

D77 Traction Motor Services

*Basic Overhaul Repair
and Return*

Basic Overhaul UTEX

Extended Life UTEX

*Long Life Overhaul
UTEX*

	<i>Basic Overhaul Repair and Return</i>	<i>Basic Overhaul UTEX</i>	<i>Extended Life UTEX</i>	<i>Long Life Overhaul UTEX</i>
Steam clean	X	X	X	X
Oven Dry	X	X	X	X
Sandblast frame and caps			X	X
Replace leads and WAF as required		X		
Replace lead set and WAF			X	X
Dimensional frame inspection	X	X	X	X
Welding and machining back to OEM Service Specs			X	
Welding and machining back to OEM New Specs				X
Line bore Axle caps			X	X
Rewind Armature to D78 configuration				X
Install refilled Commutator				X
Install new Pinion End housing				X
Install new Comm End Bearing Housing				X
Non-Destructive test (NDT) Pinion End Housing	X	X	X	
Non-Destructive test (NDT) Pinion Gear	X	X	X	X
Non-Destructive test (NDT) Axle Caps	X	X	X	X
Non-Destructive test (NDT) Armature Shaft	X	X	X	X
Replace up to 2 frame coils with Silicone style Main and Interpole Coils		X		
Replace all frame coils with Silicone style Main and Interpole Coils			X	X
VPI frame and armature	X	X	X	X
Turn, undercut and balance armature	X	X	X	X
Install new Arc Resistant Silicone (ARS) commutator band	X	X	X	X
Install new Oil Slingers on Armature				X
Replace PE & CE bearings (FAG or SKF)	X	X	X	X
Rebuild brush holders w/new studs	X	X	X	X
Replace carbon brushes	X	X	X	X
Replace all seals and gaskets	X	X	X	X
Replace pinion seal and oil slinger	X	X	X	X
Replace yellow oil filler caps	X	X	X	X
Shim axle cap 0.009"	X	X	X	X
Replace hardware with new as needed	X	X	X	X
Run Test Motor For:	X	X	X	X
30 minutes in each direction (60 min total)	X	X		
60 minutes in each direction (120 min total)			X	
120 minutes in each direction (240 min total)				X
Paint motor	X	X	X	X
Bag and secure to skid for shipping	X	X	X	X

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