



## **DC MILL MOTOR REMANUFACTURING SPECIFICATIONS**

1. All motors are matchmarked and disassembled.
2. All mechanical parts are sandblasted to remove paint and other contaminates.
3. All field coils and interpoles will be removed from field frame.
4. All electrical parts are steam cleaned and baked dry in gas-fired ovens.
5. Insulation and meggar tests are taken and recorded.
6. AC potential drops are taken on the DC fields to detect shortened turns.
7. Armature slot wedges are checked for condition and tightness and replaced or repaired as needed.
8. The headers on the main poles and interpoles are checked and replaced or repaired as required.
9. New field frame wiring is installed using flexible type wire.
10. The brush holders and springs are glass bead blasted, inspected, and repaired or replaced.
11. A bar-to-bar test is made on the commutator to detect shorts, high resistance connections, and faulty equalizers.
12. The armature is placed in a lathe, and the commutator is turned and undercut. Measurements are then taken and recorded to insure that the diameters meet manufacturer's allowable tolerances.
13. The armature is glass banded.
14. The bearings are replaced with new U.S. manufactured bearings.
15. All electrical parts are heated and then dipped in Class H varnish. The parts are baked dry at approximately 250 degrees.
16. The motor frame is cleaned, primed, and painted on the outside with Rustoleum navy-gray paint. The inside is painted with epoxy-type insulating compound. A preservative is also added to the shaft extension.
17. The armature, field coils, and interpoles are painted with a varnish-type oil-resistant, air-dry insulating compound.
18. The machine is assembled on the test floor.
19. New brushes are installed.
20. The air gap around the periphery of the armature is checked for uniformity.

21. Each machine is operated throughout its speed range. Each is dynamically balanced, and the data is recorded. These tests are implemented with electronic balancing equipment.
22. Test data including final meggar readings, field resistance, field current, dynamic balance readings, etc., are recorded and stored for future reference.

