

IEEE Standard for the Repair and Rewinding of AC Electric Motors in the Petroleum, Chemical, and Process Industries

IEEE Industry Applications Society

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**Petroleum and Chemical Industry Committee
of the
IEEE Industry Applications Society**

Approved 5 December 2015

IEEE-SA Standards Board

Abstract: This standard is intended to be a basic or primary document that can be utilized and referenced by owners of ac motors and generators (machines) that need refurbishment, repair, and/or rewinding, as well as service or repair facilities. It has been developed for the petroleum, chemical, and process industries, and it may be adapted to other areas of interest. The use of this standard is expected to result in higher quality and more cost-effective, timely repairs. A means of evaluating work performed and repair or service facilities is also provided.

Keywords: ac generator, ac machine, ac motor, IEEE 1068™, induction, refurbish, repair, repair facility, rewind, service facility, synchronous

The Institute of Electrical and Electronics Engineers, Inc.
3 Park Avenue, New York, NY 10016-5997, USA

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PDF: ISBN 978-1-5044-0103-6 STD20512
Print: ISBN 978-1-5044-0104-3 STDPD20512

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Charles “Chuck” Yung, *Chair*
William Lockley, *Vice Chair*
Javier Portos, *Secretary*

Dale Basso
Dennis Bogh
Austin Bonnett

J. Travis Griffith
Saeed Haq

Bryan Klontz
Tom Stewart
Mark Zawadski

The following members of the individual balloting committee voted on this standard. Balloters may have voted for approval, disapproval, or abstention.

Emmanuel Agamloh
Gabriele F. D. Alleva
Dale Basso
Thomas Bishop
Thomas Blair
William Bloethe
James Bryan
Paul Cardinal
Weijen Chen
Keith Chow
Glenn Davis
Davide De Luca
Gary Donner
Donald Dunn
Robert Durham
James Dymond
William Finley

Carl Fredericks
J. Travis Griffith
Randall Groves
Paul Hamer
Chris Heron
Lee Herron
Scott Hietpas
Werner Hoelzl
Richard Holub
Richard Hulett
Shahid Jamil
Yuri Khersonsky
Royce King
William Lockley
John McAlhaney, Jr.
William McBride
Bharat Mistry
Daleep Mohla

Paul Myers
Dennis Neitzel
Arthur Neubauer
Michael Newman
Lorraine Padden
Christopher Petrola
Iulian Profir
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Nikunj Shah
Jerry Smith
Gregory Stone
Edward Thornton
Wayne Timm
Kenneth White
Roger Wicks
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Hugh Zhu

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Ronald C. Petersen
Annette D. Reilly

Stephen J. Shellhammer
Adrian P. Stephens
Yatin Trivedi
Philip Winston
Don Wright
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Daidi Zhong

*Member Emeritus

Introduction

This introduction is not part of IEEE Std 1068™-2015, IEEE Standard for the Repair and Rewinding of AC Electric Motors in the Petroleum, Chemical, and Process Industries.

This document was originally published in 1990 and was revised in 1996. In keeping with the goals of maintaining progressive standards, in 2002 the Standards Subcommittee of the IEEE Petroleum and Chemical Industry Committee assigned a task force to revise and update this standard. References to other documents have been corrected. The wording in this standard was modified to reflect worldwide standards and to promote uniform application of such devices in petroleum and chemical industry facilities.

Contents

1. Overview	1
1.1 Scope	1
1.2 Purpose	2
2. Normative references	2
3. Definitions	4
4. Responsibilities	5
4.1 User responsibility	6
4.2 Repair facility responsibility	8
5. Preliminary assessment	8
5.1 Initial receipt	8
5.2 Incoming tests	10
5.3 Initial run check	11
6. Condition and damage appraisal	13
6.1 Component marking and evaluation	13
6.2 Detailed mechanical evaluation	16
6.3 Detailed electrical evaluation	23
6.4 Other	29
7. Cleaning and reconditioning	29
7.1 General	29
7.2 Reconditioning of flooded motors	30
8. Facility repair or refurbishment period	31
8.1 Receiving	31
8.2 Stripping	31
8.3 Stator and rotor lamination evaluation	32
8.4 Description of winding types	33
8.5 Replacement of coils	34
8.6 Bearing replacement and restoration of rotational fits and seals	45
8.7 Balancing	48
8.8 Electrical connections	49
8.9 Mechanical fits	50
8.10 Painting	51
8.11 Permanent magnet rotors	51
8.12 Miscellaneous	52
8.13 Final test	53
8.14 Shipping precautions	55
9. Field repairs	55
10. Post repair	55
10.1 Repair facility	55
10.2 User handling	55
Annex A (informative) Bibliography	57

Annex B (informative) Typical repair facility evaluation form.....	59
Annex C (informative) In-plant motor evaluation.....	69
Annex D (normative) Motor repair form (to be completed by owner).....	71
Annex E (normative) Condition report forms	73
Annex F (informative) Magnetic wedges	77
Annex G (informative) Repair checklist.....	78
G.1 Checklist	78
G.2 Final test results	79

IEEE Standard for the Repair and Rewinding of AC Electric Motors in the Petroleum, Chemical, and Process Industries

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1. Overview

1.1 Scope

This document covers general recommendations for the repair of alternating current (ac) electric motors and includes guidelines for both the user and the repair facility. It is not intended to replace specific instructions contained in the manufacturer’s instruction book or in any contractual agreement between a manufacturer and a purchaser of a given machine. For the purpose of this document, the term *motor* is used in lieu of, and shall equate to, the terms *wound rotor*, *generator*, and *machine*.

This standard covers reconditioning, repair, and rewind of horizontal and vertical induction motors and of synchronous motors. It applies to all voltages 15 kV and less, and all ratings above 0.75 kW (1 hp).

This standard applies only to the repair of motors, and in cases involving modifications to the basic design, care must be taken so as not to negatively affect the safety and reliability of the motor.

Excluded from the scope of this standard are the following:

- Specific requirements, certification, and inspection required for explosion proof, dust-ignition proof, flameproof, and like motors having a listing issued by a Nationally Recognized Testing

Laboratory (NRTL), for example, American Bureau of Shipping (ABS), Underwriters Laboratories, Inc. (UL), Factory Mutual (FM), and Canadian Standards Association (CSA). For motors in this category, the user shall verify if the repair facility shall be certified by such an agency.

- Any specific or additional requirements for hermetic motors, hydrogen-cooled generators, submersible motors, or Class 1E nuclear service motors.
- Direct current (dc) motors.

1.2 Purpose

This standard is intended to be used and referenced by users of motors that need repair as well as by owners and operators of establishments that offer motor repair services. It has been developed primarily for the needs of the petroleum, chemical, and process industries, but can be adapted to other applications or industries.

The use of this standard by users and repair facilities is expected to result in higher quality, cost-effective, timely repairs. It also provides a means of evaluating repairs and facilities.

2. Normative references

The following referenced documents are indispensable for the application of this document (i.e., they must be understood and used, so each referenced document is cited in text and its relationship to this document is explained). For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments or corrigenda) applies.

ANSI/ABMA 20, Radial Bearings of Ball, Cylindrical Roller and Spherical Roller Types—Metric Design.^{1, 2}

API 541, Form-Wound Squirrel-Cage Induction Motors—500 Horsepower and Larger.³

API 541-2014 (6.3.3.13, Annex D, Annex E), Form-Wound Squirrel-Cage Induction Motors—500 Horsepower and Larger.

API 546, Brushless Synchronous Machines—500 KVA and Larger.

API 546-2008 (2.4.6.3, 4.3.3.11, Annex F, Annex G) Brushless Synchronous Machines—500 KVA and Larger.

API 547, General-Purpose Form-Wound Squirrel Cage Induction Motors—250 Horsepower and Larger.

ASTM B117, Standard Practice for Operating Salt Spray (Fog) Apparatus.⁴

IEC 60034-8, Rotating Electrical Machines—Part 8: Terminal Markings and Direction of Rotation.⁵

¹ ANSI publications are available from the Sales Department, American National Standards Institute, 25 West 43rd Street, 4th Floor, New York, NY 10036, USA (<http://www.ansi.org>).

² ABMA publications are available from the American Bearing Manufacturers Association (ABMA), 2025 M Street, NW, Suite 800, Washington, DC 20036 (<http://www.abma-dc.org>).

³ API publications are available from the Publications Section, American Petroleum Institute, 1200 L Street NW, Washington, DC 20005, USA (<http://www.api.org>).

⁴ ASTM publications are available from the American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959, USA (<http://www.astm.org>).