

작업공정사진철

고객명:

공사명: AC VECTOR SPINDLE MOTOR OVERHAUL

규격: 1PH6-206 93KW 1000~MAX 5000RPM

REPAIR 내역: 분해 및 불순물 CLEANSING DRYING
INSULATING VARNISH DIPPING DRYING
부하측 HOUSING METALLIZING 연마
BALANCING 및 UNBALANCE교정
BLOWER MOTOR 세척 실시
BEARING교환
출고검사 시운전 TEST



<http://jinyangmotor.com/>



JIN YANG

작업 공정 사진

작업공정

AC SPINDLE MOTOR 입고검사



Ass'y

분해 전

작업공정

AC SPINDLE MOTOR 입고검사



냉각구

분해 실시

JIN YANG

작업 공정 사진

작업공정

AC SPINDLE MOTOR 입고검사



냉각 FAN

분해 실시

작업공정

AC SPINDLE MOTOR 입고검사



Ass'y 분해전

냉각구 및 권체 세척실시

JIN YANG

작업 공정 사진

작업공정

AC SPINDLE MOTOR 입고검사

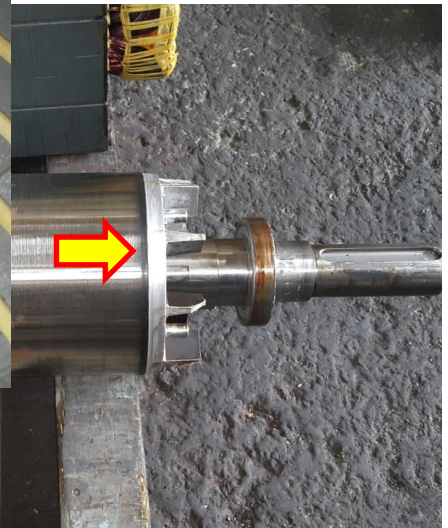


STATOR 권체

분해 후 권선상태 양호



작업공정

AC SPINDLE MOTOR 입고검사



부하측

약간의 회전 마찰이 진행 중이었던 것으로 보임

JIN YANG	작업 공정 사진
작업공정	AC SPINDLE MOTOR 입고검사
	
BRACKET	부하측 HOUSING 측정치 4/100로 불량
작업공정	AC SPINDLE MOTOR 입고검사
	
BRACKET	반 부하측 HOUSING 측정치 1/100로 양호

JIN YANG

작업 공정 사진

작업공정

AC SPINDLE MOTOR 입고검사



STATOR 권체

권선 및 냉각구 세척 실시

작업공정

AC SPINDLE MOTOR 입고검사



STATOR 권체

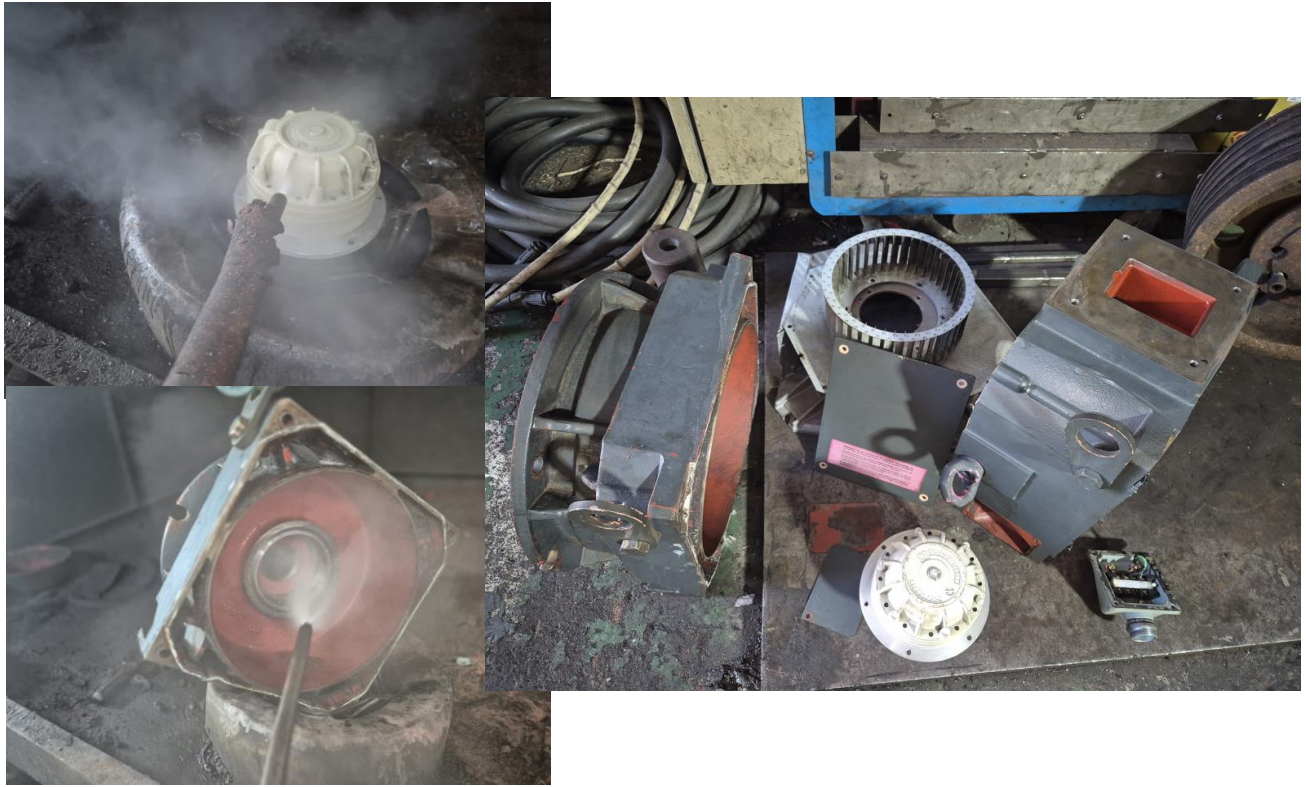
세척 후 건조실시

JIN YANG

작업 공정 사진

작업공정

AC SPINDLE MOTOR 입고검사

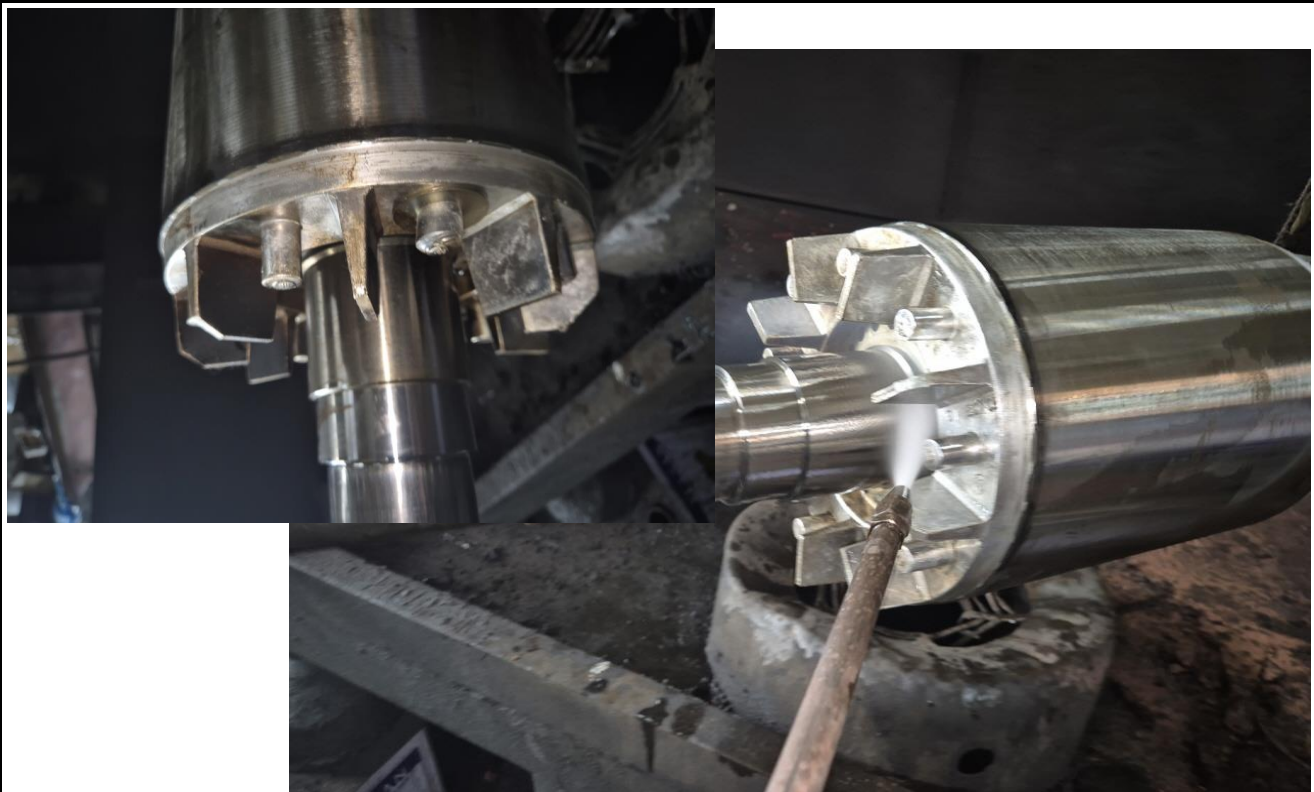


조립부품

세척 실시

작업공정

AC SPINDLE MOTOR 입고검사



조립부품

세척 실시

JIN YANG

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AC SPINDLE MOTOR OVERHAUL



BRACKET

부하측 HOUSING METALLIZING 연마 후 검사 1/100

작업공정

AC SPINDLE MOTOR OVERHAUL



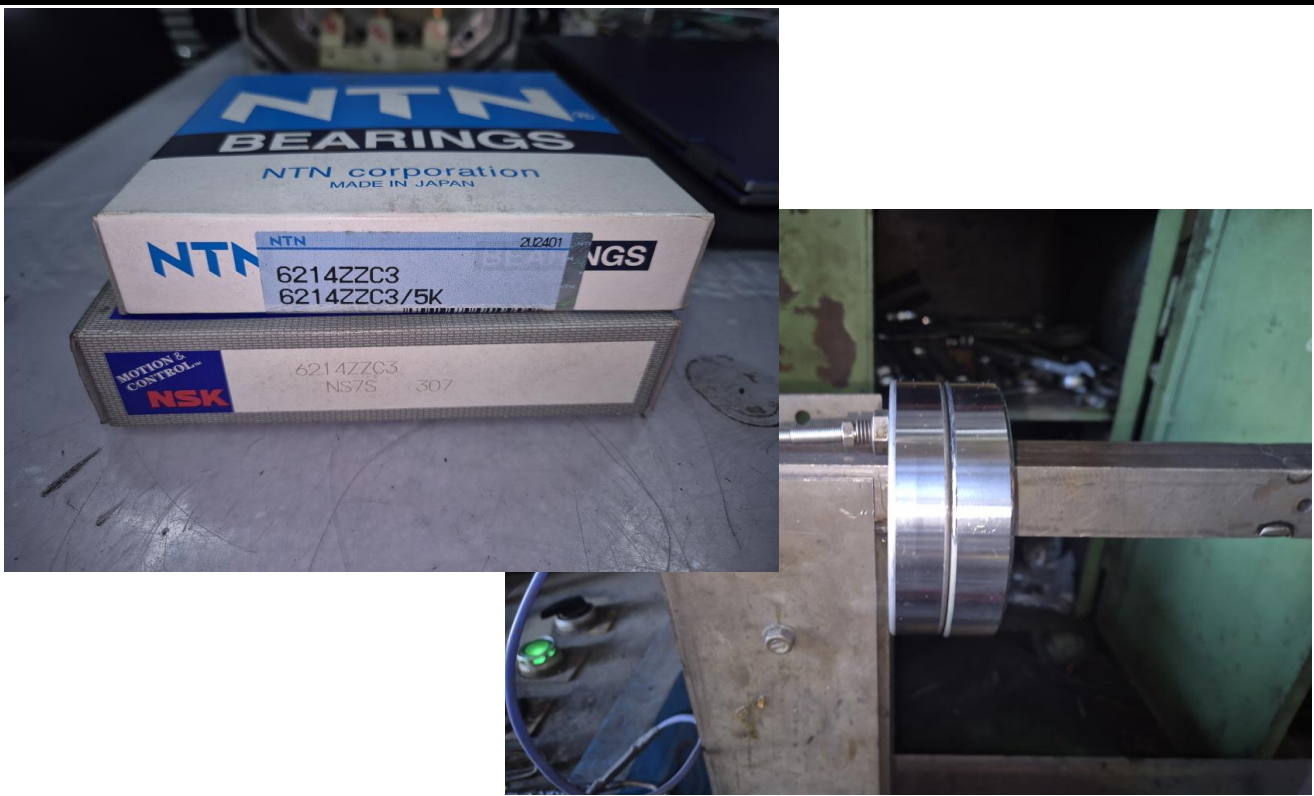
ROTOR

BALANCING 실시

JIN YANG	작업 공정 사진
작업공정	AC SPINDLE MOTOR OVERHAUL



ROTOR	교정된 UNBALACE REPORT참조
작업공정	AC SPINDLE MOTOR OVERHAUL



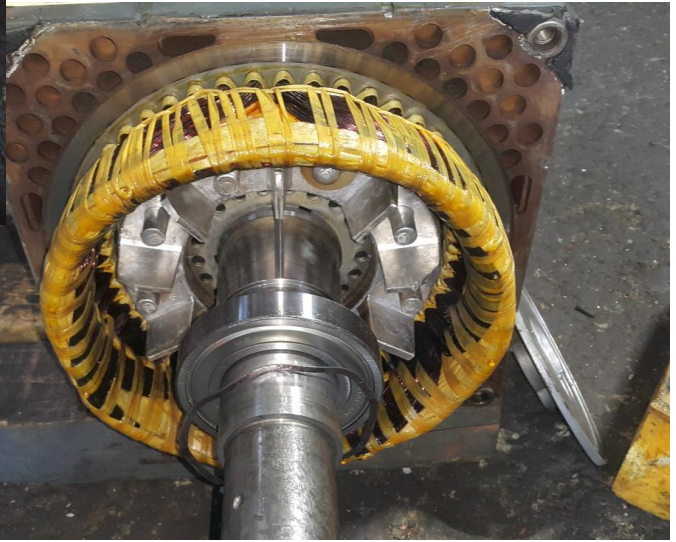
소모부품	BEARING 예열실시
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JIN YANG

작업 공정 사진

작업공정

AC SPINDLE MOTOR OVERHAUL



조립부품

BEARING교환 조립실시

작업공정

AC SPINDLE MOTOR OVERHAUL



BLOWER

절연저항 & 각상별 권선저항

JIN YANG

작업 공정 사진

작업공정

AC SPINDLE MOTOR OVERHAUL



BLOWER

시운전 TEST실시

작업공정

AC SPINDLE MOTOR OVERHAUL



BLOWER

시운전 TEST실시 운전 CURRENT

작업공정

AC SPINDLE MOTOR OVERHAUL



BLOWER

보수 후

작업공정

AC SPINDLE MOTOR OVERHAUL



출고검사

SPINDLE 절연저항 & 각상별 권선저항

JIN YANG

작업 공정 사진

작업공정

AC SPINDLE MOTOR OVERHAUL



출고검사

시운전 TEST 실시

작업공정

AC SPINDLE MOTOR OVERHAUL

The screenshot displays the 'VECTOR_03' configuration window for a motor. The left sidebar shows a project tree with 'VECTOR_03' selected. The main window is divided into several sections:

- Configuration:** Shows drive data set 'DDS 0' (Active) and command data set 'CDS 0' (Active). It includes buttons for 'Configure DDS...', 'Add DDS...', and 'Remove DDS...'.
- Motor data:** Lists motor specifications:
 - Motor type: [1] Induction motor (rotating)
 - Order no.: 1PH7194-2D015-6A4-3
 - Speed: 1000.0 rpm
 - Current: 90.00 Arms
 - Power: 39.00 kW
 - Voltage: 325 Vrms
 - Brake available: No
 - Motor data set number: 0
- Reference variables:** Shows 'Reference speed: 1000.00 rpm' and 'Reference voltage: 1000 Vrms'.
- Real-time Test Data (Bottom Panel):**
 - Operation: [0] Operation - everything enabled
 - Speed: Specified 1000.0, Actual 1000.0 rpm
 - Torque: Specified 4.12, Actual 3.95 Nm
 - Output frequency smoothed: 33.3 Hz
 - CO: Output voltage smoothed: 313.8 Vrms
 - Motor current: 41.86 Arms
 - Torque utilization: 0.6 %

출고검사

시운전 TEST 실시

시운전 TEST실시 운전 MONITORING REPORT

STARTER - DONG JU - [Drive unit: VECTOR_03 - Configuration]

Project Control panel Edit Target system View Options Window Help

CU_S_126

- Infeeds
 - A_INF_02
 - Insert DCC chart
 - Configuration
 - Expert list
 - Control logic
 - Functions
 - Communication
 - Diagnosics
 - Input/output components
 - Encoder
 - Drives
 - VECTOR_03
 - Insert DCC chart
 - Configuration
 - Expert list
 - Drive navigator
 - Control logic
 - Seabport channel
 - Open-loop/closed-loop control
 - Functions
 - Messages and monitoring
 - Commissioning
 - Control panel
 - Device trace
 - Function generator
 - Measuring function
 - Automatic controller setting
 - Stationary/tuning measurement

Display data set switchover

Drive data set D0S 0 (Active) **Configure D0S...**

Command data set C0S 0 (Active) **Add C0S...** **Remove C0S...**

Blocked list - setting

Order no.	Type	SMI20/D0I
65131201	DRIVE-CLIQ	6513055-0A400-SMA3
1PH7194-2D015-0A43	DRIVE-CLIQ	1PH7194-2D015-0A43
2048	Encoder data set number	2048

Motor data

VECTOR_03 Motor_SMI_6 (Motor)

Motor type: [1] Induction motor (feeding)

Order no.: 1PH7194-2D015-0A43

Speed: 1000.0 rpm

Current: 90.00 Arms

Power: 39.00 kW

Voltage: 335 Vrms

Brake available: No

Motor data set number: 0

Reference variables

Reference speed: 1000.00 rpm

Reference voltage: 1000 Vrms

Drive unit specification

n = 2000 rpm

0% n x 60 % = 200%

1200.00 rpm

Output frequency smoothed: 33.3 Hz

CO- Output voltage smoothed: 313.8 Vrms

Motor current: 41.96 Arms

Torque utilization: 0.6 %

Speed: Specified 1000.0 Actual 1000.0 rpm

Torque: Specified 4.12 Actual 3.55 Nm

Control panel **stop with spaccbar** Realtek USB GbE Family Controller TCP Online mode

Control priority Drive control panel

Press F1 to open help display.

오류 1239 2023-07-10

BALANCING INSPECTION REPORT

SETUP

PART NAME : SERVO ROTOR			
CUSTOMER :			
TEST TIME : 2025. 7. 9 8:13:44			
GRADE :	G 6.3	RATING SPEED :	3000 rpm
WEIGHT :	90.000 kg	TESTING SPEED :	543 rpm
DIAMETER :	230 mm	CORRECTION :	ADD
ACCEPTABLE UNBALANCE			
PLANE1 :	7.9 gr	PLANE2 :	7.9 gr

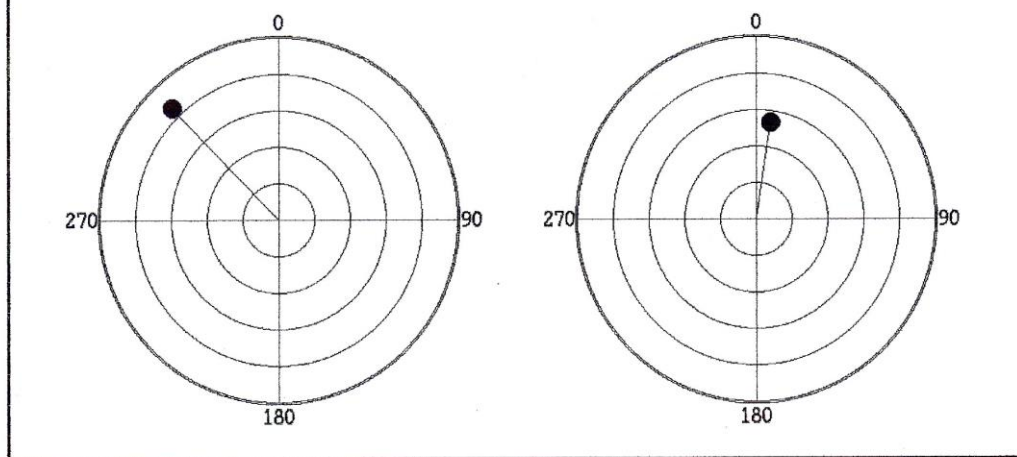
INITIAL UNBALANCE

	PLANE1	PLANE2
UNBALANCE	9.3 gr	6.4 gr
ANGLE	309 deg	83 deg
RESULT	REJECT	ACCEPT

CORRECT UNBALANCE

	PLANE1	PLANE2
UNBALANCE	4.3 gr	2.7 gr
ANGLE	316 deg	9 deg
RESULT	ACCEPT	ACCEPT

CORRECT UNBALANCE GRAPH (max = 5.0 gr)



진양전기
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