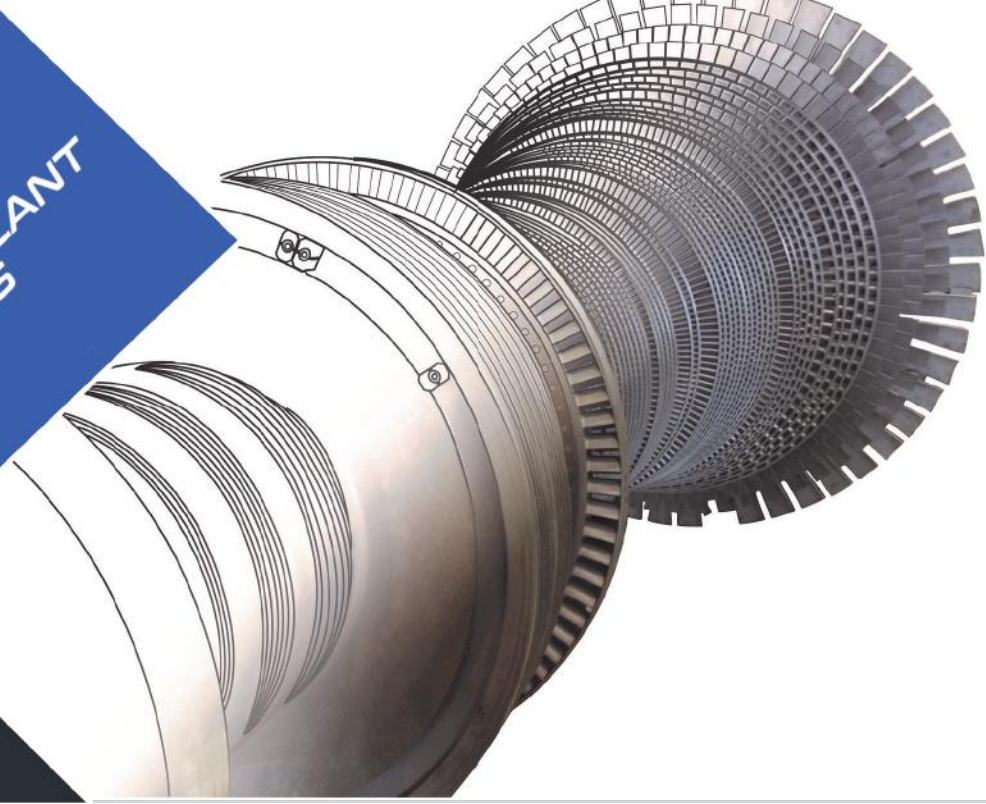




**PPS** | POWER PLANT  
SERVICES



## Rotor Repairs

The PPS Repair Team provides inspections to the received rotor to determine the scope of the problem. Once the minor and major rotor maintenance needs are determined, a full report is submitted to the customer. Approval from the customer on any repairs is obtained prior to performing work. The rotor process is then completed for blade replacement, weld restoration, or both, as determined by the clients approval. The PPS Repair Teams work in conjunction with our Manufacturing Teams to expedite the manufacturing of parts in order to meet our customer's delivery objectives.

### Repair Processes

- Receive rotor in shop and visually inspected.
- Blast clean rotor and perform NDE with Magnetic Particles
- Inspect rotors dimensions
- A set of Run-outs were taken and recorded.
- Polish thrust face journals
- Remove blades and reverse engineer damaged components for manufacturing of new blades (when required)
- Balance rotor with blades removed
- L-0 Root areas were cleaned and inspected. Inspect & clean Root areas
- New blades were moment weighted and installed as per incoming chart.
- Temporarily secure blades and check balance
- After moving blades as needed to achieve acceptable balance readings, pitches were recorded and new covers manufactured.
- Calculate blade movement to achieve proper balance readings.
- Manufacture new covers
- Install covers, hot peened, and red dye inspected.
- Provide final balance run



**PPS** | POWER PLANT  
SERVICES

[Sales@ppsvcs.com](mailto:Sales@ppsvcs.com)

(708)345-8600

[WWW.PPSVCS.COM](http://WWW.PPSVCS.COM)