

작업공정사진철

고객명: (주)

공사명: SIEMENS VECTOR MOTOR OVERHAUL

규격: 113~147KW 340~460V 34~46Hz 1000~1360RPM

REPAIR 내역: 분해 조립 및 조립부품 불순물 CLEANSING
INSULATING VARNISH DIPPING DRYING
양측 HOUSING METALLIZING 연마
BEARING 교환
BALANCING 및 UNBALANCE교정
BLOWER BEARING교환
입 출고검사 및 시운전 TEST



<http://jinyangmotor.com/>



JIN YANG	작업 공정 사진
작업공정	147KW VECTOR MOTOR 입고검사
	
Ass'y	분해 전
작업공정	147KW VECTOR MOTOR 입고검사
	
권선검사	절연저항 이상 & 각 상별 권선저항

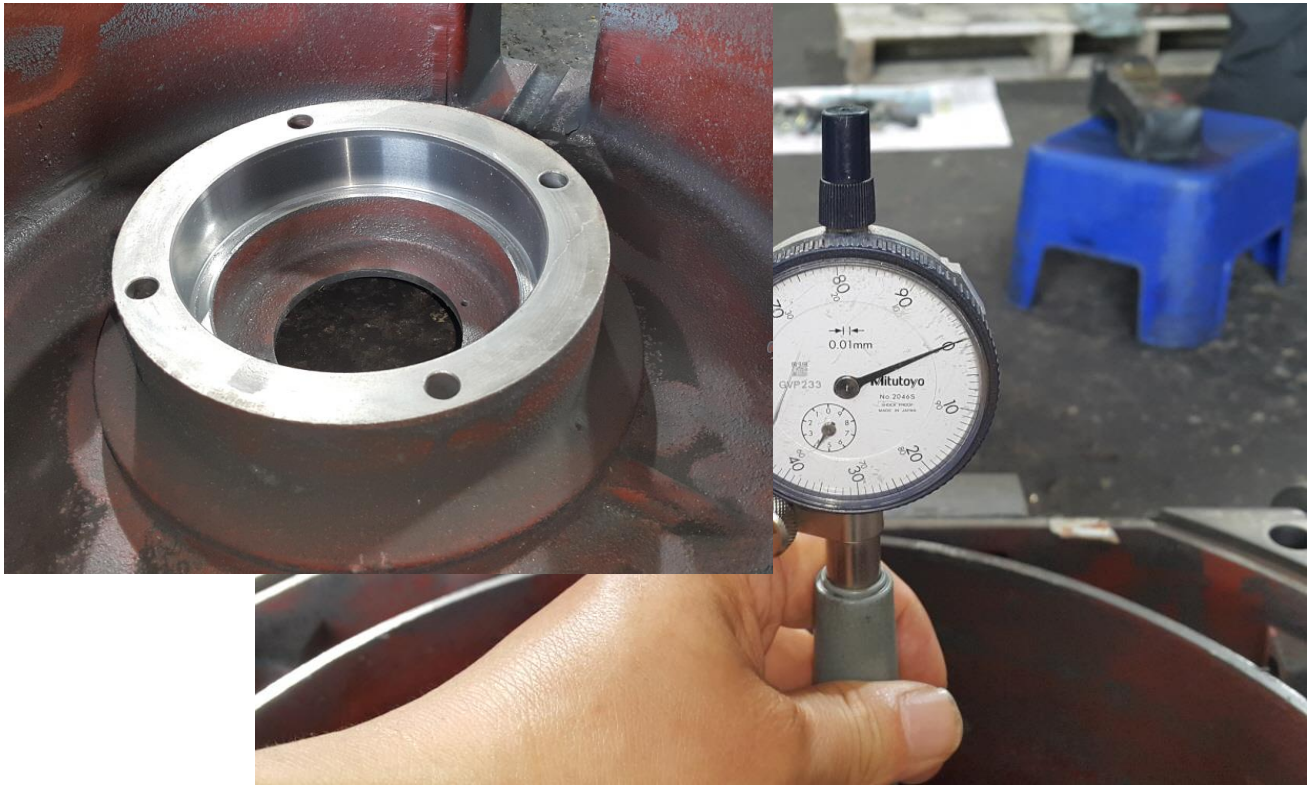
JIN YANG	작업 공정 사진
작업공정	147KW VECTOR MOTOR 입고검사
	
	
권선검사	FAN MOTOR 절연저항 & 각 상별 권선저항 동일
작업공정	147KW VECTOR MOTOR 입고검사
	
BRACKET	부하측 HOUSING검사 6/100으로 불량

JIN YANG	작업 공정 사진
작업공정	147KW VECTOR MOTOR 입고검사
	
BRACKET	반 부하측 HOUSING검사 6/100으로 불량
작업공정	147KW VECTOR MOTOR 입고검사
	
STATOR 권체	권선상테 양호

JIN YANG	작업 공정 사진
작업공정	147KW VECTOR MOTOR OVERHAUL
	
STATOR 권체	계척건조 실시
작업공정	147KW VECTOR MOTOR OVERHAUL
	
ROTOR	BALANCING 실시 및 초기UNBALACE

JIN YANG	작업 공정 사진
작업공정	147KW VECTOR MOTOR OVERHAUL
	
ROTOR	교정된 UNBALACE REPORT
작업공정	147KW VECTOR MOTOR OVERHAUL
	
소모품	BEARING 예열 실시

JIN YANG	작업 공정 사진
작업공정	147KW VECTOR MOTOR OVERHAUL
	
반 부하측 절연 BEARING	
ROTOR	BEARING 예열삽입 및 GREASE CHARGING 조립실시
작업공정	147KW VECTOR MOTOR OVERHAUL
	
BRACKET	부하측 HOUSING METALLIZING 연마 후 검사 0/100

JIN YANG	작업 공정 사진
작업공정	147KW VECTOR MOTOR OVERHAUL
	
BRACKET	반 부하측 HOUSING METALLIZING 연마 후 검사 0/100
작업공정	147KW VECTOR MOTOR OVERHAUL
	
조립부품	보수 후 세척 실시

JIN YANG

작업 공정 사진

작업공정

147KW VECTOR MOTOR OVERHAUL



권선검사

절연저항 & 각 상별 권선저항

작업공정

147KW VECTOR MOTOR OVERHAUL



Ass'y

시운전 TEST 실시

JIN YANG	작업 공정 사진
작업공정	147KW VECTOR MOTOR OVERHAUL
	
	
BLOWER	BEARING 교환 실시
작업공정	147KW VECTOR MOTOR OVERHAUL
	
	
BLOWER	시운전 TEST 운전 CURRENT

시운전 TEST 운전 MONITORING

STARTER - TEST - [Drive unit:1,VECTOR_03 - Expert list]

Project Control panel Edit Target system View Options Window Help

VECTOR_03

Insert DCC chart

Configuration

Expert list

Drive navigator

Control logic

Setpoint channel

Open-loop/closed-loop control

Functions

Messages and monitoring

Commissioning

Control panel

Device trace

Function generator

Measuring function

Automatic controller setting

Stationary/turning measurement

Communication

Expert list

Enter search text

hexadecimal

Param...	Data	Parameter text	Online value VECTOR_03	Unit	Modifiable to	Access level	Minimum	Maximum
1 i2	All	Drive operating display	[0] Operation - everything ...	All	All	All		
2 p5[0]	All	BOP operating display selection, Parameter number	2		Operation	2	0	65535
3 p6	All	BOP operating display mode	[4] p0005		Operation	3		
4 p10	All	Drive commissioning parameter filter	[0] Ready		Ready to run	1		
5 p13[0]	All	BOP user-defined list	0		Operation	3	0	65535
6 p15	All	Macro drive object	0		Commission...	1	0	999999
7 i20	All	Speed setpoint smoothed	1500.0	rpm		2		
8 i21	All	CO: Actual speed smoothed	1499.5	rpm		2		
9 i22	All	Speed actual value rpm smoothed	1499.5	rpm		2		
10 i24	All	Output frequency smoothed	50.0	Hz		3		
11 i25	All	CO: Output voltage smoothed	389.5	Vrms		2		
12 i26	All	CO: DC link voltage smoothed	600.5	V		2		
13 i27	All	CO: Absolute actual current smoothed	73.54	Arms		2		
14 i28	All	Modulation depth smoothed	91.5	%		3		
15 i30	All	r-current actual value Ramp generation smoothed	73.61	Arms		3		

Drive_unit_1: VECTOR_03

Give up control priority

Enables

DDS: 0

DOS: 0

Help

n setpoint specification

n = 1500 rpm

0% n x 101 % = 200%

1515.00 rpm

[0] Operation - everything enabled

Enables available

Diagnostics

OFF1 enable

OFF2 enable

OFF3 enable

Enable operation

Ramp-function gen. enable

Ramp-function generator start

Setpoint enable

Speed: 1500.0 rpm

Actual: 1500.5 rpm

Torque: 9.92 9.04 Nm

Output frequency smoothed 50.0 Hz

CO: Output voltage smoothed 389.5 Vrms

Motor current: 73.68 Arms

Torque utilization: 1.3 %

Control panel

target system output

Load to PG output

Diagnostics overview

Press F1 to open Help display.

찾기

Control priority [Drive control panel] - stop with spacebar

Realtek USB GbE Family Controller, TCP Online mode

오후 4:33

2024-06-16

BALANCING INSPECTION REPORT

SETUP

PART NAME : SERVO ROTOR			
CUSTOMER :			
TEST TIME : 2024. 6.16 14:59:40			
GRADE :	G 6.3	RATING SPEED :	1350 rpm
WEIGHT :	294.000 kg	TESTING SPEED :	541 rpm
DIAMETER :	290 mm	CORRECTION :	ADD
ACCEPTABLE UNBALANCE			
PLANE1 :	45.2 gr	PLANE2 :	45.2 gr

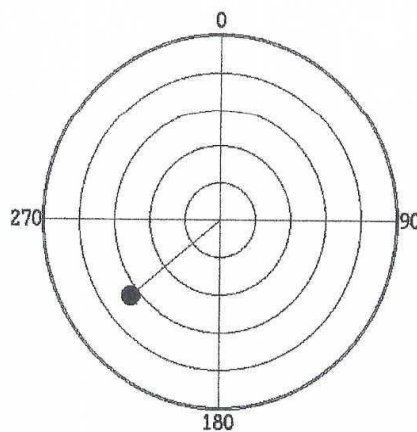
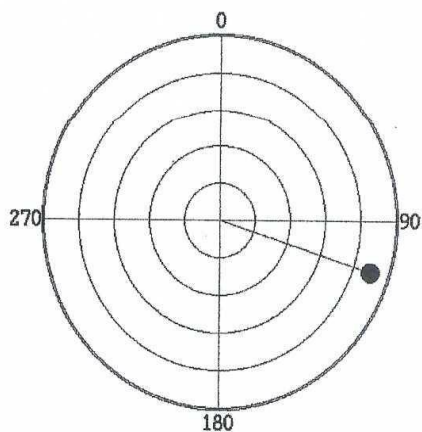
INITIAL UNBALANCE

	PLANE1	PLANE2
UNBALANCE	20.7 gr	46.4 gr
ANGLE	111 deg	318 deg
RESULT	ACCEPT	REJECT

CORRECT UNBALANCE

	PLANE1	PLANE2
UNBALANCE	9.0 gr	6.5 gr
ANGLE	108 deg	231 deg
RESULT	ACCEPT	ACCEPT

CORRECT UNBALANCE GRAPH (max = 10.0 gr)



진 양 전 기

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