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Distribution list Jenbach, Subsidiaries, Service Providers		
Service Technician Instruction	ST-224	16 October 2018

Engine type **Type 3, 4 and 6 engines with CGT DIG120/130/140/142 generators**

Subject **CGT DIG120/130/140/142 generators**
Inspection of the main stator winding slot wedges

The Service Technician Instruction ST-224 describes the criteria and process steps for inspecting the main stator winding slot wedges of CGT (Cummins Generator Technologies) DIG120/130/140/142 generators.

AFFECTED ENGINES / SCOPE OF THIS BULLETIN

Jenbacher gas engines with CGT DIG120/130/140/142 generators.

PURPOSE OF THIS BULLETIN / NEED FOR ACTION

This document informs of the need of assessing DIG generator main stator winding slot wedges and potential further actions **required during generator bearing exchange**. The generator manufacturer specifies the instructions in detail within Product Support Bulletin CGTS-S-00000079-1 (ST-224_Att-01 in DP Portal). The generator manufacturer is aware and has distributed the Bulletin to its generator service partners. Before distribution of this Service Technician Instruction, stator wedges were assessed and missing ones were replaced without criteria for replacement. Now only when met, the criteria listed below shall trigger further investigation or replacement of missing stator wedges.

DESCRIPTION OF THE CONTENT

Magnetic stator wedges used in CGT DIG generators are subjected to magnetic forces during operation which can cause the wedges to become loose and fall out with time. Please see below for illustrations of this issue.

During generator bearing exchange, the stator slot wedges shall be inspected by qualified generator service personnel for loose or missing wedges as per CGT's Product Support Bulletin CGTS-S-00000079-1 (ST-224_Att-01 in DP Portal).



Figure 1: Loose wedge



Figure 2: Missing wedge

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The criteria to trigger further actions after assessment are given as follows:

- **If any slot has >50% wedges missing**, contact CGT & Jenbacher Customer Service and forward the completed Service Record (see CGT Bulletin) and all digital images. CGT & Jenbacher will determine rework necessity and associated authorisation.
- **If <80% of the total number of slots are intact**, contact CGT & Jenbacher Customer Service and forward the completed Service Record (see CGT Bulletin) and all digital images. CGT & Jenbacher will determine rework necessity and nominate an appropriate Authorised Service Provider.
- **If >80% & <100% of the total number of slots are intact**, the alternator can be operated, but an increase of inspection frequency must be adopted in agreement with CGT & Jenbacher, and if desired, rework can be completed at the next service schedule.

RELEVANT DOCUMENTS

When working on Jenbacher modules, all applicable local regulations must of course be observed in addition to our documentation. In relation to this Service Technician Instruction we stress the fact that the following documents must also be observed:

- Technical Instruction TA 1100-0111: General Conditions – Operation and maintenance
- Technical Instruction TA 2300-0001: Employee protection
- Technical Instruction TA 2300-0005: Safety regulations
- CGT (Cummins Generator Technologies) Product Support Bulletin CGTS-S-00000079-1 (ST-224_Att-01 in DP Portal)

REVISION CODE

INDEX	DATE	DESCRIPTION / REVISION SUMMARY
01	Oct. 16, 2018	First version of this document

Table 1: Revision history