AC GENERATOR ASSEMBLY FORM

JOB# 2307011 / PO# 57612 DATE: 7/24/2023 ASSEMBLED BY: RICARDO YANEZ

NAME PLATE DATA

SERIAL #:	21660-23	VOLTAGE:	346/600	HZ:	60
MODEL #:	AA27673013	KW:	1204	PF:	
MAKE:	KATO	AMPS:	1655	SF:	
TYPE:		RPM:	1200		

BEFORE ASSEMBLY MECHANICAL

Stator Megger	1000	M Ω	Stator Surge	2230	volts		
Stator Hipot	154	M Ω	2420	volts	15.750	micro amps	
Stator Resistance	1- 7.22	m Ω	2- 7.29	m Ω	3- 7.21	m Ω	
Rotor Megger	1000+	M Ω	Rotor Drop Test in File	√			
Rotor Hipot	734	M Ω	2210	volts	3.101	micro amps	
Exc. Stator Hipot	46486	M Ω	1720	volts	0.037	micro amps	
Exc. Stator Polarity Test	GOOD						
Exc. Rotor Hipot	1714	M Ω	1520	volts	6.887	micro amps	
Exc. Rotor Resistance	1- -	m Ω	2- -	m Ω	3- -	m Ω	
Exc. Rotor Surge	1240	volts	PMG Electrical in File	√			

RTD''s	1 N/A	ohms	2 -	ohms	3 -	ohms	
	4 -	ohms	5 -	ohms	6 -	ohms	

HEATERS QTY. 2 Rating 120V-500W

DC ROTOR DROP TEST AND POLARITY

INPUT VOLTAGE: 120

1	23.0	2	23.4	3	23.4
4	25.0	5	23.1	6	23.1
7	-	8	-	9	-

ASSEMBLY MECHANICAL

RUN-OUT	0.001	ENDPLAY	0.027
	D.E.		O.D.E.
Bearing Journal	5.1190		5.1191
Bearing Housing	11.0243		11.0241
Bearing size/MFG.	6326 / SKF		6326 / SKF
Grease Type	278 POLYUREA		278 POLYUREA
Shaft Size	5"	Key Way Size	1.235

GENERAL VISUAL INSPECTION

Rotor Cleaned ☑	Stator Clean ☑	Leads Good Cond. ☑	Covers ☑
Rotor Painted ☑	Fits Clean ☑	Lugs Installed ☑	J-Box ☑
Rotor Balanced ☑	Stator Tapped ☑	Terminal Block ☑	Fan ☑
Balance sheet in file ☑	Feet Clean ☑	Grease Fits Clean ☑	Fan Cover ☑
Stator Varnish Dip ☑	Winding Painted ☑	Bolts Clean ☑	Final Paint ☐
Rotor Varnish Dip ☑	EXC Stator Dip ☑	EXC. Rotor Dip ☑	PMG Dip ☐

BEFORE CONNECTING FOR TEST RUN

Stator Megger 1000+ **M Ω**

TEST RUN - *SINGLE BEARING GENERATOR - STATIC ELETRICAL TESTING ONLY*

# LEADS	WYE	DELTA	EITHER	BUS BAR
48	☑	☐	☐	☑

Gen. Output Voltage 605.1 **VAC** **Exc. Field Resistance** 14.0 **Ohms**

Excitation Input Voltage 20.35 **VDC**

No Load RPM's N/A

VIBRATION READING

D.E.		O.D.E	
H	0.09	H	0.09
V	0.08	V	0.09
A	0.08	A	0.08

BEARING TEMPERATURE READINGS

Bearing temperature will be taken in intervals of 5 minutes and in degree Celcius

D.E.				O.D.E			
1	33.5	7	41.5	1	31.8	7	40.4
2	34.8	8	43.1	2	33.9	8	41.9
3	36.4	9	44.2	3	36.8	9	42.1
4	37.8	10	45.8	4	37.5	10	42.9
5	39.1	11	44.8	5	38.5	11	43.1
6	40.1	12	45.1	6	39.1	12	43.5

Assembled by: RICARDO YANEZ **Date:** 7/24/2023

Tested by: RICARDO YANEZ **Date:** 7/24/2023

Supervisor JOEL RIOS **Date:** 7/24/2023