

LOW PRESSURE FEEDER

(REV.7 02/18/2010 B.L.Guy)

RECEIVING INSPECTION REPORT

JOB#: 50227827 DATE: 03/07/2012 INSPECTOR: B.L.Guy
SIZE: No 4 CUSTOMER: Lincoln P & T Lincoln, ME
S.H.#: 1144 KAMYR#: _____ MYRENS#: _____

GENERAL RECEIVING INFORMATION:

FEEDER SKID: <u>YES</u>	COMMENTS: <u>N/A</u>	<u>Feeder Settings @ Shipment</u>
HANDWHEEL: <u>YES</u>	COMMENTS: <u>N/A</u>	Cold Travel- _____
HANDWHEEL KEY: <u>YES</u>	COMMENTS: <u>N/A</u>	Rotor Setting- _____
SCALE: <u>YES</u>	COMMENTS: <u>N/A</u>	
SCALE POINTER: <u>YES</u>	COMMENTS: <u>N/A</u>	
FEET: <u>NO</u>	COMMENTS: <u>N/A</u>	
COUPLING: <u>YES</u>	COMMENTS: <u>Double row spur , Set flush with end of shaft</u>	
FLINGERS: <u>YES</u>	COMMENTS: <u>N/A</u>	
LANTERN RINGS: <u>YES</u>	COMMENTS: <u>N/A</u>	
EXHAUST COVER: <u>YES</u>	COMMENTS: <u>N/A</u>	
STEAM MANIFOLD: <u>NO</u>	COMMENTS: <u>N/A</u>	
LIFTING PLATES: <u>YES</u>	COMMENTS: <u>On top</u>	
REDUCER SUPPORT: <u>NO</u>	COMMENTS: <u>N/A</u>	

GENERAL REMARKS: _____

HARDWARE INSPECTION LIST

T.S. HEAD: <u>REPLACE</u>	# & SIZE: <u>16 ea 1 1/4"-12 X 3 1/2" lg</u>
D.S. HEAD: <u>REPLACE</u>	# & SIZE: <u>12 ea 1" -14 X 3" lg</u>
SPIDER: <u>OK</u>	# & SIZE: <u>N/A</u>
BEARING COVERS: <u>OK</u>	# & SIZE: <u>N/A</u>
HANDWHEEL HOLDER: <u>N/A</u>	# & SIZE: <u>N/A</u>
PACKBOX: <u>REPLACE</u>	# & SIZE: <u>8 ea 3/4"-10 X 3 1/2" lg HHCS</u>
PACKING GLAND: <u>OK</u>	# & SIZE: <u>N/A</u>
EXHAUST COVER: <u>OK</u>	# & SIZE: <u>N/A</u>

LOW PRESSURE FEEDER REBUILD REPORT (REV.6-01/16/2008)

JOB#: 50227827

DATE: 03/07/2012

INSPECTOR: B.L.Guy

SIZE: No 4

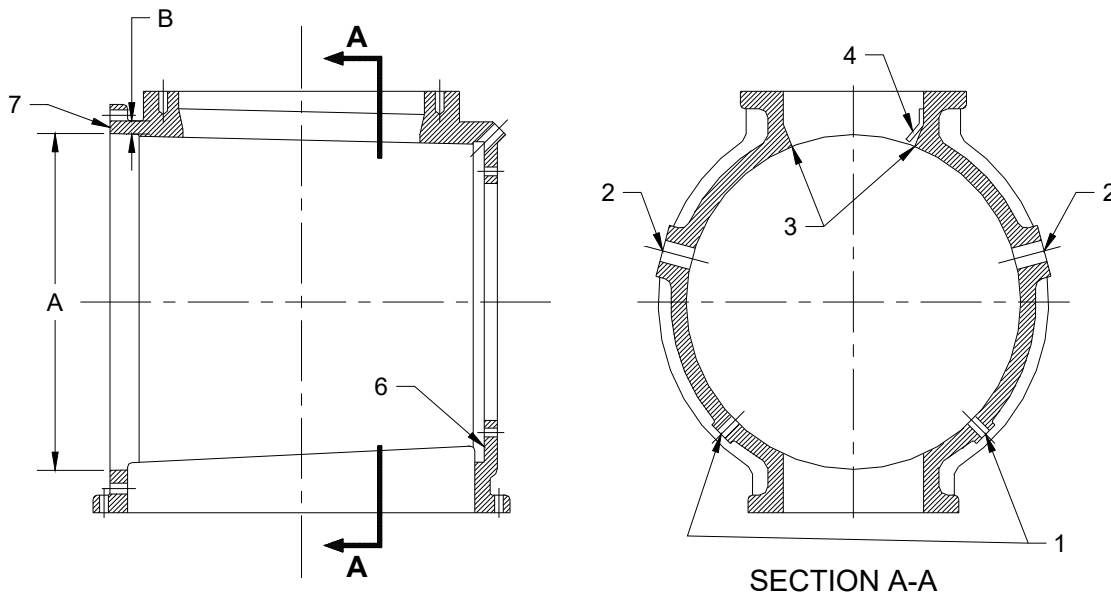
CUSTOMER: Lincoln P & T Lincoln, ME

S.H.#: 1144

KAMYR#: _____

MYRENS#: _____

ROTOR HOUSING



A) BORE SIZE AS RECEIVED: 34 7/8"
CONDITION OF BORE: Fair

ACTUAL FINISHED DIAMETER: _____

B) HOUSING WALL THICKNESS AS RECEIVED: 1 5/8" - 1 11/16"

1) POCKET PURGE: YES, 1 side only

CONDITION: OK

2) EXHAUST PORTS: YES, 2 ea ,REPAIR

CONDITION: 1 side eroded bad, see pics

3) SHEAR EDGE OVERLAY: REQUIRED

POCKET TAPER: 3/4" in use

CONDITION: Worn

4) DOCTOR BLADE: REPLACE

CONDITION: Full length gussett

5) FEEDER ROTATION(FROM D.S.): CW

RUN IN BOTH DIRECTIONS? Could

6) DRIVE SIDE GASKET FACE: OK

CONDITION: N/A

7) ADJUSTING SIDE GASKET FACE: OK

CONDITION: N/A

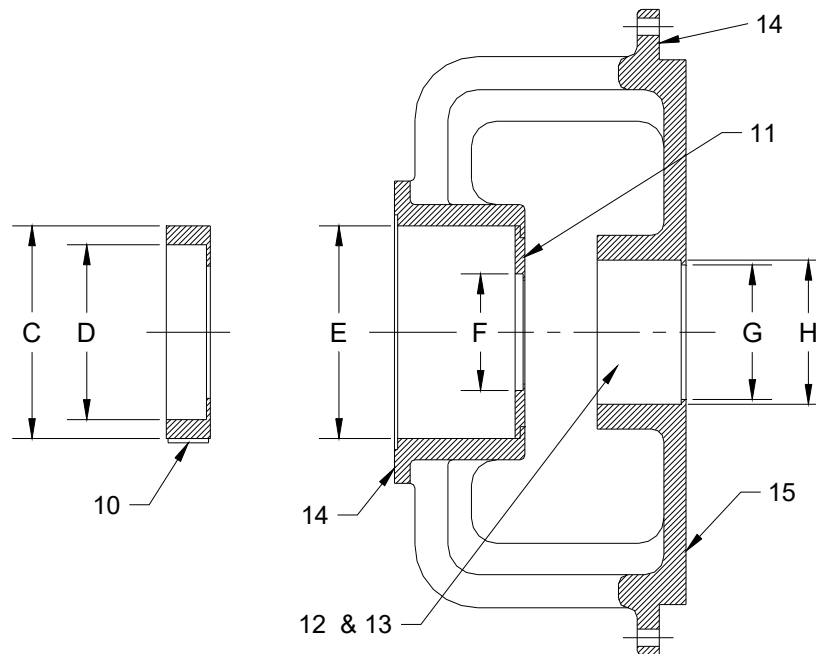
8) VISIBLE CRACKS: YES

CONDITION: See pics

9) TAPPED HOLES: REPAIR NUMBER & SIZE: 1 ea at adj. block on D/S. // 2 ea at T/S flange go thru into pocket // 2 ea T/S flange have badthreads. // 6 ea are "plug repaired" weld seams opening up, see pics

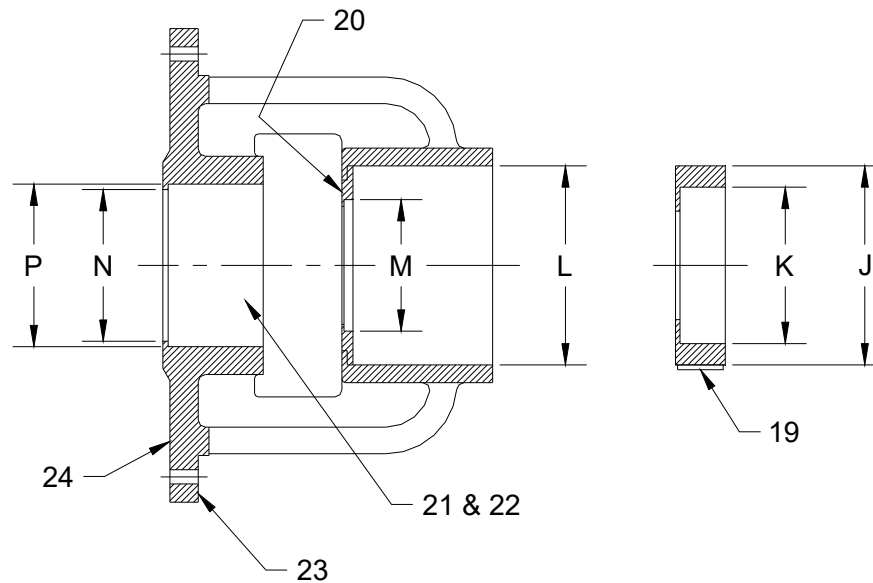
GENERAL REMARKS: _____

ADJUSTING SIDE END HEAD



	<u>AS RECEIVED</u>	<u>CONDITION</u>	<u>AFTER REPAIR</u>
C) SLIDING MEMBER O.D.:	<u>15.391</u>	<u>OK</u>	_____
D) SLIDING MEMBER I.D.:	<u>11.812/.813</u>	<u>OK</u>	_____
E) BEARING HOUSING BORE:	<u>15.394/.395</u>	<u>OK</u>	_____
F) SEAL BORE:	<u>9.250</u>	<u>Minor erosion</u>	_____
G) WEAR RING I.D.:	<u>7.933/.939</u>	<u>S/S radial scoring, see pics</u>	_____
WEAR RING BORE:	<u>N/A</u>	<u>N/A</u>	_____
H) PACKBOX BORE:	<u>9.375</u>	<u>OK</u>	_____
10) KEY/KEYWAY:	<u>Both OK</u>	<u>CONDITION: N/A</u>	
11) SEAL ADAPTER PLATE:	<u>YES,OK</u>	<u>CONDITION: Head pattern is not modified</u>	
12) PACKING GLANDS:	<u>YES,REPAIR</u>	<u>MAT'L: Stl</u>	<u>COMMENTS: Bore eroded out</u>
GLAND HARDWARE:	<u>REPLACE</u>	<u>DESCRIPTION: N/A</u>	
13) LANTERN RINGS:	<u>REPLACE</u>	<u>MATERIAL: Teflon</u>	<u>COMMENTS: Bore is worn</u>
14) GASKET FACE:	<u>OK</u>	<u>CONDITIONN/A:</u>	
15) BACKSIDE OF HEAD:	<u>OK</u>	<u>CONDITION: N/A</u>	
16) WEAR RING ADAPTER PLATE:	<u>N/A:</u>	<u>CONDITION: N/A</u>	
17) TAPPED HOLES:	<u>REPAIR</u>	<u>NUMBER & SIZE: 4 ea 3/4"-10 @ pk box</u>	
18) CLEAN-OUT PORTS:	<u>N/A</u>	<u>COMMENTS: _____</u>	
GENERAL REMARKS:	_____		

DRIVE SIDE END HEAD



	<u>AS RECEIVED</u>	<u>CONDITION</u>	<u>AFTER REPAIR</u>
J) SLIDING MEMBER O.D.:	<u>13.128</u>	<u>OK</u>	_____
K) SLIDING MEMBER I.D.:	<u>11.418/.419</u>	<u>OK</u>	_____
L) BEARING HOUSING BORE:	<u>13.132/.134</u>	<u>Minor erosion, dings</u>	_____
M) SEAL BORE:	<u>9.252</u>	<u>OK</u>	_____
N) WEAR RING I.D.:	<u>7.933/.940</u>	<u>S/S, OK</u>	_____
WEAR RING BORE:	<u>N/A</u>	<u>N/A</u>	_____
P) PACKBOX BORE:	<u>9.3745</u>	<u>OK</u>	_____
19) KEY/KEYWAY:	<u>Both OK</u>	CONDITION: <u>N/A</u>	
20) SEAL ADAPTER PLATE:	<u>YES,OK</u>	CONDITION: <u>Headpattern is not modified</u>	
21) PACKING GLANDS:	<u>YES,REPAIR</u>	MAT'L: <u>Stl</u>	COMMENTS: <u>Bore is eroded out</u>
GLAND HARDWARE:	<u>REPLACE</u>	DESCRIPTION: _____	
22) LANTERN RINGS:	<u>YES,REPAIR</u>	MATERIAL: <u>Teflon</u>	COMMENTS: <u>Bore is worn out</u>
23) GASKET FACE:	<u>OK</u>	CONDITION: <u>N/A</u>	
24) BACKSIDE OF HEAD:	<u>OK</u>	CONDITION: <u>N/A</u>	
25) WEAR RING ADAPTER PLATE:	<u>N/A</u>	CONDITION: <u>N/A</u>	
26) TAPPED HOLES:	<u>REPAIR</u>	NUMBER & SIZE: <u>4 ea 3/4"-10 @ pk box</u>	
27) CLEAN-OUT PORTS:	<u>N/A</u>	COMMENTS: _____	
GENERAL REMARKS:	_____		

PACK-RYT INFORMATION Form

REV. 1 01/16/2008 B.L.Guy

TENDING SIDE END HEAD:

PACK BOX BORE: See pg # 3

PACKBOX BORE LENGTH: 6 1/8" With wear ring

WATER HOLE DIAMETER: 5/16"

WATER HOLE LOCATION:
(FROM TOP OF WEAR RING TO C/L OF HOLE) 2 1/2" - 2 3/4"

WEAR SLEEVE DIAMETER: See print

DRIVE SIDE END HEAD:

PACK BOX BORE: See pg # 5

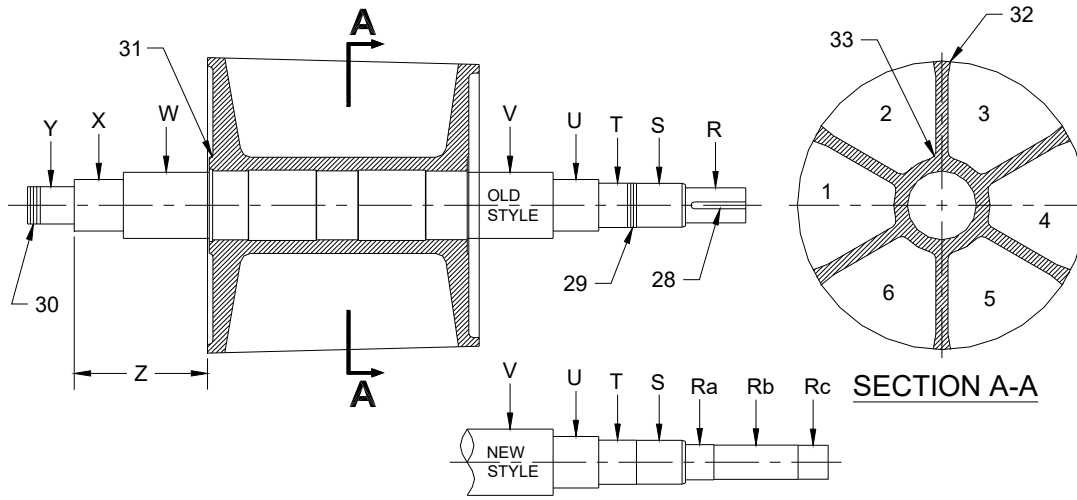
PACKBOX BORE LENGTH: 6 1/8" With wear ring

WATER HOLE DIAMETER: 5/16"

WATER HOLE LOCATION:
(FROM TOP OF WEAR RING TO C/L OF HOLE) 2 1/16"

WEAR SLEEVE DIAMETER: See print

ROTOR & SHAFT ASSEMBLY



ROTOR: Fabricated

	<u>AS RECEIVED</u>	<u>CONDITION</u>	<u>AFTER REPAIR</u>
R) DRIVE FIT DIAMETER:	<u>4.998</u>	<u>Linear scoring, see pics</u>	_____
Ra) INBOARD DRIVE FIT DIAMETER:	<u>N/A</u>	_____	_____
Rb) CLEARANCE DRIVE FIT DIAMETER:	<u>N/A</u>	_____	_____
Rc) OUTBOARD DRIVE FIT DIAMETER:	<u>N/A</u>	_____	_____
S) OUTBOARD SEAL FIT DIAMETER:	<u>5.314</u>	<u>OK</u>	_____
T) D.S. BEARING FIT DIAMETER:	<u>5.510</u>	<u>OK</u>	_____
U) INBOARD SEAL FIT DIAMETER:	<u>7.480</u>	<u>Eroded</u>	_____
V) D.S. WEAR SLEEVE DIAMETER:	<u>REPLACE</u>	<u>Worn</u>	_____
W) T.S. WEAR SLEEVE DIAMETER:	<u>REPLACE</u>	<u>Worn</u>	_____
X) T.S. SEAL FIT DIAMETER:	<u>7.480</u>	<u>Radial scoring</u>	_____
Y) T.S. BEARING FIT DIAMETER:	<u>4.919</u>	<u>OK</u>	_____
Z) BEARING SHOULDER TO FACE:	<u>17 3/8"</u>	<u>OK</u>	_____
28) KEYWAY: <u>1 1/4"X 5/8"X 8 3/8"</u>			<u>CONDITION:OK</u>
29) D.S. THREADS: <u>OK</u>	<u>CONDITION:N/A</u>		
30) T.S. THREADS: <u>OK</u>	<u>CONDITION:N/A</u>		
31) CRACKS AROUND HUB?: <u>NO</u>	<u>DESCRIPTION: N/A</u>		
32) BAR CRACKS?: <u>NO</u>	<u>DESCRIPTION: N/A</u>		
33) POCKET CORNER CRACKS?: <u>NO</u>	<u>DESCRIPTION: N/A</u>		

NOTE: SEE ATTACHED N.D.T. REPORT(S) FOR ROTOR/SHAFT.

GENERAL REMARKS: Rotor is pinned in place

MISCELLANEOUS COMPONENTS

- 34) SPIDER: YES COMMENTS: OK
- 35) SPINDLE: YES COMMENTS: Die Gage Fit - Loose
THREADS: OK COMMENTS: N/A
HARDWARE: REPLACE COMMENTS: 4 ea 3/4"-10 X 1 1/4" lg
- 36) BRASS NUT: YES COMMENTS: OK
HANDWHEEL FIT: 2.999 COMMENTS: OK
KEYWAY: SIZE: 1/2"X 1/4"X 2 3/4" COMMENTS: OK
FIT WITH SPINDLE- AXIALLY: .003 RADIALY: .004
- 37) BRASS WASHER: YES COMMENTS: OK
- 38) HANDWHEEL: YES COMMENTS: OK
HANDWHEEL BORE: 3.003 COMMENTS: OK
HANDWHEEL KEYWAY: 1/2"X 1/4"X Fulllength COMMENTS: OK
HANDWHEEL KEY: 1/2"X 1/2"X 2 1/2" COMMENTS: OK
- 39) 3"NUT & SHROUD: YES COMMENTS: OK
- 40) HANDWHEEL HOLDER: N/A COMMENTS: N/A
- 41) T.S. BEARING COVER: YES COMMENTS: OK
- 42) D.S. BEARING COVER: YES COMMENTS: OK
- 42a) SEAL BORE SIZE: 6.501 SIZE AFTER REPAIR: _____
- 43) EXHAUST COVER PLATE: REPAIR COMMENTS: Eroded 3/8" dp of 1/2" plate
- 44) STEAM PURGE MANIFOLD: NO COMMENTS: N/A
- 45) D.S. BEARING NUT: REPLACE COMMENTS: N/A
- 46) T.S. BEARING NUT: REPLACE COMMENTS: N/A
- 47) LOCK TAB WASHER: REPLACE COMMENTS: N/A
- 48) ADAPTER SLEEVE: REPLACE COMMENTS: N/A
- 49) LOCKPLATE: N/A COMMENTS: N/A
- 50) BEARING SHOULDER RINGS: N/A COMMENTS: N/A
- 51) DRIVE APPARATUS: Double row sprocket CONDITION: OK
BORE: 4.998 COMMENTS: OK
KEYWAY: 1 1/4"X 5/8"X Thru COMMENTS: OK
KEY: 1 1/4"X 1 1/4"X 8 3/8" COMMENTS: OK
PILOT: N/A COMMENTS: N/A
TAPPED HOLES: OK NUMBER & SIZE: N/A

GENERAL REMARKS: _____

Liquid Penetrant Inspection Form

REV. 1 10/24/06 B.L.Guy

JOB#: 50227827 DATE: 03/07/2012 INSPECTOR: B.L.Guy

SIZE: No 4 CUSTOMER & LOCATION: Lincoln P & T Lincoln ,ME S.H.#: 1144

SPECIFICATIONS: Section # 5 ASME COMPONENT: Rotor/Shaft

SOLVENT VISIBLE: WATER WASHABLE: XXX

RESULTS:

INSPECTOR CLOCK NUMBER: 907

ACCEPTED: REJECTED: XXX REMARKS: Rotor - Cracks and pinholes in pocket corners and end plate to end ring welds.

ACCEPTED: XXX REJECTED: REMARKS: Shaft - No defects found

ACCEPTED: XXX REJECTED: REMARKS: Sprocket - No defects found

ACCEPTED: REJECTED: REMARKS:

ACCEPTED: REJECTED: REMARKS:

ACCEPTED: REJECTED: REMARKS:

ACCEPTED: REJECTED: REMARKS:

ACCEPTED: REJECTED: REMARKS:

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ACCEPTED: REJECTED: REMARKS:

GENERAL COMMENTS:

Component Scrap Request

REV. 1 11/23/09 B.L.Guy

JOB#: 50227827 DATE: 03/07/2012 INSPECTOR: B.L.Guy
SIZE: No 4 CUSTOMER & LOCATION: Lincoln P & T Lincoln, ME S.H.#: 1144

INSPECTOR CLOCK NUMBER: 907

Items scrapped :

:T/S Packing gland REMARKS:Per R. Campbell

:D/S Packing gland REMARKS:Per R. Campbell

:Scale REMARKS:Per R. Campbell

:Pointer REMARKS:Per R. Campbell

:T/S Lantern ring REMARKS:Per R. Campbell

:D/S Lantern ring REMARKS:Per R. Campbell

:Exhaust Cover plate REMARKS:Per R. Campbell

:_____ REMARKS:_____

:_____ REMARKS:_____

:_____ REMARKS:_____

:_____ REMARKS:_____

:_____ REMARKS:_____

GENERAL COMMENTS:_____