**CLEAN, DIP, AND BAKE THE 1A SSTG STATOR (VRR 21-127)**

7.4.10 Using Ref 2.3 as guidance, CLEAN generator

assembly (rotor and stator) with hot fresh water

and non-ionic detergent in accordance with

paragraph 300-5.2.2.1 (Steam or Hot Water

Cleaning).

7.4.11 Using Ref 2.3 as guidance, RINSE generator

assembly (rotor and stator) per 300-5.2.5.1,

Freshwater Washing). Generator rotor/stator

shall be tested for salt residual in accordance

with paragraph 300-5.2.5.2 (Salt Content Test).

Rinsing shall continue for at least one (1) hour

after the salinity test shows that all salt has

been removed.

7.4.12 Using Ref 2.3 as guidance, DRY generator

stator/rotor in accordance with paragraphs 300-

5.3 (Drying and paragraph) and 300-5.3.2 (Oven

Drying). Rotor/stator temperatures shall be

monitored in accordance with paragraph 300-

5.3.1.2 (Temperature Monitoring).

7.4.13 In accordance with Ref 2.3 as guidance,

paragraph 300-5.3.2.4, the windings shall be

inspected during drying process and the

temperature lowered if there are any signs of

compound running out of the coils. The softening

point of different compounds may vary

considerably.

7.4.14 In accordance with Ref 2.3 as guidance,

paragraph 300-5.3.7.2, drying is completed when

either the insulation resistance readings show no

abrupt changes and do not increase more than 5

percent over a 12-hour period, or the

polarization index is greater than 3.0.

7.4.15 **Dip and Bake**. Upon satisfactory completion

of cleaning and drying, and using Ref 2.3, para

300.4.5.8 through 300.4.5.9 and para 300.5.5.4 as

guidance, accomplish insulation treatment

rotor and stator windings by dip tank or vacuum

pressure impregnated (VPI) with OEM approved

varnish/resin. Insulation is to be cured by

baking in accordance with varnish/resin

manufactures requirements. The Stator and Rotor

temperatures shall be monitored in accordance

with paragraph 300-5.3.1.2 (Temperature

Monitoring).

7.4.16 Clean and dress collector rings. Remove

black spots, dirt and debris from SSTG collector

ring set. Dress collector rings to a smooth

surface taking care to preserve the typical

“chocolate brown” copper oxide and graphite

surface film. Measure, record and report to the

MSCREP, total indicated run-out (TIR) of each

collector ring. Install new GFM brushes. Verify

free movement, alignment and proper spring

tension. Provide an “as released” report to the

Port Engineer.

7.4.17 Reassemble generator rotor/stator using new

Contractor Furnished bearing.

7.4.18 Once assembled, Contractor shall accomplish

a final Polarization Index Test in accordance

with Ref 2.3, paragraph 300-3.4.12. Record and

retain data. Submit copy to Port Engineer.

7.4.19 Return/rig generator assembly to ship and

install.

7.4.20 Re-connect generator and align in accordance

with OEM instruction and guidance.

7.4.21 Contractor shall provide megger readings of

each generator main power feed cables prior to

making final re-connections to generator. Provide

readings to MSCREP.