

OPERATIONAL METHOD SHEETS

PROCESS:	D-flanged Motor/Compr Misalignment Verification	
STATION# : Final Assem	O.M.S.# : OMS-105	Orig Rel Date: 5-19-2011
PAGE: 1 of 1	REV # : 001	REV Date 11-28-2012
Q.E. SIGN:	Originator: W. Crisp/R. Tolan	Revised By

◆ CHECK
 ■ WORK CONTENT
 ● VERIFY

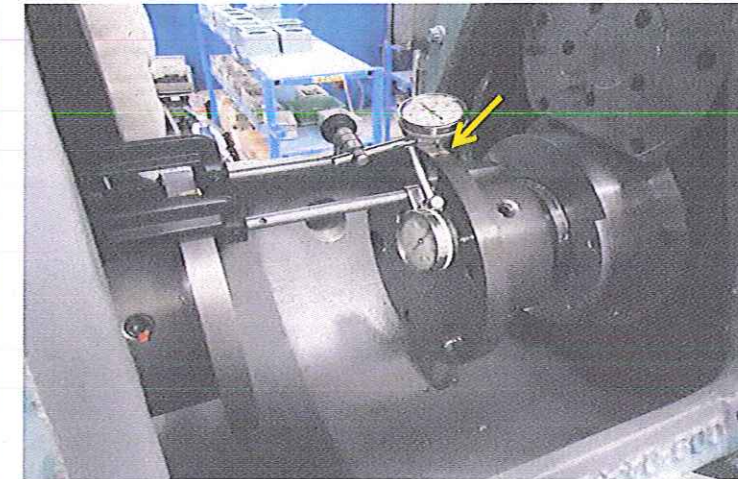
Approvals					
Mfg Engr Mngr	Mtrl Mngr	Prod Mngr	Safety Mngr	Q.A. Mngr	Plant Manager
					
Date: 11-29-12	Date: 11/28/12	Date:	Date:	Date: 11-28-12	Date: 11/29/12



Tools needed to perform misalignment verification. Reference OMS-026 for coupling installation and shimming.
 See notes at the end of this OMS.



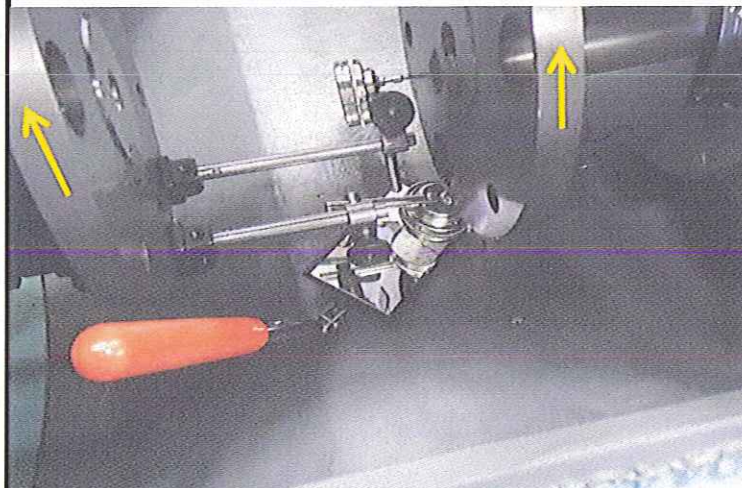
Identify compressor/motor hub top center with a yellow mark. Reference OMS-026 for coupling installation and shimming. This OMS references misalignment verification only.



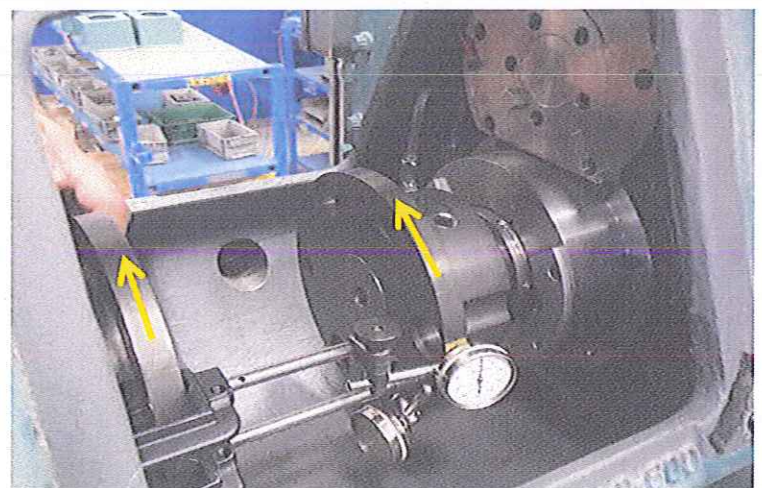
Rotate marks to top center and set up indicators as illustrated. Indicators to be set up with a minimum of 1 revolution load on the needles and set dial to 0. Rotate motor & compr shafts 360° to ensure indicators return to 0.



Rotate motor & compressor shafts to 90° (rotation must be in same direction as operating rotation) position & log indicator readings in Final Assembly Check Sheet "Total Misalignment".



Rotate motor & compressor shafts to 180° position & log indicator readings in Final Assembly Check Sheet "Total Misalignment". Mirror will be needed to view readings.



Rotate motor & compressor shafts to 270° position & log indicator readings in Final Assembly Check Sheet "Total Misalignment". Mirror may be needed or second operator to view readings.



Final rotation will be to 360° (back to top center), indicator readings should be within .005 of 0.

Notes

Rotation direction to be continuous, **always** in the direction of operating rotation, see rotation arrow on compressor

Indicator readings as follows:

- Arrow rotation toward 10 is a positive reading **.010**
- Arrow rotation toward 90 is a negative reading **-.010**

QAE to be notified if total misalignment exceeds **.028**

Indicator sag is approximately **.001**