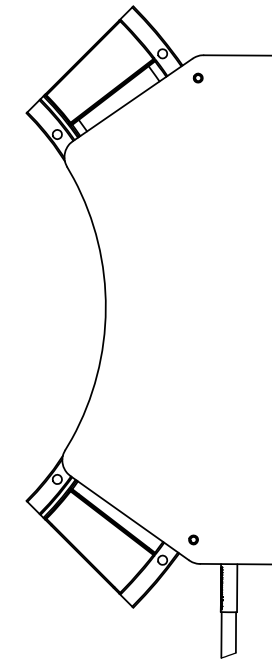
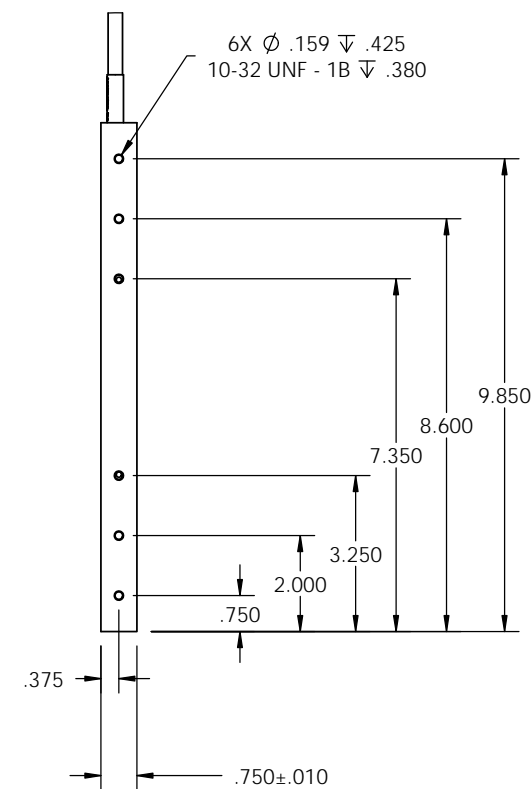
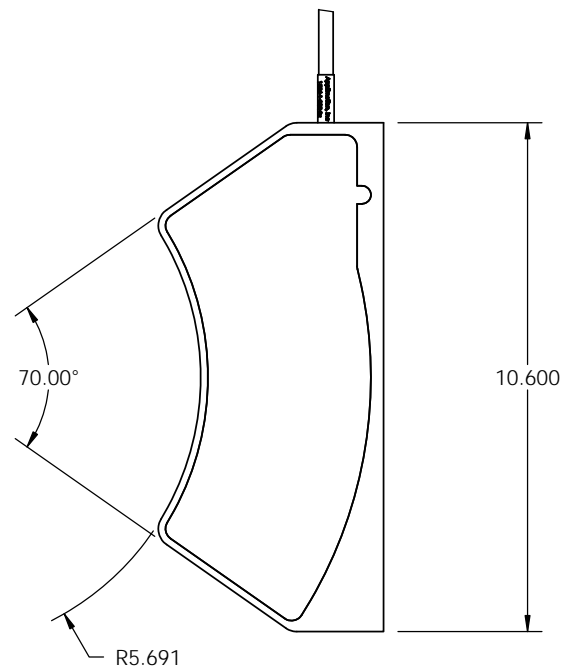
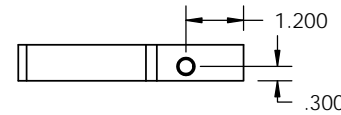
LEAD COLOR CODE

POWER LEADS

BELDEN 83334E MULTI-CONDUCTOR CABLE
22 AWG, TEFLON COATED LEADS WITH BRAIDED SHIELD AND TEFLON JACKET

24" MIN LENGTH

BLK - PHASE A
RED - PHASE B
WHT - PHASE C



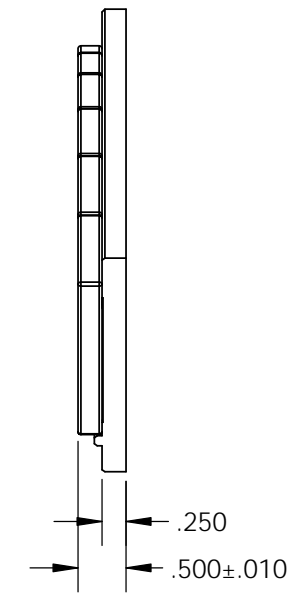
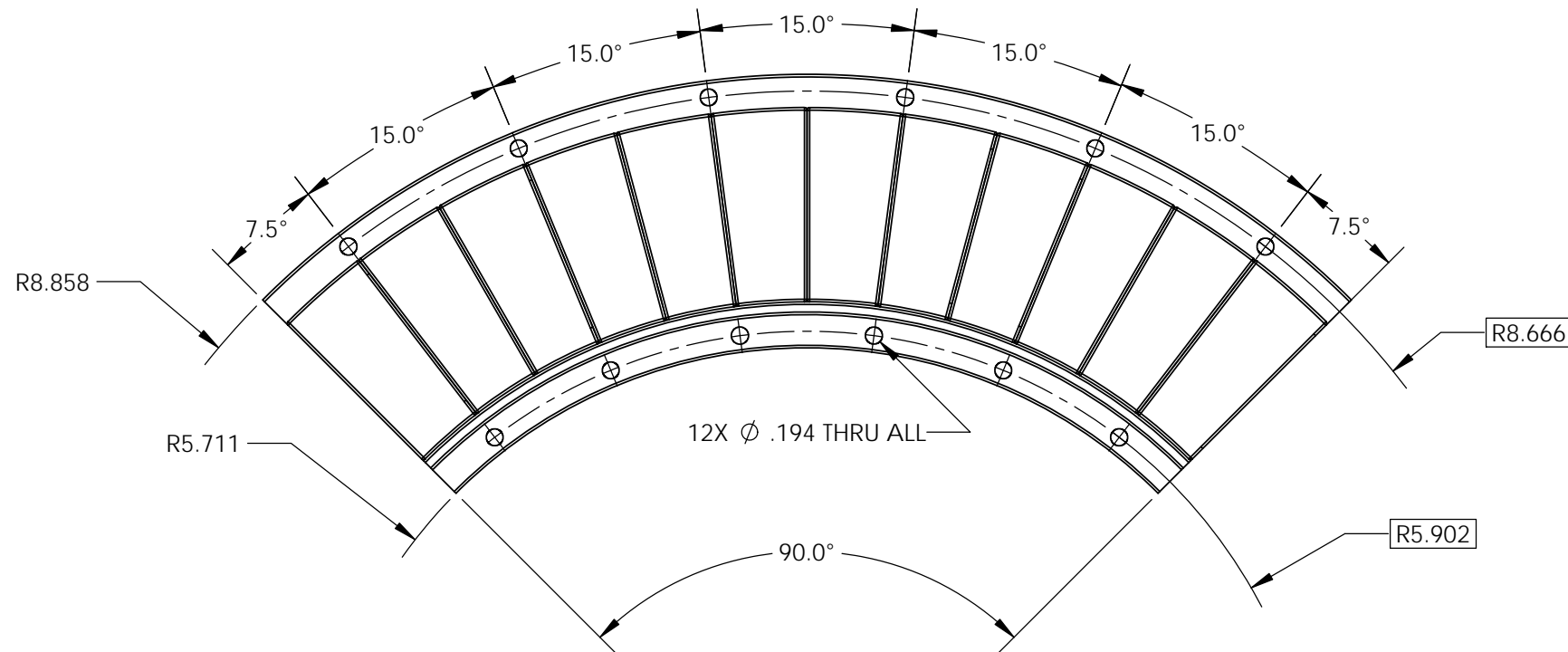
FORCER AND MAGNET TRACK PLACED CONCENTRICALLY WITH AXIAL AIRGAP OF .030 BETWEEN MAGNET TOP SURFACE AND FORCER BOTTOM SURFACE.

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DWG. NO: 1554-1-095-01	PROJECT: 1554	TITLE: FORCER INTERFACE DWG		THIRD ANGLE PROJECTION:	UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE:
DRAWN BY: GSM	CHECKED BY: DML	COG ENGINEER: DML	SCALE: N1S	SURFACE FINISH: SEE NOTES	DECIMALS LINEAR ANGULAR X ±0.020 ±1° XX ±0.010 ±0.2° XXX ±0.005 ±0.01°
9/19/2013	9/19/2013	9/19/2013	UNITS: INCH		

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REV.	DCN:	DESCRIPTION OF CHANGE:	DATE:	SIGN
P1	004203	INITIAL RELEASE	2013-SEPT-20	GSM



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DWG. NO: 1554-1-096-01	PROJECT: 1554	TITLE: MAGNET TRACK INTERFACE		THIRD ANGLE PROJECTION:	UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE:
DRAWN BY: GSM	CHECKED BY: DML	COG ENGINEER: DML	SCALE: N1S	SHEET: 1 of 1	DECIMALS LINEAR ANGULAR
9/19/2013	9/19/2013	9/19/2013	UNITS: INCH	SURFACE FINISH: SEE NOTES	X ±0.020 ±1° XX ±0.010 ±0.2° XXX ±0.005 ±0.01°

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