

Frame size description: Siemens. 25 kW. DC 220 volt. 126 amps. Type 1HA3253-6ZZ24-Z

Description	Normal repair time	% Increase in Price for a Breakdown	Time period to return a motor on a Breakdown (Emergency)	Price per 2 pole	Price per 4 pole	Price per 6 pole	Price per 8 pole
Assessment scope of work							
Transport cost							
Test motor as received: Measure insulation resistance and determine polarization index result.							
Test motor as received: Perform locked rotor test, and record starting current, power factor, starting torque, impedance, and compute equivalent copper resistance.							
Test motor as received: Perform no-load test, and record no-load current, no-load power factor.							
Determine efficiency as received:							
Separate losses, and determine efficiency.							
Test stator core as received.							
Test rotor bar continuity and core condition as received.							
Collection, dismantling, assessment and compile recommended repair scope of work and failure report.							
Repair scope of work							
Overhaul motor (wash, clean and dry)							
Dynamic balancing of the rotor							
Sandblast motor							
Repair and file stator core							
Clean stator core and prep for assembly							
Re-tap all stator mounting holes							
Polish rotor core and check ovality							
Polish all stator spigots and landings							
Polish all journals and seal landings							
Re-sleeve DE endshield							
Re-sleeve NDE endshield							

Weld and machine shaft extension and cut keyway							
Replace / fit new bearings (DE & NDE)							
Supply and fit new circlip (each)							
Supply and fit new oil seals (each)							
Supply and fit new gaskets							
Rewinding of stator							
Supply and fit motor DE end shield							
Supply and fit motor NDE end shield							
Supply and fit motor flange shield							
Supply and fit motor DE grease cap and grease nipple							
Supply and fit motor NDE grease cap and grease nipple							
Supply and fit motor terminal box							
Supply and fit motor terminal box cover							
Supply and fit motor terminal block							
Supply and fit motor cooling fan							
Supply and fit motor fan cowl							
Supply and fit motor dust cover seal							
Supply and fit bearing oil seals (each)							
Supply and fit motor feet							
Skim motor feet							
Repair rotor journal (each)							
Supply and fit new rotor shaft							
Replace complete rotor							
Re-stack stator core							
Rewind armature, VPI, bake and replace binders							
Skim, undercut and bevel armature							
Recondition brush-gear							
Perform a full concentricity on the motor(high no-load vibration)							
Re-assembly of motor							
Spray painting motor							
Replacement of motor name plate							

Supply and fit new brushes							
Remove old commutator							
Supply new commutator							
Fit new commutator							
Repair brush gear to standard							
Slot stator feet							
NDT rotor test							
Rewind Stator							
Manufacture new brush gear , box , springs , column clamps and rocket ring							
Test motor as repaired: Measure insulation resistance and determine polarization index result.							
Test motor as repaired. Perform locked rotor test, and record starting current, power factor, starting torque, impedance, and compute equivalent copper resistance.							
Test motor as repaired. Perform no-load test, and record no-load current, no-load power factor.							
Determine efficiency as repaired: Separate losses, and determine efficiency.							
Test stator core as repaired.							
Test rotor bar continuity and core condition as repaired.							
Compile and supply report as per the requirements under <i>Reports</i> listed in the Contract Conditions.							