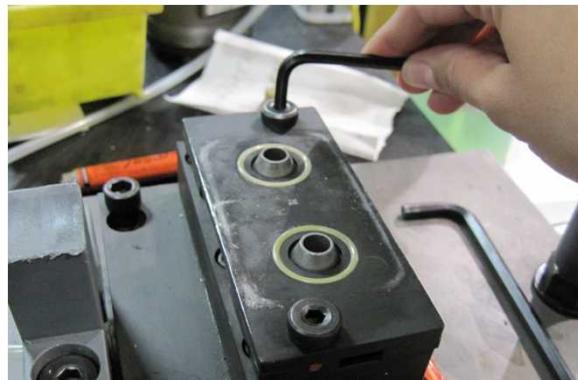


Rev.	Revision	Apr	By	Date	Rev.	Revision	Apr	By	Date	Description: Motor Assembly	OPER.	Part Number(s)
A	NEW RELEASE		KCB	2/9/2010						Model:	Material	All A, H, R, S, T Motors
B	Added Verification Test		KCB	10/4/2012						Date / By: 2/17/2010 KCB	Dept. 080	(Except motors with end ports)
C	Added Program Step 5		KCB	1/25/2013						Checked: KCB	TL	

Air Leak Test

STEP # 1



Set up

Install oring plates, depending on the housing ports size, there are 2 Oring plates tools for the Air Leak Test.

Housing Port Size	Plate
-001 7/8-14 UNF	1
-002 1/2-14 NPTF	1
-003, -004 Oring OD .688	2
-006 G 1/2 BSP	1
-007 9/16-18 UNF	1
-008, 011 M22 X 1.5	1
-009 G 1/2 BSP	1
-010 3/4-16 UNF	1
-012 M18 X 1.5	1
-103 Oring OD .688	2

For Housing 6026402-003 use special Plate 3

Plate	Tooling #	Oring
1	700256-001/002	20-398-00122
2	700256-120	20-398-00117
3	700256-121	00117/20-400-00010
	Manifold fixture	20-400-00124

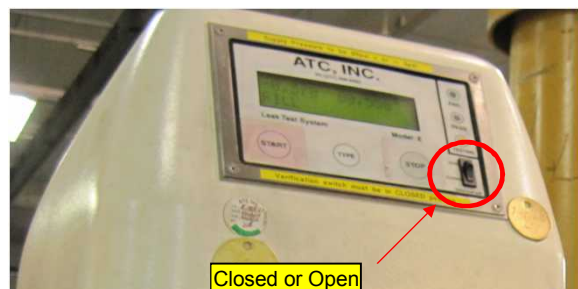
Verify that the oring are in a good condition and Install the oring plates on the air leak fixture. Tight

STEP # 2



Perform Verification test Closed and Open, at the beginning of each shift before testing. Test **Air Test Block** instead of a Motor Unit, per this Operation Instruction.

STEP # 3



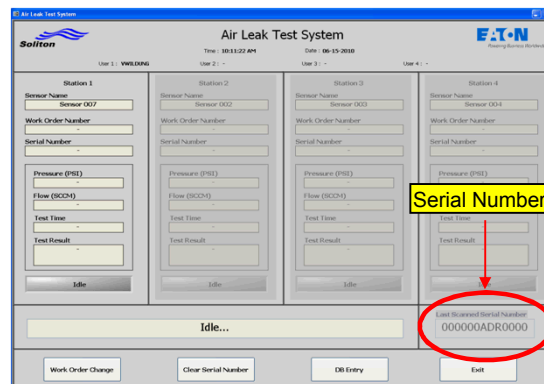
Verification test Closed, black switch should be in the close position. This test should **PASS**.

-If Air Test block failed this test, review the orings or contact Manufacturing Engineering.

Verification test Open, black switch should be in the open position. This test should Fail.

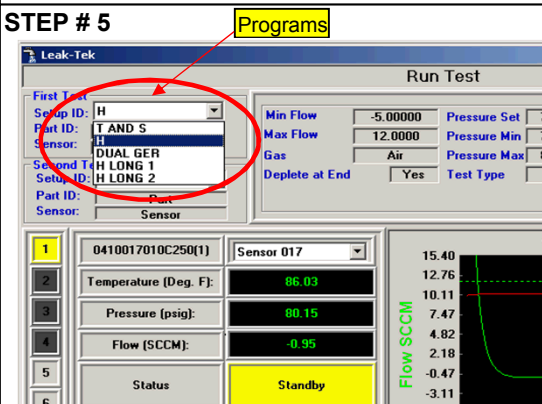
-If Air Test Block Pass this test, contact Maintenance or Manufacturing Engineering.

STEP # 4



Verify that the computer screen is showing the Air Leak Test System as shown above. For Software set-up and troubleshoot, review **OI ABV-2725-ALTS.XLS**

STEP # 5



Select the correct program for the Leak-Tek screen depending on the type of Motor to be tested.

H, T and S, Dual Ger for Motor 101-3724-009.
H LONG 1/2. to be used for H motor failure issues.



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B	Added Verification Test		KCB	10/4/2012						Date / By: 2/17/2010 KCB	Dept. 080	(Except motors with end ports)
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Air Leak Test

STEP # 6



Scan the Motor unit label and the serial number will appear on the screen .

STEP # 7



Place the Motor Unit on the test fixture, station 1 or 2. Both station can be used at the same time.

STEP # 8



Simultaneously press green buttons to clamp the unit. Verify that the unit has been properly clamped, the light should turn green and message on screen:

STEP # 9

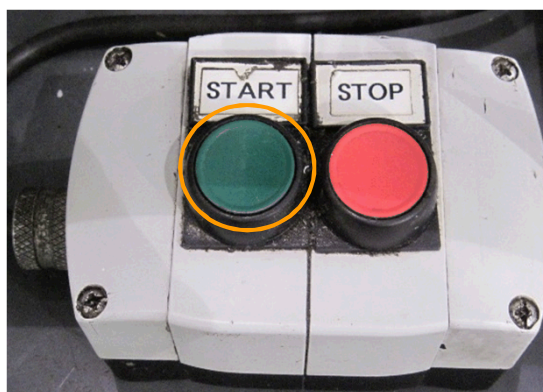
**UUT Clamped in Station
But Serial Number is invalid**

**Please Scan the Serial Number and
then clamp the unit.**

OK

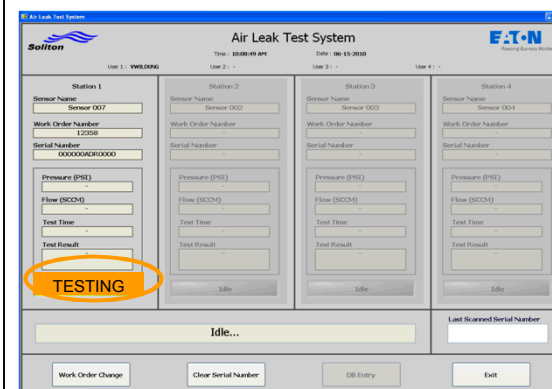
If the unit was not clamped correctly, a message will appear on the screen, select ok, remove the unit and scan again.

STEP # 10



Press the green Start button on the Start/Stop button to Bbegin the testing.

STEP # 11

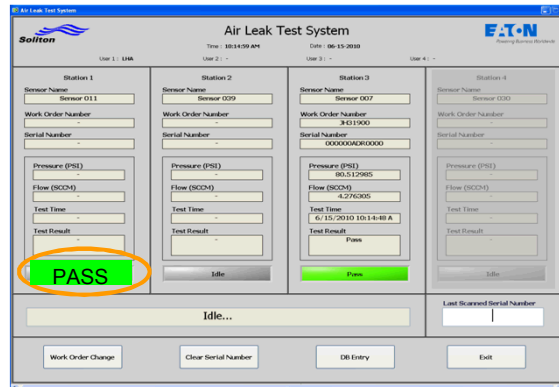


An amber message "TESTING" will appear on the screen and also the light will turn amber.

Rev.	Revision	Apr	By	Date	Rev.	Revision	Apr	By	Date	Description:	Motor Assembly	OPER.	Part Number(s)
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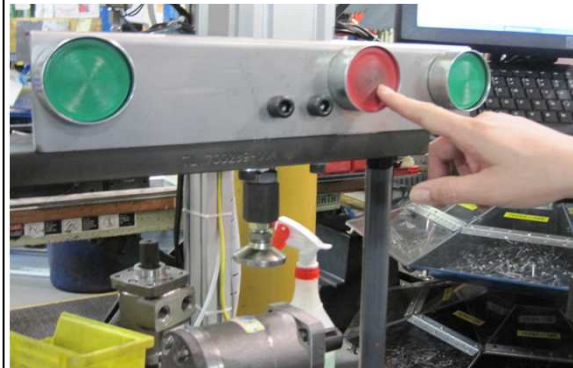
Air Leak Test

STEP # 12



If the unit Passed the test, the light will turn green and a green message "PASS" will appear on the screen.

STEP # 13



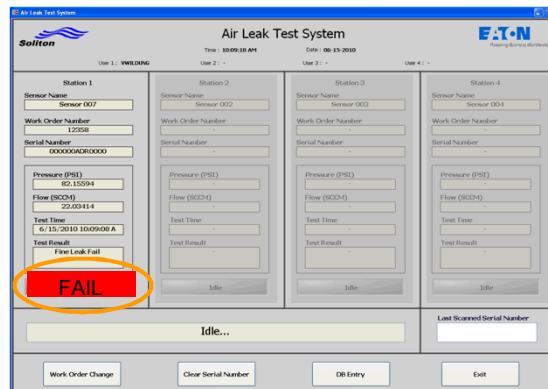
Press the red button to release the motor unit from the test fixture.

STEP # 14



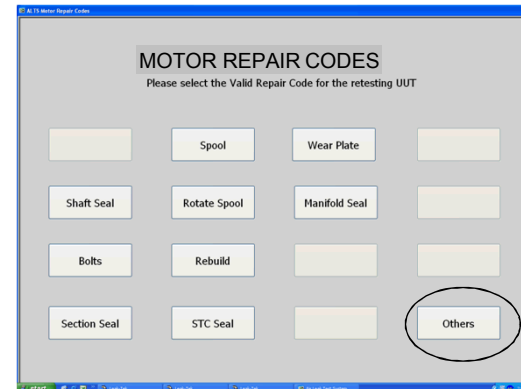
Mark the shaft with a ORANGE dot.
only if the unit pass the test

STEP # 15



If the unit Failed the test, the light will turn red and a red message "FAIL" will appear on the screen.

STEP # 16



If the unit failed, repeat the test, one more time. Keep the unit clamped (do not need to scan again). If the unit is scan again the screen for Motor Repair Codes will appear, select "Others"

STEP # 17



If the motor failed, place it on the table with the Orange area "Air Leak Failures" to be repaired and tested outside the line.