

작업공정사진철

고객명: (주)
공사명: COOLING TOWER MOTOR OVERHAUL

규격: AC MOTOR 175HP(132KW) 4P 440V

REPAIR 내역: 분해 조립 및 조립부품 불순물 CLEANSING
INSULATING VARNISH DIPPING DRYING
2번 SHAFT BEARING부 METALLIZING 연마
BALANCING 및 UNBALANCE교정
BEARING 교환
입 출고검사 시운전 TEST 및 COLOR PAINTING



<http://jinyangmotor.com/>



JIN YANG

작업 공정 사진

작업공정

AC MOTOR 175HP 입고검사



Ass'y

분해 전

작업공정

AC MOTOR 175HP 입고검사

No.1



No.1

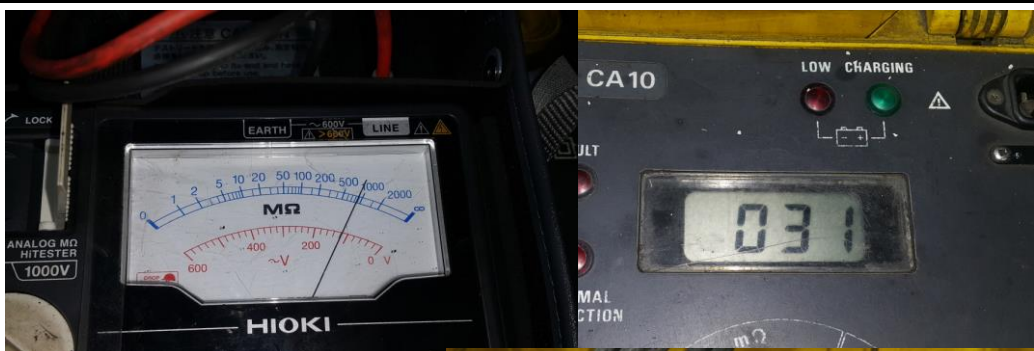


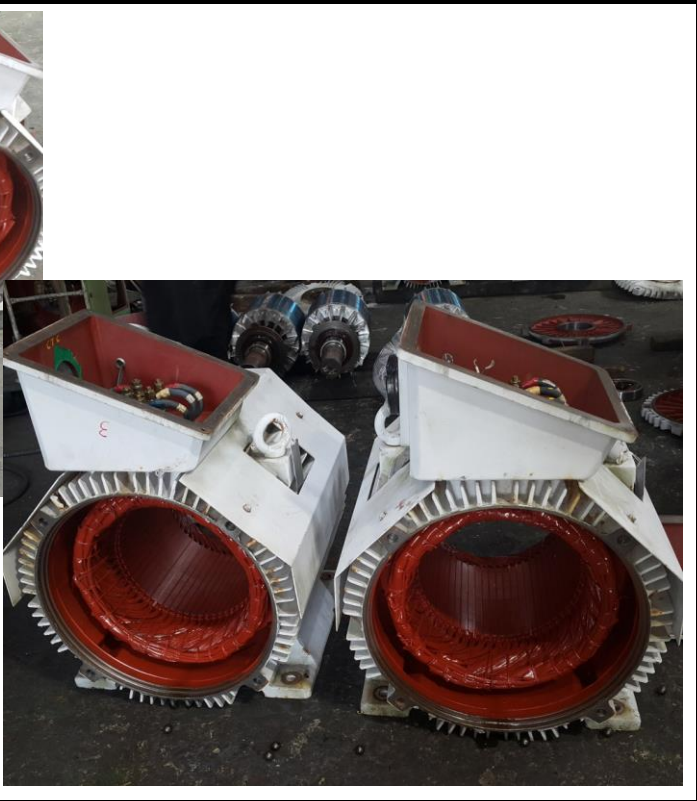
No.2



No.2

권선검사

절연저항 & 각 상별 권선저항 동일

JIN YANG	작업 공정 사진	
작업공정	AC MOTOR 175HP 입고검사	
No.3		No.3
No.4		No.4
권선검사	절연저항 & 각 상별 권선저항 동일	
작업공정	AC MOTOR 175HP 입고검사	
		
STATOR권체	분해 실시	

JIN YANG	작업 공정 사진
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작업공정	AC MOTOR 175HP 입고검사
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ROTOR	분해 후 BEARING 취외
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작업공정	AC MOTOR 175HP 입고검사
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ROTOR 2번	부하측 BEARING부 이상으로 인하여 BALANCING을 실시할수 없음
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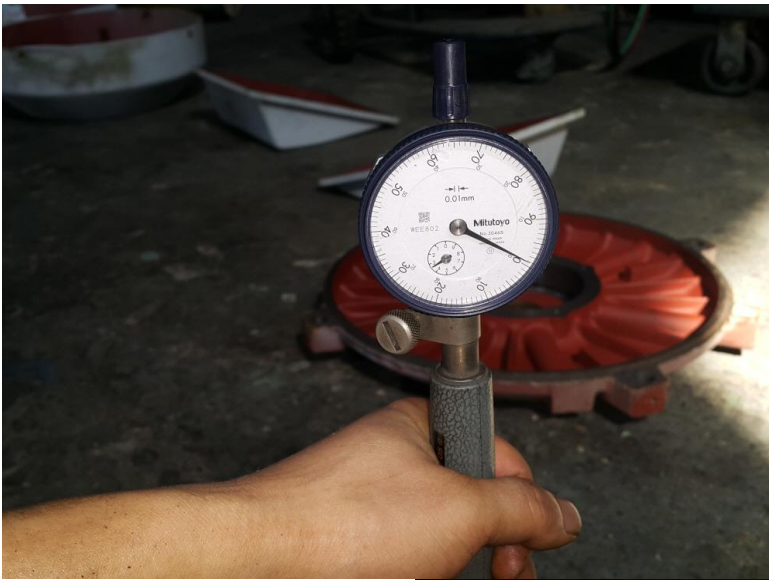
METALLIZING 연마 복원이 필요	
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JIN YANG

작업 공정 사진

작업공정

AC MOTOR 175HP 입고검사

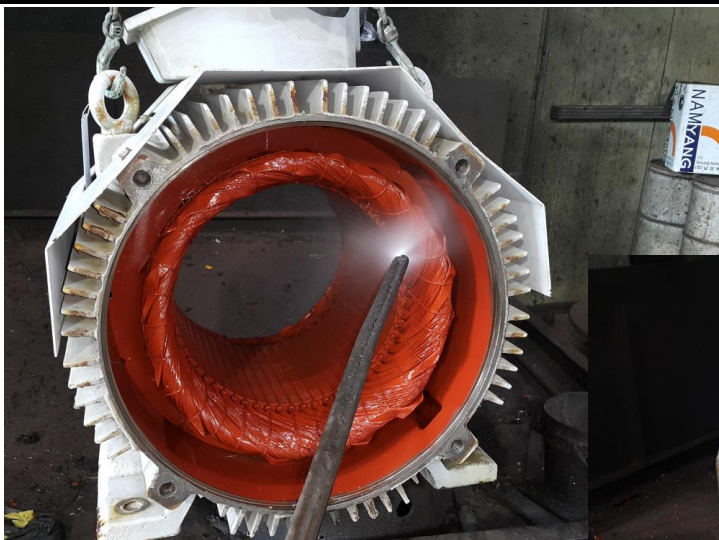


BRACKET

양측 HOUSING검사 8면 모두 1/100이내로 양호

작업공정

AC MOTOR 175HP 4P OVERHAUL



STATOR 권체

세척 실시

JIN YANG

작업 공정 사진

작업공정

AC MOTOR 175HP 4P OVERHAUL



STATOR 권체

세척 후 건조실시

작업공정

AC MOTOR 175HP 4P OVERHAUL

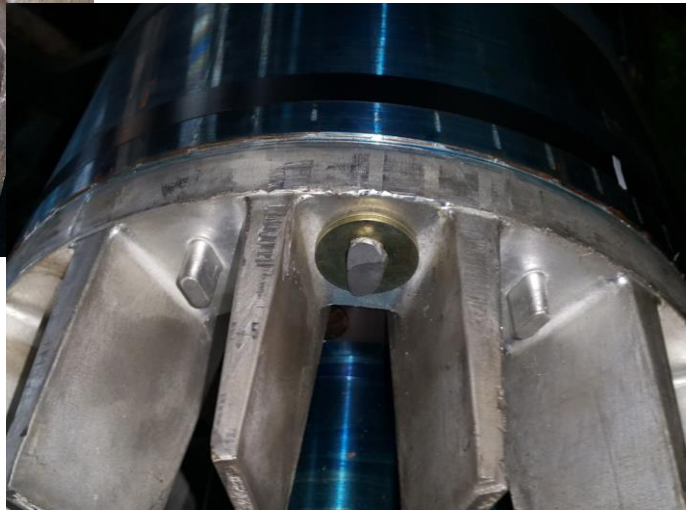
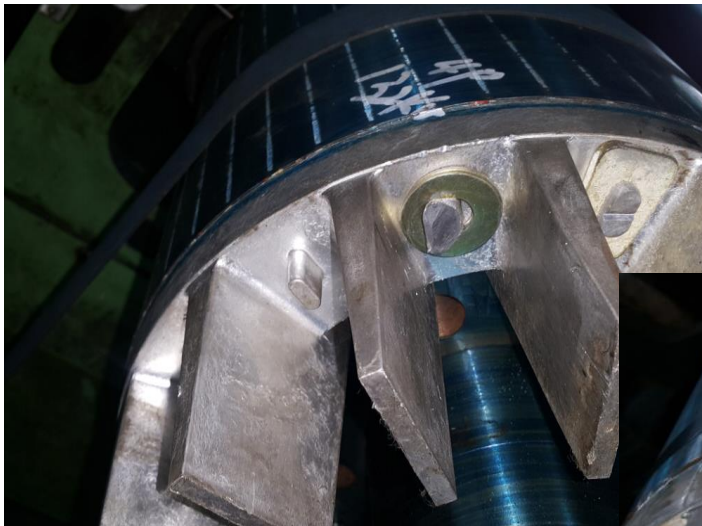


ROTOR No.1

BALANCING 실시

JIN YANG	작업 공정 사진
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작업공정	AC MOTOR 175HP 4P OVERHAUL
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ROTOR No.1	교정된 UNBALACE REPORT참조
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4대 동등한 조건으로 BALANCING실시 하였슴으로 REPORT참조

작업공정	AC MOTOR 175HP 4P OVERHAUL
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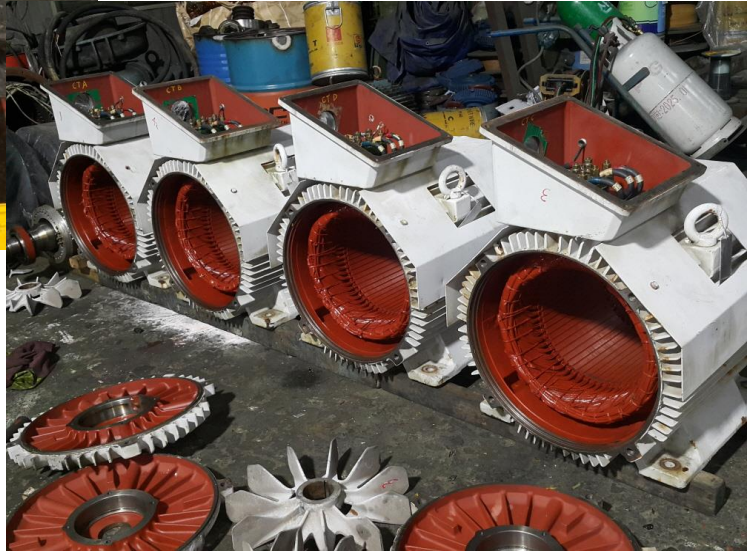
소모품	BEARING 예열교환 실시
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JIN YANG

작업 공정 사진

작업공정

AC MOTOR 175HP 4P OVERHAUL

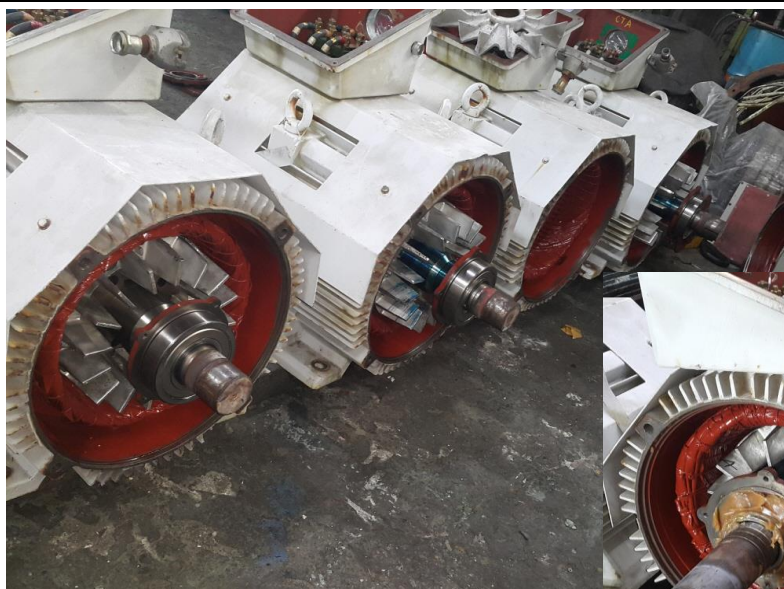


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BEARING 예열교환 조립실시

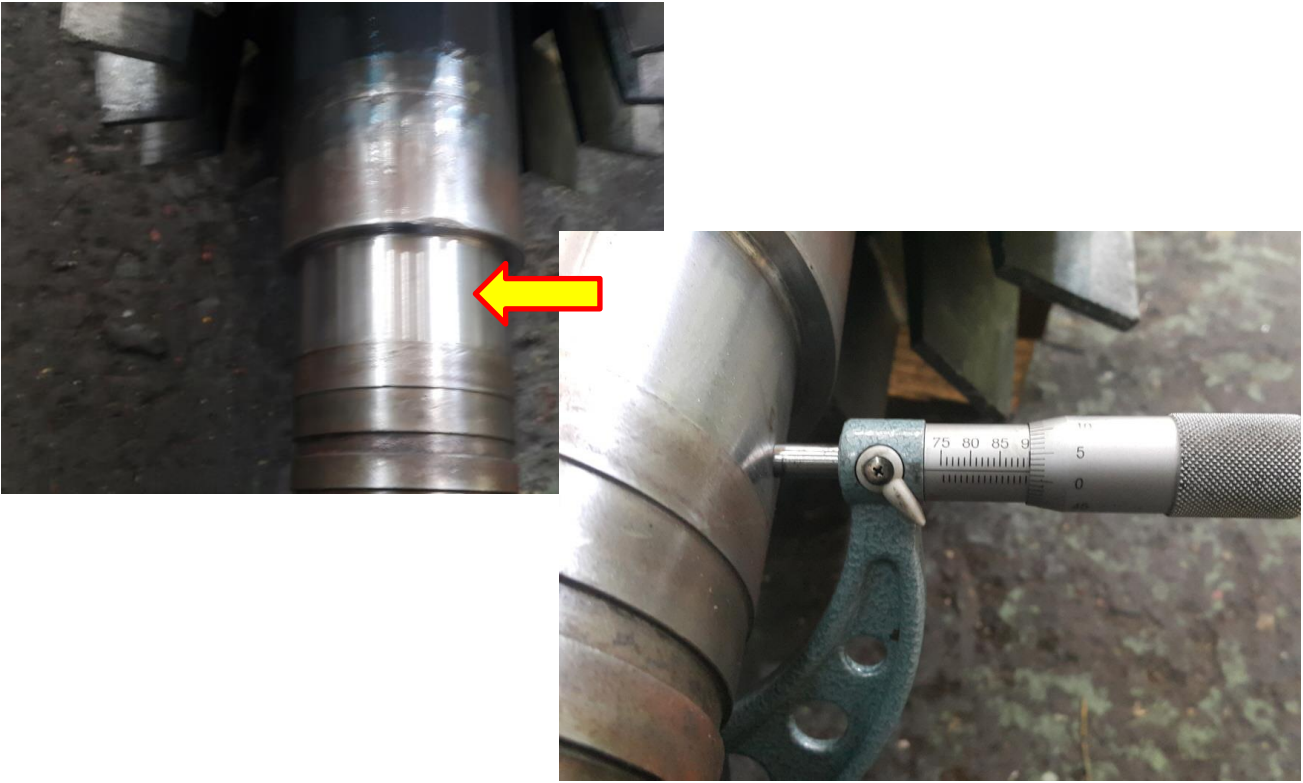

작업공정

AC MOTOR 175HP 4P OVERHAUL



ROTOR 2번

GREASE CHARGING

JIN YANG	작업 공정 사진
작업공정	AC MOTOR 175HP 4P OVERHAUL
	
ROTOR 2번	부하측 BEARING부 METALLIZING 연마 복원 후 검사 2/100
작업공정	AC MOTOR 175HP 4P OVERHAUL
	
출고검사 No.2	절연저항 & 각 상별 권선저항

JIN YANG

작업 공정 사진

작업공정

AC MOTOR 175HP 4P OVERHAUL

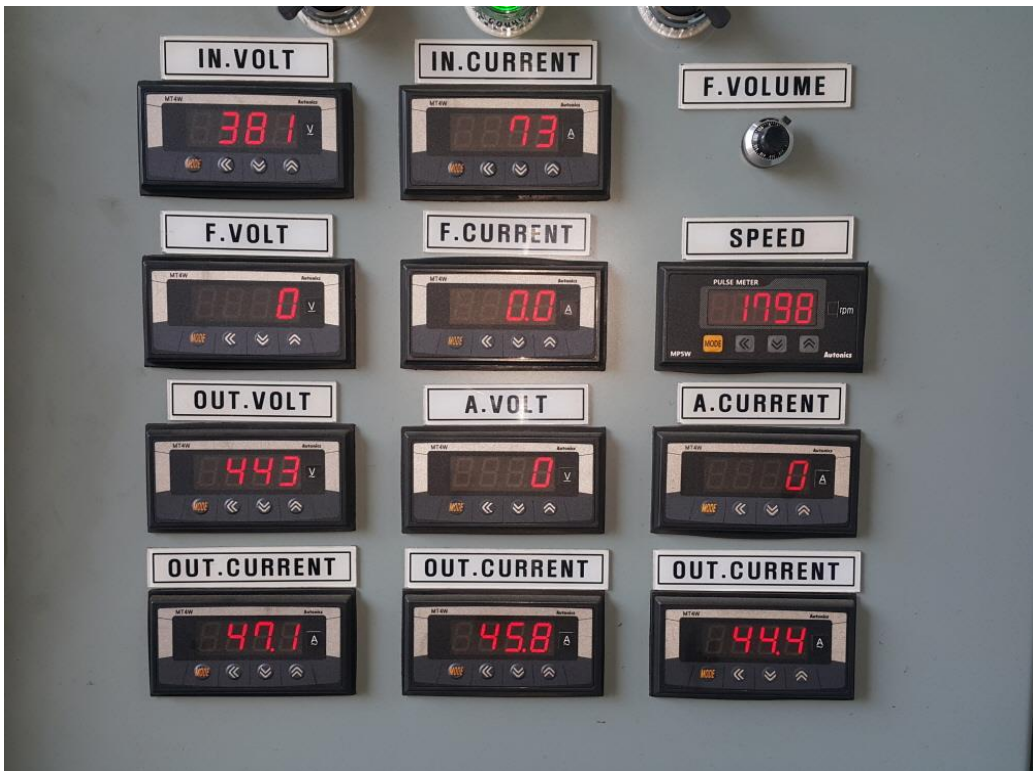


출고검사 No.2

시운전 TEST 실시

작업공정

AC MOTOR 175HP 4P OVERHAUL



출고검사 No.2

시운전 TEST 실시 CURRENT

4대 동등한 조건으로 출고검사 완료 됨으로 CHECK LIST를 참조 하십시오

JIN YANG

작업 공정 사진

작업공정

AC MOTOR 175HP 4P OVERHAUL



출고검사 후

COLOR PAINTING 실시

BALANCING INSPECTION REPORT

SETUP

PART NAME : AC ROTOR 4P A			
CUSTOMER :			
TEST TIME : 2024. 8.28 8:28:31			
GRADE :	G 6.3	RATING SPEED :	1800 rpm
WEIGHT :	132.000 kg	TESTING SPEED :	511 rpm
DIAMETER :	310 mm	CORRECTION :	ADD
ACCEPTABLE UNBALANCE			
PLANE1 :	14.2 gr	PLANE2 :	14.2 gr

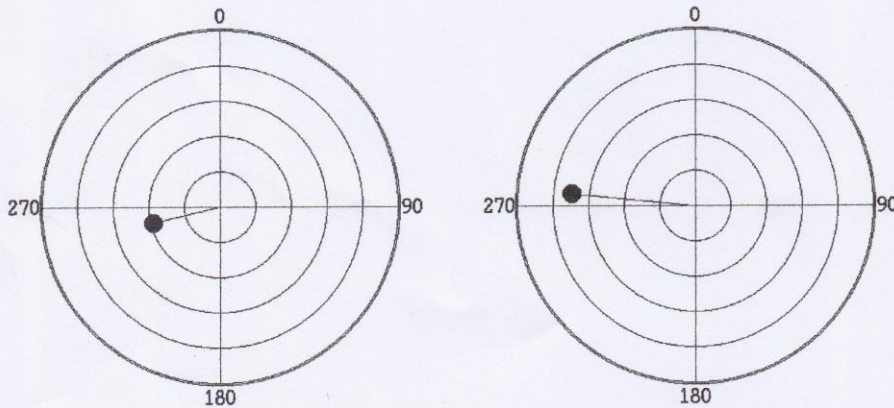
INITIAL UNBALANCE

	PLANE1	PLANE2
UNBALANCE	11.5 gr	4.9 gr
ANGLE	350 deg	273 deg
RESULT	ACCEPT	ACCEPT

CORRECT UNBALANCE

	PLANE1	PLANE2
UNBALANCE	3.9 gr	7.0 gr
ANGLE	256 deg	276 deg
RESULT	ACCEPT	ACCEPT

CORRECT UNBALANCE GRAPH (max = 10.0 gr)



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

BALANCING INSPECTION REPORT

SETUP

PART NAME : AC ROTOR 4P B			
CUSTOMER :			
TEST TIME : 2024. 8.31 11:53: 4			
GRADE :	G 6.3	RATING SPEED :	1800 rpm
WEIGHT :	132.000 kg	TESTING SPEED :	511 rpm
DIAMETER :	310 mm	CORRECTION :	ADD
ACCEPTABLE UNBALANCE			
PLANE1 :	14.2 gr	PLANE2 :	14.2 gr

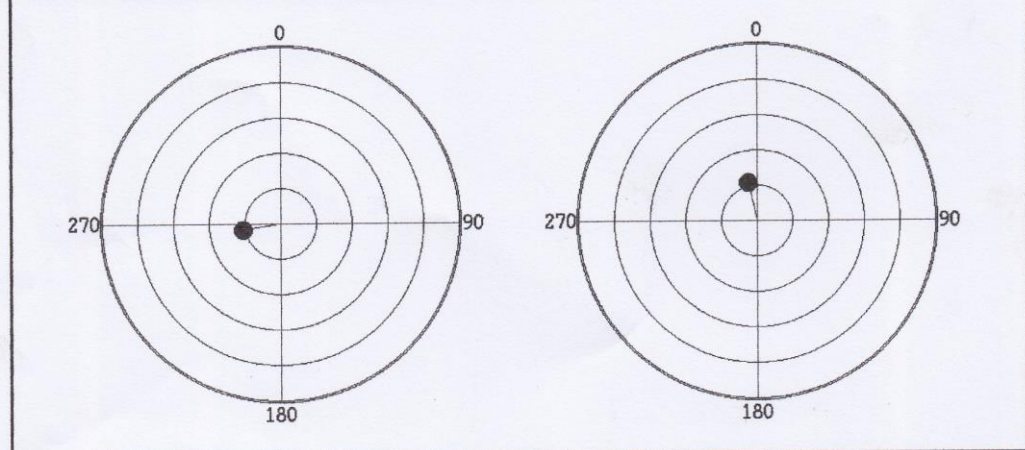
INITIAL UNBALANCE

	PLANE1	PLANE2
UNBALANCE	45.8 gr	39.1 gr
ANGLE	307 deg	89 deg
RESULT	REJECT	REJECT

CORRECT UNBALANCE

	PLANE1	PLANE2
UNBALANCE	10.7 gr	11.2 gr
ANGLE	260 deg	347 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 : AC ROTOR 4P C			
CUSTOMER :			
TEST TIME : 2024. 8.28 9:55:55			
GRADE :	G 6.3	RATING SPEED :	1800 rpm
WEIGHT :	132.000 kg	TESTING SPEED :	508 rpm
DIAMETER :	310 mm	CORRECTION :	ADD
ACCEPTABLE UNBALANCE			
PLANE1 :	14.2 gr	PLANE2 :	14.2 gr

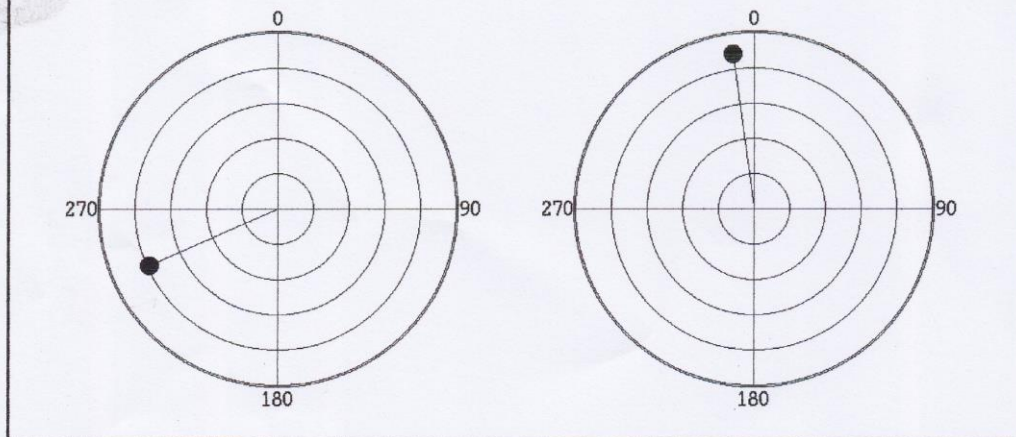
INITIAL UNBALANCE

	PLANE1	PLANE2
UNBALANCE	7.9 gr	8.9 gr
ANGLE	246 deg	352 deg
RESULT	ACCEPT	ACCEPT

CORRECT UNBALANCE

	PLANE1	PLANE2
UNBALANCE	7.9 gr	8.9 gr
ANGLE	246 deg	352 deg
RESULT	ACCEPT	ACCEPT

CORRECT UNBALANCE GRAPH (max = 10.0 gr)



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

BALANCING INSPECTION REPORT

SETUP

PART NAME : AC ROTOR 4P D			
CUSTOMER :			
TEST TIME : 2024. 8.28 10:25:55			
GRADE	: G 6.3	RATING SPEED	: 1800 rpm
WEIGHT	: 132.000 kg	TESTING SPEED	: 508 rpm
DIAMETER	: 310 mm	CORRECTION	: ADD
ACCEPTABLE UNBALANCE			
PLANE1	: 14.2 gr	PLANE2	: 14.2 gr

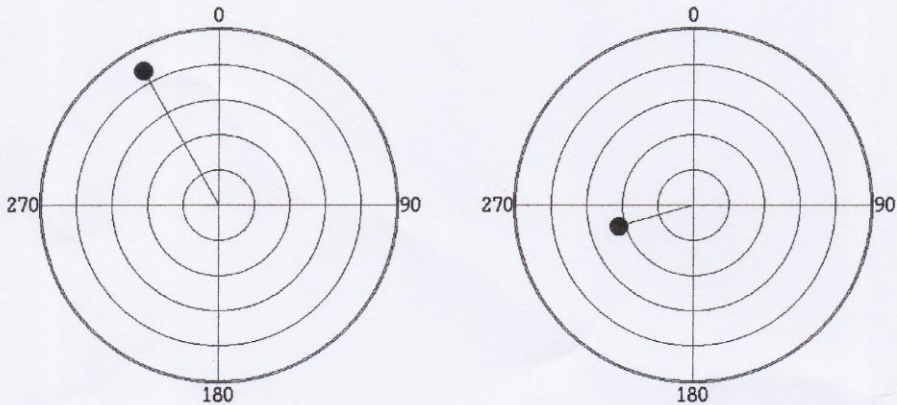
INITIAL UNBALANCE

	PLANE1	PLANE2
UNBALANCE	24.6 gr	59.4 gr
ANGLE	176 deg	15 deg
RESULT	REJECT	REJECT

CORRECT UNBALANCE

	PLANE1	PLANE2
UNBALANCE	4.4 gr	2.2 gr
ANGLE	331 deg	254 deg
RESULT	ACCEPT	ACCEPT

CORRECT UNBALANCE GRAPH (max = 5.0 gr)



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