

# 작업공정사진철

고객명: (주)

공사명: DC SPINDLE MOTOR REWINDING

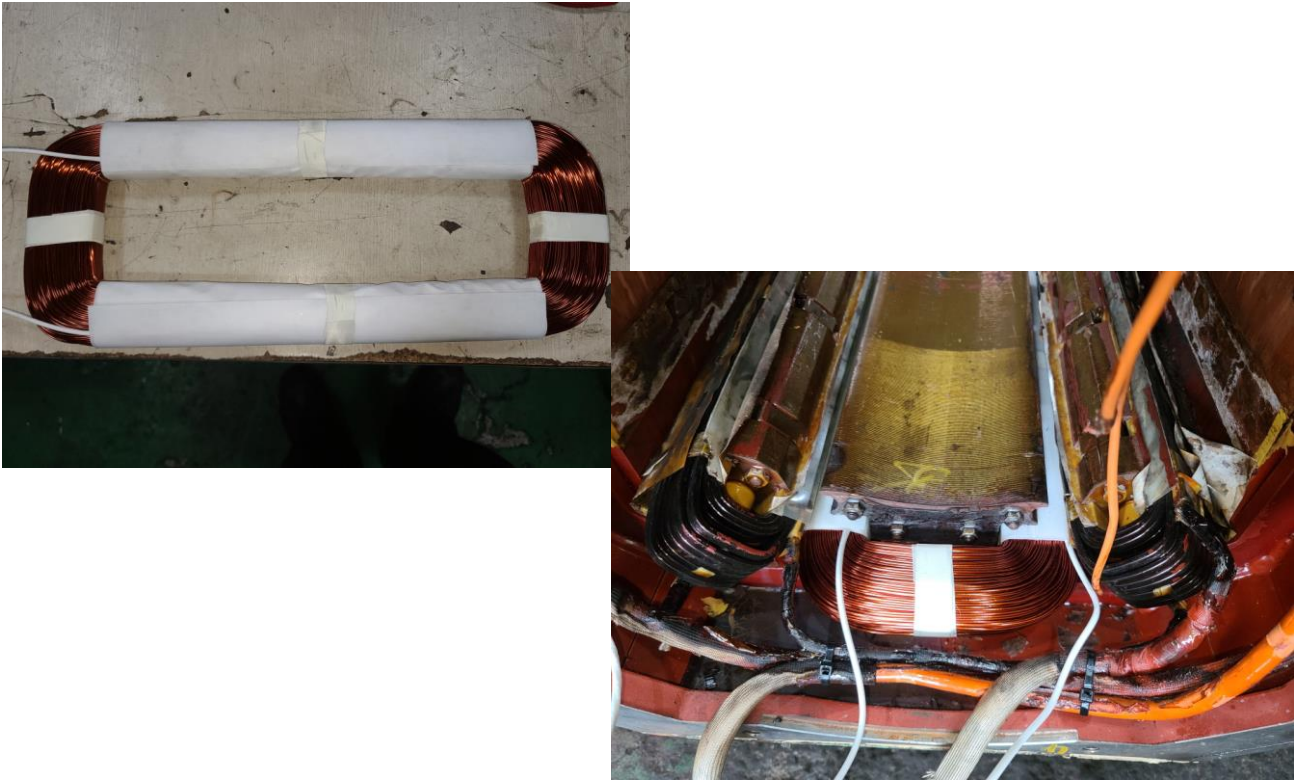
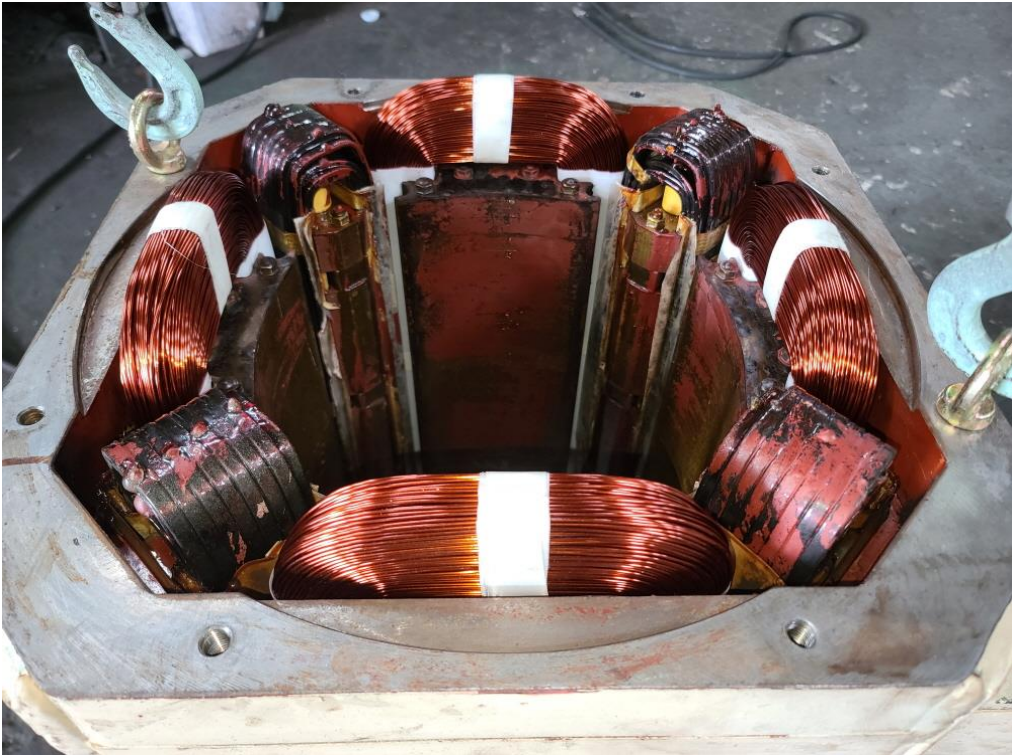
규격: DC MOTOR 117KW 380V

REPAIR 내역: 분해 조립 및 불순물 CLEANSING DRYING  
FIELD REWINDING  
INSULATING VARNISH DIPPING DRYING  
COMMUTATOR 동심도 가공 및 UNDERCUTTING  
양측 HOUSING METALLIZING 연마  
BALANCING 및 UNBALANCE교정  
BEARING및 BRUSH 교환  
BLOWER 및 FAN MOTOR 보수  
출고검사 시운전 TEST 및 COLOR PAINTING



<http://jinyangmotor.com/>



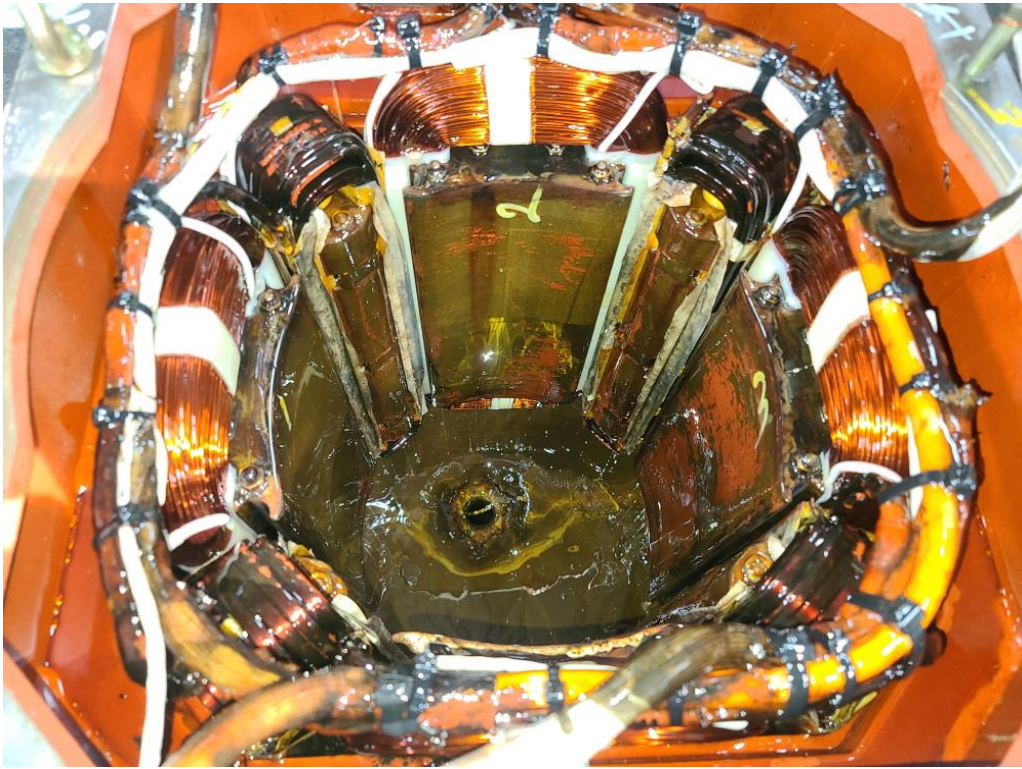
JIN YANG	작업 공정 사진
작업공정	DC MOTOR 117KW 용 BLOWER 입고검사
	
FIELD 권선	재 권선 및 권선삽입 실시
JIN YANG	DC MOTOR 117KW FIELD REWINDING
	
FIELD 권선	재 권선 및 권선삽입

JIN YANG

작업 공정 사진

작업공정

DC MOTOR 117KW FIELD REWINDING



FIELD 권선

재 권선 실시 후

작업공정

DC MOTOR 117KW FIELD REWINDING



계자 권체

INSULATING VARNISH DIPPING & DRYING 실시

JIN YANG

# 작업 공정 사진

작업공정

DC MOTOR 117KW FIELD REWINDING

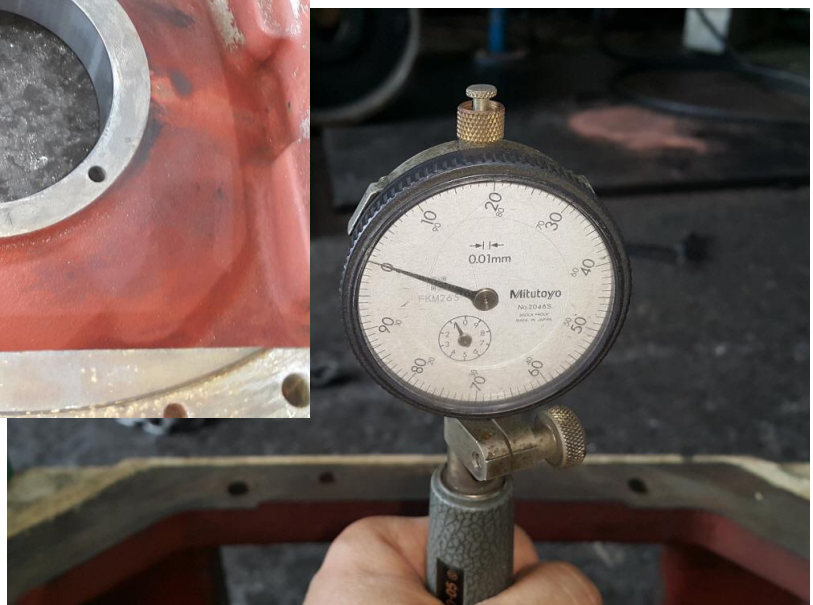


계자 권체

절연건조 실시 완료

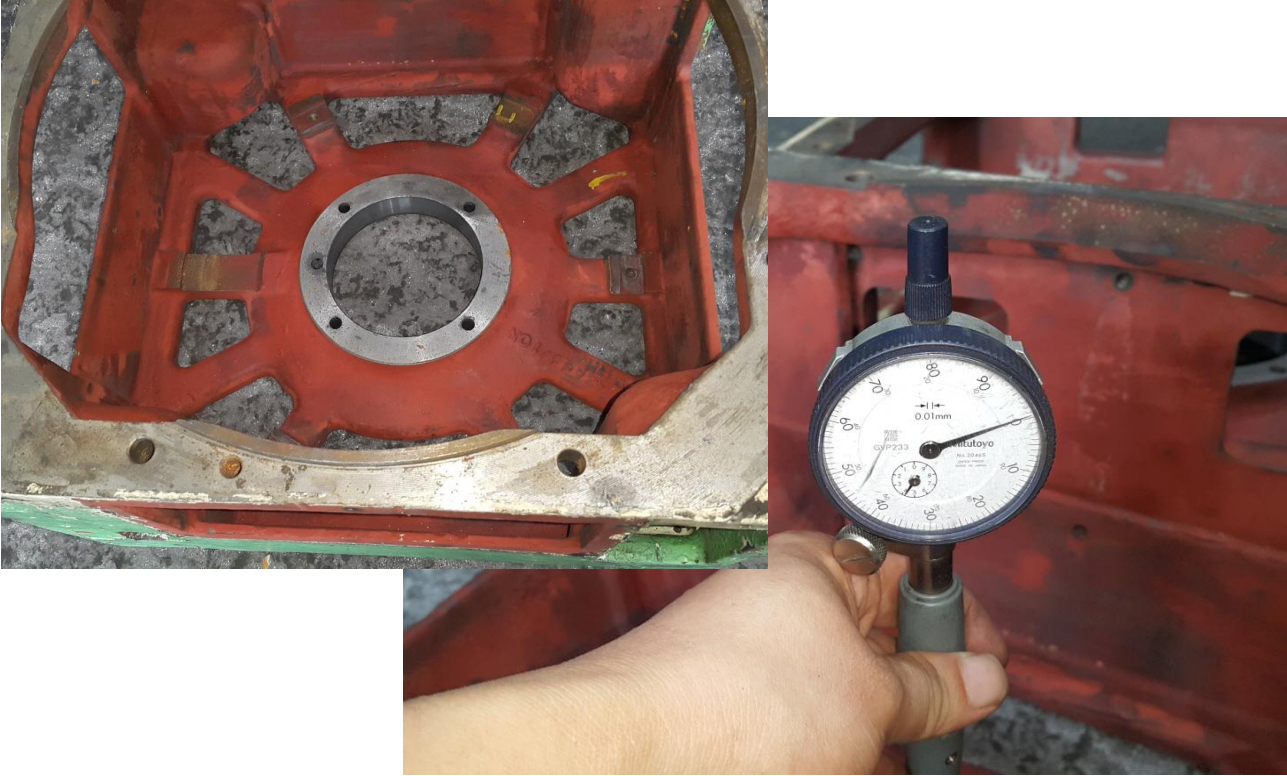
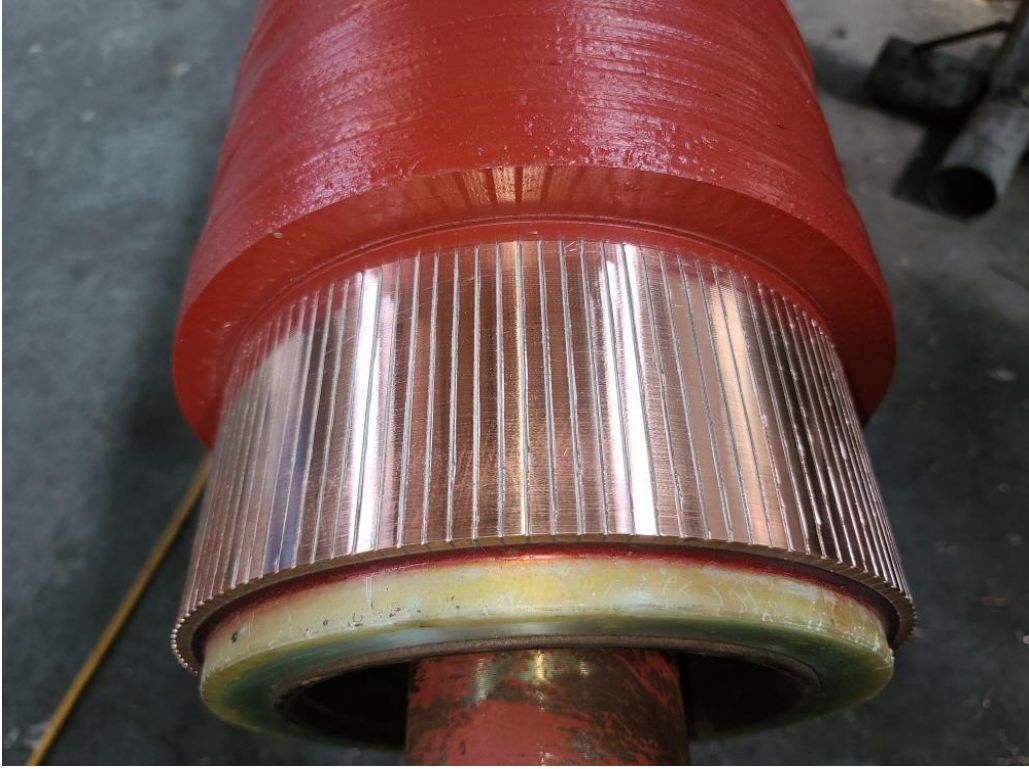
작업공정

DC MOTOR 117KW FIELD REWINDING



BRACKET

부하측 HOUSING METALLIZING 연마 후 검사 0/100

JIN YANG	작업 공정 사진
작업공정	DC MOTOR 117KW FIELD REWINDING
	
BRACKET	반 부하측 HOUSING METALLIZING 연마 후 검사 0/100
작업공정	DC MOTOR 117KW FIELD REWINDING
	
COMMUTATOR	동심도 가공 흠파기 및 UNDERCUTTING 실시

JIN YANG

# 작업 공정 사진

작업공정

DC MOTOR 117KW FIELD REWINDING



ARMATURE

BALANCING 실시 교정된 UNBALANCE REPORT 참조

작업공정

DC MOTOR 117KW FIELD REWINDING



BRARING

BEARING 예열 실시

JIN YANG	작업 공정 사진
작업공정	DC MOTOR 117KW FIELD REWINDING
	
BRARING	BEARING 예열삽입 및 GREASE CHARGING 조립실시
작업공정	DC MOTOR 117KW FIELD REWINDING
	
소모품	BRUSH 교환

JIN YANG

작업 공정 사진

작업공정

DC MOTOR 117KW FIELD REWINDING

ARMATURE  
절연저항



ARMATURE  
권선저항

FIELD  
절연저항



FIELD  
권선저항

출고검사

절연저항 & 권선저항

작업공정

DC MOTOR 117KW FIELD REWINDING



출고검사

시운전 TEST실시

JIN YANG

작업 공정 사진

작업공정

DC MOTOR 117KW FIELD REWINDING

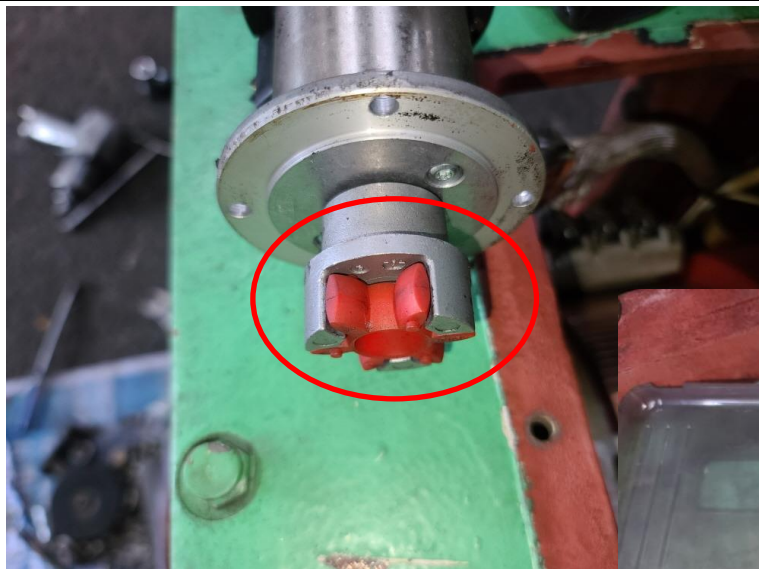


출고검사

시운전 TEST 운전 MONITORING

작업공정

DC MOTOR 117KW FIELD REWINDING



T/Q 고무라바 교환



출고검사

운전 MONITORING SPEED & T/Q 출력 전압

JIN YANG

작업 공정 사진

작업공정

DC MOTOR 117KW FIELD REWINDING



BRACKET

양측 HOUSING BUSHING 가공삽입 후 검사 1/100

작업공정

DC MOTOR 117KW FIELD REWINDING



ROTOR

BEARING교환 조립실시

JIN YANG	작업 공정 사진
작업공정	DC MOTOR 117KW FIELD REWINDING
	
BLOWER	시운전 TEST 실시 운전 CURRENT
작업공정	DC MOTOR 117KW FIELD REWINDING
	
Ass'y	출고검사 후 COLOR PAINTING

# BALANCING INSPECTION REPORT

## SETUP

PART NAME : DC ROTOR			
CUSTOMER : 영산기계			
TEST TIME : 2022. 7. 28 15:19:41			
GRADE	: G 6.3	RATING SPEED	: 2700 rpm
WEIGHT	: 272.000 kg	TESTING SPEED	: 521 rpm
DIAMETER	: 290 mm	CORRECTION	: ADD
ACCEPTABLE UNBALANCE			
PLANE1	: 20.9 gr	PLANE2	: 20.9 gr

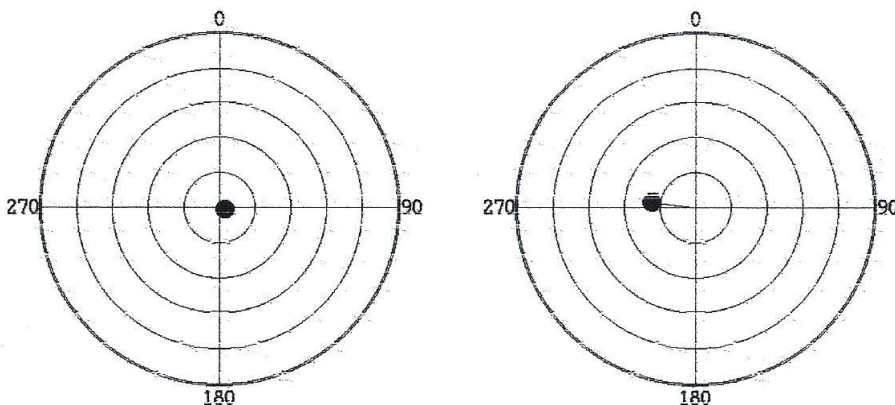
## INITIAL UNBALANCE

	PLANE1	PLANE2
UNBALANCE	12.2 gr	53.1 gr
ANGLE	170 deg	7 deg
RESULT	ACCEPT	REJECT

## CORRECT UNBALANCE

	PLANE1	PLANE2
UNBALANCE	1.8 gr	12.5 gr
ANGLE	112 deg	277 deg
RESULT	ACCEPT	ACCEPT

CORRECT UNBALANCE GRAPH (max = 50.0 gr )



진양전기  
 경남 마산시 내서읍 중리 1123-3번지  
 TEL (055) - 231-9318-9  
 FAX (055) - 231-9314

# BALANCING INSPECTION REPORT

## SETUP

PART NAME : DC ROTOR			
CUSTOMER : 영산기계			
TEST TIME : 2022. 7.28. 15:30:55			
GRADE	: G 6.3	RATING SPEED	: 2700 rpm
WEIGHT	: 272.000 kg	TESTING SPEED	: 520 rpm
DIAMETER	: 290 mm	CORRECTION	: ADD
ACCEPTABLE UNBALANCE			
PLANE1	: 20.9 gr	PLANE2	: 20.9 gr

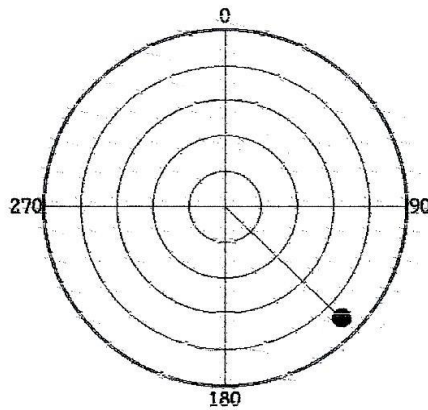
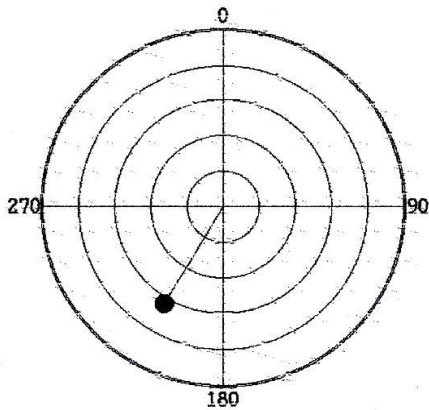
## INITIAL UNBALANCE

	PLANE1	PLANE2
UNBALANCE	3.2 gr	4.5 gr
ANGLE	211 deg	134 deg
RESULT	ACCEPT	ACCEPT

## CORRECT UNBALANCE

	PLANE1	PLANE2
UNBALANCE	3.2 gr	4.5 gr
ANGLE	211 deg	134 deg
RESULT	ACCEPT	ACCEPT

CORRECT UNBALANCE GRAPH (max = 5.0 gr )



진양전기

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