

NAVSEA  
STANDARD ITEM

FY-18

ITEM NO: 009-113

DATE: **18 NOV 2016**

CATEGORY: II

1. SCOPE:

1.1 Title: Rotating Electrical Equipment with **a** Sealed Insulation System (SIS); rewind

2. REFERENCES:

2.1 Standard Items

2.2 MIL-STD-2037, Procedure to Obtain Certification for Electric Motor Sealed Insulation Systems

2.3 Equipment Technical Manual

2.4 S9086-KC-STM-010/CH-300, Electric Plant - General

2.5 S9086-KE-STM-010/CH-302, Electric Motors and Controllers

2.6 S9086-KN-STM-010/CH-310, Electric Power Generators and Conversion Equipment

2.7 S9086-HN-STM-010/CH-244, Propulsion Bearings and Seals

2.8 S6260-BJ-GTP-010, Electrical Machinery Repair, Electric Motor, Shop Procedures Manual

2.9 MIL-STD-1310, Shipboard Bonding, Grounding, and Other Techniques for Electromagnetic Compatibility, **Electromagnetic Pulse (EMP)** Mitigation, and Safety

3. REQUIREMENTS:

3.1 Only Repair Activities certified by Naval Sea Systems Command (NAVSEA) in accordance with 2.2 may rewind motors with a Sealed Insulation System.

3.1.1 Submit one legible copy, in hard copy or approved transferrable media of the NAVSEA Certification Recertification letter confirming the Repair Activity has fulfilled the requirements for the Sealed Insulation System process. The NAVSEA letter shall indicate the type of

motors and the range of motor frame sizes the activity is qualified to rewind.

3.1.2 Submit any change of certification as it occurs to the SUPERVISOR.

3.2 Submit one legible copy, in hard copy or approved transferrable media of any deviations between the NAVSEA-approved Repair Activity SIS Rewind Procedure (SISRP) and this Standard Item for record purposes.

3.3 Prior to disconnecting equipment:

3.3.1 Record and retain electrical hook-up data.

3.3.2 Inspect **each** coupling for cracks, broken segments, wear, and misalignment in excess of tolerances specified in 2.3. Record and retain air gap readings. Record and retain bearing clearances for sleeve bearing equipment only.

3.3.3 Identify associated cables and wiring. Disconnect equipment mechanically, using 2.3 for guidance.

3.3.3.1 Matchmark, identify, and retain chocks, shims, shock mounts, sound damping pads, and other accessories associated with equipment.

3.3.3.2 Record shaft thrust and run out readings.

3.4 Remove equipment including rotating components connected directly to the shaft.

3.4.1 Remove entire vaneaxial and tubeaxial fan assemblies from the duct system and transport to the shop for repair.

3.5 Inspect **each** foundation for cracks, areas of distortion, and deterioration in excess of 25 percent of the thickness of each member of the structure.

3.6 Submit one legible copy, in approved transferrable media, of a report listing inspection results, missing parts, defective parts, and measurements taken for electrical hook up data recorded in 3.3.1, mechanical inspection required by 3.3.2 through 3.3.3.2, and structural inspection required in 3.5 to the SUPERVISOR.

3.7 Matchmark, disassemble and inspect the equipment removed in 3.4, in accordance with the Repair Activity SISRP, using 2.3 through 2.8 for guidance.

3.7.1 Accomplish a core loss test prior to winding removal in accordance with the Repair Activity SISRP. Record data.

3.7.1.1 Conduct a loop test in accordance with Paragraphs 5.1.2.3.3(a) (1) through (16) or 5.1.2.3.3(b) (1) through (12) as applicable of 2.2 when core indicates a marginal satisfactory reading or when test equipment does not directly support equipment being subjected to testing.

3.7.1.2 Inspect for hot spots in accordance with the Core Loss Tester Instruction Manual.

3.7.2 Remove each winding, in accordance with the Repair Activity SISRP for winding removal and 2.8 for core inspection.

3.7.2.1 Verify the temperature limitations of the core material prior to exercising the burnout oven option. The surface temperature of the laminated iron surface shall be determined by thermocouple and shall not exceed 370 degrees Centigrade (698 degrees Fahrenheit).

3.7.2.2 Record winding data. Verify conformance of recorded data to the manufacturer's winding data.

3.7.2.3 Accomplish a core loss test after winding removal in accordance with the Repair Activity SISRP. Record data.

3.7.2.4 Conduct a loop test in accordance with Paragraphs 5.1.2.3.3(a) (1) through (16) or 5.1.2.3.3(b) (1) through (12) as applicable of 2.2 when core indicates a marginal satisfactory reading or when test equipment does not directly support equipment being subjected to testing.

3.7.2.5 Inspect for hot spots in accordance with the Core Loss Tester Instruction Manual.

3.7.2.6 Dip core for preservation in accordance with the Repair Activity SISRP.

3.7.3 Protect machined surfaces. Accomplishment of cleaning and painting for equipment housing exterior, fan(s), interior and exterior of each end bell shall be in accordance with NAVSEA Standard Items (See Note 4.9).

3.8 Inspect **each** rotor for cracked bars, localized overheating, rubbing, insulation damage, and burns/hot spots. Record data.

3.9 Inspect and dimensionally measure end bells, frame, rabbet fits, shaft, sleeve and pedestal bearings, keyways, fan and running surfaces for wear, eccentricity, and other defects, using 2.3 for accept or reject criteria, and 2.7 for location and type of measurements to be taken. Record data.

3.10 Submit one legible copy, in approved transferrable media, of a report listing results of the requirements of 3.7 through 3.9 to the SUPERVISOR.

3.11 Rewind the equipment in accordance with the Repair Activity SISRP and the Original Equipment Manufacturer's (OEM) "for Navy use" winding data.

3.11.1 Do not permanently connect winding until after successful completion of testing of 3.11.3 through 3.11.7.

3.11.2 Material shall be in accordance with the Repair Activity SISRP.

3.11.2.1 New temperature detectors shall be in accordance with 2.3.

(V) "INSULATION RESISTANCE TEST"

3.11.3 Accomplish 500-volt megger insulation resistance test in accordance with the Repair Activity SISRP.

(V) "DC RESISTANCE TEST"

3.11.4 Accomplish a DC resistance test of windings, using a Wheatstone or Kelvin bridge, or with an ohmmeter capable of resolving one milliohm (0.001 ohm) in accordance with the Repair Activity SISRP. Record phase balance for multi-phase equipment.

(V) "VOLTAGE SURGE TEST"

3.11.5 Accomplish a voltage surge test in accordance with the Repair Activity SISRP.

(V) "DC HI POT TEST"

3.11.6 Accomplish a DC HI POT test in accordance with the Repair Activity SISRP.

3.11.7 Accomplish 500-volt megger insulation resistance test in accordance with the Repair Activity SISRP.

3.12 Permanently connect the windings.

3.12.1 Repeat tests described in 3.11.3 through 3.11.7.

(V) "VARNISH TEMPERATURE, VISCOSITY, AND GEL TIME TESTS"

3.13 Select varnish methods and material in accordance with the Repair Activity SISRP.

3.13.1 Maintain the varnish in accordance with the Repair Activity SISRP and the varnish manufacturer's instructions.

3.13.2 Maintain a current revision of the varnish manufacturer's instructions on storage, maintenance, and use of the type of varnish to be applied.

3.13.3 Maintain a record, in accordance with the Repair Activity SISRP, of varnish temperature, viscosity, and, for solventless varnish, gel time tests. Tests must show varnish is within varnish manufacturer's recommendations and have been accomplished in the intervals specified by the varnish manufacturer. The record must also show the varnish is being stored as recommended by the varnish manufacturer.

3.14 Insulate the windings using the Vacuum Pressure Impregnation (VPI) procedure in accordance with the Repair Activity SISRP.

3.14.1 Do not immerse the leads.

3.14.2 Wipe surfaces that affect assembly such as rabbet fits and mounting flanges with a cloth moistened with a solvent after draining and before baking.

3.15 Remove excess varnish runoff from the component locations described in 3.14.2 after final baking.

3.16 Prime equipment housing, fan(s), and end bells with one coat F-84 Alkyd Zinc Molybdate TT-P-645 (1.5 mils dry film thickness).

3.17 Submerge wound assembly in fresh water for 24 hours.

3.18 Accomplish a Submerged Insulation test in accordance with the Repair Activity SISRP. Record data.

3.19 Accomplish a 500-volt megger dry insulation resistance test in accordance with the Repair Activity SISRP. Record data.

3.20 Accomplish an AC HI POT test in accordance with the Repair Activity SISRP. Record data.

3.21 Accomplish a Surge Comparison test in accordance with the Repair Activity SISRP. Record data.

3.22 Accomplish a 500-volt megger dry insulation resistance test in accordance with the Repair Activity SISRP. Record data.

3.23 Measure resistance value of each winding temperature detector, using a low voltage ohmmeter. Record data.

3.24 Submit one legible copy, in approved transferrable media, of a report listing results of the requirements of 3.18 through 3.23 to the SUPERVISOR.

3.25 Accomplishment of the balancing requirement for each rotating assembly shall be in accordance with NAVSEA Standard Items (See Note 4.10).

3.26 Install **each** identification marker on wiring in the external connection box.

3.26.1 Markers shall be aluminum wrap-around type with metal stamped or embossed markings.

3.27 Repair lightly scored areas of frame, end bells, and shaft by manual methods. Recondition threads and fit key to keyway. Step keys shall not be used.

3.27.1 Apply a thin coat of petrolatum to unpainted mating surfaces except for explosion-proof motors that shall have clean, dry mating surfaces.

3.28 Prepare and refinish equipment. Protect machine surfaces, windings, and nameplates from being painted or otherwise damaged.

3.28.1 Accomplishment of cleaning and painting for housing, fan, and interior and exterior of each end bell shall be in accordance with NAVSEA Standard Items (See Note 4.9).

3.29 Accomplishment of cleaning and painting for foundations of the equipment removed in 3.4 shall be in accordance with NAVSEA Standard items (See Note 4.9).

3.30 Accomplish the following on equipment having other than sleeve-type bearings unless otherwise specified in the invoking Work Item, using 2.8 for guidance.

3.30.1 Except as indicated in 3.30.1.1 (utilizing Attachment A for guidance), install new bearings, seals, fittings, lock washers, and locknuts conforming to 2.3, using 2.7 and Chapter 6 of 2.8 for guidance.

3.30.1.1 Install Type 111, Class 8 (double seal) bearings in motors meeting the criteria identified in Chapter 6 of 2.8. Only double seal bearings identified in Chapter 6 of 2.8 are acceptable for this use.

3.30.1.2 For vaneaxial and tubeaxial fan motors not meeting the criteria of Chapter 6 of 2.8, if not originally furnished or already accomplished during previous repair, install Type 111, Class 8 (double seal) bearings with a C3 (greater than normal) radial internal clearance in place of the Type 111 bearing originally furnished. Install Type 120 bearings in vaneaxial and tubeaxial fan motors originally furnished with Type 120 bearings.

3.30.1.3 Install **each** new label plate with the inscription "DO NOT LUBRICATE" on equipment using double seal bearings (Type 111, Class 8 or Type 120).

3.30.1.4 For equipment converted from re-lubricable bearings to double seal bearings, install pipe plugs on all grease fills and drains.

3.30.1.5 For equipment converted from lubricated bearings to double seal bearings, submit one legible copy, in approved transferrable media, of a report that reflects the change in the maintenance requirements for the converted motor.

3.30.2 For equipment not using double seal bearings, lubricate bearings with grease conforming to DOD-G-24508 as required in Paragraphs 244-1.7.7.2 and 244-1.7.7.3 of 2.7.

3.31 Assemble the equipment disassembled in 3.7, using 2.3 through 2.8 for guidance.

3.31.1 Do not use materials containing silicone in the repair and reassembly of equipment with commutator or collector rings.

3.31.2 Install **each** new fastener **in place of those identified to be missing or defective**.

3.31.3 Fasteners requiring a permeability factor of 2.0 or less shall conform to Grade 304 CRES.

3.31.4 Install **each** new gasket on covers, inspection plates, and between the external connection box and the frame. Gaskets shall conform to MIL-PRF-1149 unless otherwise specified in 2.3.

3.31.5 Adjust air gap as specified in 2.3, plus or minus 10 percent.

3.31.6 Rotate shaft by hand a minimum of 3 revolutions. Rubbing or binding of rotating assembly shall not be allowed.

3.31.7 Install **each** label plate conforming to MIL-DTL-15024 for those **identified** to be missing or damaged.

(V) "NO-LOAD SHOP TEST"

3.32 Accomplish a no-loadshop test of the motor for a minimum of one-half hour.

3.32.1 Verify proper direction of rotation.

3.32.2 After one-half hour, record current and voltage in each phase, speed and bearing temperature rise measured on the equipment's exterior near each bearing.

3.32.3 Submit one legible copy, in approved transferrable media, of the recorded data to the SUPERVISOR.

(V) "OPERATIONAL SHOP TEST (FOR VANEAXIAL/TUBEAXIAL FANS - ASSEMBLY COMPLETELY REASSEMBLED) "

3.33 With the vaneaxial/tube axial fan reassembled, accomplish an operational test for one hour after bearing and stator temperatures stabilize within **one** degree C for three consecutive 15-minute intervals.

3.33.1 Verify proper direction of rotation.

3.33.2 Record current, voltage, frame and bearing temperature rise and speed at 15-minute intervals.

3.33.2.1 Bearing temperatures shall not exceed 180 degrees Fahrenheit, unless otherwise specified in the invoking Work Item or equipment technical manual.

3.33.3 Measure and record hot insulation resistances of winding to ground immediately upon completion of the operational shop test, using a 500-volt megger.

3.33.4 Submit one legible copy, in approved transferrable media, of the recorded data to the SUPERVISOR.

3.34 Install equipment removed in 3.4.

3.34.1 Replace **each** fastener removed in 3.4 **in place of those identified to be missing or defective.**

3.34.1.1 Install **each** new gasket conforming to MIL-PRF-900 on disturbed ventilation.

3.34.2 Remove **each** existing body-fitted bolt and stud and **replace with** new fitted bolts and studs.

3.34.3 Fasteners, body-fitted bolts, and studs requiring a permeability factor of 2.0 or less shall conform to Grade 304 CRES.

3.34.4 Align equipment in accordance with 2.3. Measure and record facial and peripheral coupling data.

3.34.4.1 Install chocks, shims, shock mounts, and sound damping pads.

3.34.4.2 Accomplishment of pump and driver shaft alignment shall be in accordance with NAVSEA Standard Items (See Note 4.11).

3.34.5 Connect electrical cables to equipment, using data retained in 3.3.1.



3.34.6 Bond and ground equipment in accordance with 2.9, using new ground straps.

3.34.7 Rotate shaft by hand a minimum of 3 revolutions. Rubbing or binding of rotating assembly not allowed.

3.34.8 Measure and record the air gap and bearing clearance (sleeve bearing equipment only), insulation resistance (at 500 volts DC), and thrust.

(V) (G) "OPERATIONAL TEST"

3.35 Accomplish an operational test of the assembled equipment at full system capacity for **a minimum of** one hour after bearing and stator temperatures stabilize within **one** degree C for three consecutive 15 minute intervals, unless otherwise specified in the invoking Work Item. **If temperatures do not stabilize in four hours, stop test and contact the SUPERVISOR.**

3.35.1 Verify proper direction of rotation.

3.35.2 Record current, voltage, frame and bearing temperature rise, and speed at 15-minute intervals. Frame and bearing temperature rise and speed is not required for vaneaxial and tubeaxial fan assemblies.

3.35.2.1 Bearing temperatures shall not exceed 180 degrees Fahrenheit unless otherwise specified in the invoking Work Item/equipment technical manual.

3.35.3 Measure and record hot insulation resistances of windings to ground immediately upon completion of test, using a 500-volt megger.

3.36 Submit one legible copy, in hard copy or approved transferrable media, of a report listing data recorded in 3.34.4, 3.34.8, 3.35.2, and 3.35.3 to the SUPERVISOR.

#### 4. NOTES:

4.1 This Standard Item is concerned primarily with the requirements to rewind rotating electrical equipment with a sealed insulation system in accordance with 2.2. Each Certified Repair Activity has developed a SIS Rewind Procedure (SISRP) that has been reviewed, approved by and filed with NAVSEA. In most cases, these Repair Activity SISRPs are treated as proprietary and may not be available to the SUPERVISOR for process review. The NAVSEA approved Repair Activity SISRP is the guiding document by which the equipment is to be rewound and supersedes any specification detailed in this Standard Item.

4.2 Equipment technical manual, Allowance Parts List (APL) (if applicable) and drawings will be listed in the invoking Work Item.

4.3 Shop test of generator will be addressed in the invoking Work Item.

4.4 The use of silicone is not allowed on any rotating electrical machinery containing brushes.

4.5 For the current list of NAVSEA-certified facilities for Vacuum Pressure Insulation (VPI) Sealed Insulation Systems, contact Naval Surface Warfare Center Carderock Division, Department 934, Phone (215) 897-7245.

4.6 Utilize Attachment A for determination if the Navy's motor bearing conversion program for Extended Life Double Seal (ELDS) ball bearings is permissible.

4.7 MIL-B-17931 (Bearings, Ball, Annular, For Quiet Operation) bearings are considered to be Long Lead Time (LLT) material. It is recommended these bearings be provided as Government Furnished Material (GFM).

4.8 Data received in 3.30.1.5 shall be forwarded to the SUPERVISOR for the purpose of initiating action ensuring shipboard databases such as the Equipment Guidance List (EGL) are updated to reflect the change in maintenance requirements for converted motors. Additionally, where APL changes are initiated to convert to ELDS bearings, a COSAL feedback report shall be submitted, providing the NSN and part number for the ELDS bearing by the SUPERVISOR. Utilize the following website to initiate changes to Technical Manuals, APLs, etc.: <http://www.navy311.navy.mil>.

4.9 If cleaning and painting of 3.7.3, 3.28.1, or 3.29 is required; the use of Category II Standard Item 009-32 "Cleaning and Painting Requirements; accomplish" **of 2.1** will be specified in the Work Item.

4.10 If balancing of rotating equipment of 3.25 is required; the use of Category II Standard Item 009-15 "Rotating Machinery; balance" **of 2.1** will be specified in the Work Item.

4.11 If pump and driver shaft alignment of 3.34.4.2 is required; the use of Category II Standard Item 009-58 "Pump and Driver Shaft Alignment; accomplish" **of 2.1** will be specified in the Work Item.

ATTACHMENT A

1. To reduce motor maintenance and repair costs, the NAVY has implemented a program that allows for the use of Extended Life Double Seal (ELDS) bearings.

2. LIMITATIONS: The ELDS program does NOT apply to motors that are under the cognizance of NAVSEA 08.

3. APLs for motors meeting the conversion criteria requirements have been modified to identify ELDS bearings. In these cases, the APL bearing criteria will override any specifications delineated in the equipment technical manual or the motor "Original Equipment Manufacturer (OEM)" drawings. If ELDS bearings are not indicated in an APL, the following motor criteria must meet the applicability specifications for motors to undergo conversion to ELDS bearings:

3.a Motor must be installed on a surface ship and must NOT be under the cognizance of NAVSEA 08.

3.b Commercial motors are not eligible. Motors must have been furnished to the NAVY in accordance with MIL-DTL-17060 (Motors, Alternating Current, Integral Horsepower, Shipboard use), MIL-M-17413 (Motors, Direct Current, Integral H.P., Naval Shipboard [NAVY]) or MIL-M-17059 (Motors, 60 Cycle, Alternating Current Fractional H.P. [Shipboard Use]).

3.c Motors using one or more noise-quiet bearings per MIL-B-17931 (Bearings, Ball, Annular, For Quiet Operation) are NOT eligible for ELDS conversion.

3.d Bearings originally furnished with the motor must be type 111 bearings per FF-B-171. Motors are NOT to be considered as candidates for ELDS conversion in situations where the equipment technical manual and/or the OEM motor drawings originally specified FF-B-171 bearings but have notes indicating that replacement bearings are to be in accordance with MIL-B-17931 (Bearings, Ball, Annular, For Quiet Operation).

3.e The use of ELDS bearings is limited to motors where the full load speed and the size of both bearings are as follows:

1. Maximum bearing size 306 or 206 and full load rpm between 1,801 and 3,600 rpm.

2. Maximum bearing size 313 or 213 and full load rpm between 1,201 and 1,800 rpm.

3. Maximum bearing size 318 or 218 and full load rpm less than 1200 rpm.

4. The repair process using ELDS bearings includes the following requirements:

4.a Only ELDS bearings, in accordance with the following table (Attachment A / Table 1), can be used. Other double seal bearings will not provide an acceptable bearing life.

## Attachment A / Table 1

## ELDS Bearings NSNs and Part Numbers

SIZE	P/N	NSN
201	6201-2RS1C3/GHY	3110-01-492-0221
202	6202-2RS1C3/GHY	3110-01-491-0233
203	6203-2RS1C3/GHY	3110-01-491-0234
204	6204-2RS1C3/GHY	3110-01-491-6636
205	6205-2RS1C3/GHY	3110-01-451-9166
206	6206-2RS1C3/GHY	3110-01-451-9165
207	6207-2RS1C3/GHY	3110-01-451-9164
208	6208-2RS1C3/GHY	3110-01-451-9170
209	6209-2RS1C3/GHY	3110-01-451-9252
210	6210-2RS1C3/GHY	3110-01-492-1831
211	6211-2RS1C3/GHY	3110-01-518-0937
303	6303-2RS1C3/GHY	3110-01-493-3750
304	6304-2RS1C3/GHY	3110-01-451-9153
305	6305-2RS1C3/GHY	3110-01-451-9158
306	6306-2RS1C3/GHY	3110-01-451-9159
607	6307-2RS1C3/GHY	3110-01-451-9161
308	6308-2RS1C3/GHY	3110-01-451-9167
309	6309-2RS1C3/GHY	3110-01-451-9168
310	6310-2RS1C3/GHY	3110-01-490-6683
311	6311-2RS1C3/GHY	3110-01-492-0223
312	6312-2RS1C3/GHY	3110-01-490-6848
313	6313-2RS1C3/GHY	3110-01-492-0191

314	6314-2RS1C3GHY	3110-01-492-0226
315	6315-2RS1C3/GHY	3110-01-494-0993
316	6316-2RS1C3/GHY	3110-01-492-0188
317	6317-2RS1C3/GHY	3110-01-492-0219
318	6318-2RS1C3/GHY	3110-01-493-3749

4.b Both bearings of each converted motor must be ELDS bearings.

4.c A label plate must be permanently attached to the motor indicating "Do Not Lubricate".

4.d Grease fills and drains, if present, must be fitted with a pipe plug, securely fastened. Fittings to accommodate grease guns must be replaced with pipe plugs."