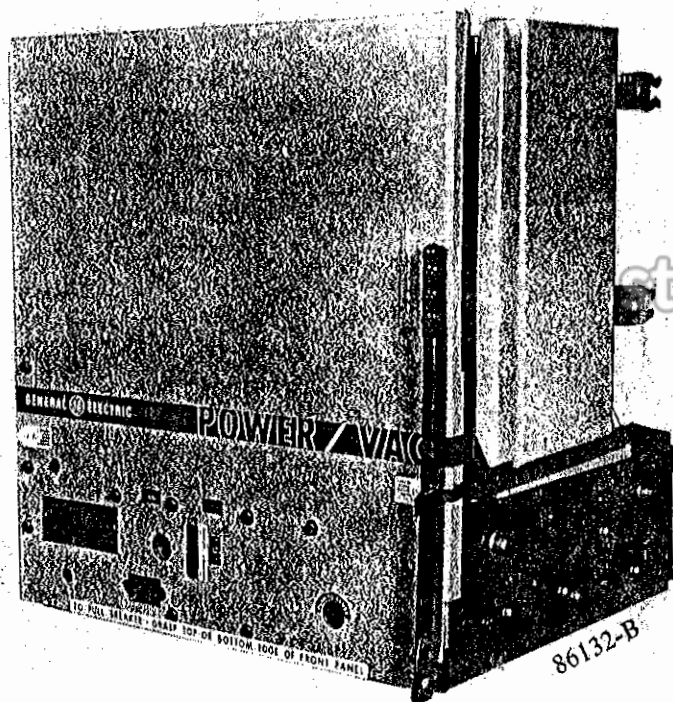




INSTRUCTIONS

POWER/VAC* VACUUM CIRCUIT BREAKER WITH ML-18 MECHANISM



store.ips.us



CONTENTS

	Page No.
1. INTRODUCTION	1
1.1. Safety	1
1.1.1. General	1
1.1.2. Specific	1
2. DESCRIPTION	2
3. RECEIVING, HANDLING AND STORAGE	2
3.1. Receiving	2
3.2. Handling	2
3.3. Storage	2
4. INSTALLATION	2
4.1. Safety Precautions	2
4.2. Interlocks	3
4.2.1. Rating Interference Plate	3
4.2.2. Closing Spring Discharge Interlock	3
4.2.3. Negative Interlock Roller	3
4.2.4. Positive Interlock Bar	3
4.2.5. Closing Spring Gag Interlock	3
5. OPERATION	3
5.1. Close Spring Charging	4
5.2. Closing Operation	4
5.3. Opening Operation	4
5.4. Trip Free Operation	5
6. CONTROL CIRCUIT	5
7. MECHANICAL CHECKING AND SLOW CLOSING	5
7.1. Visual Inspection	5
7.2. Closing Spring Charging	5
7.3. Closing Spring Gag	5
7.4. Slow Closing	5
7.5. Gag Plate Removal	5
8. DIMENSIONAL CHECKS	6
8.1. Primary Contact Erosion	6
8.2. Spring Wipe	6
8.3. Contact Gap	6
8.4. Close Coil Plunger Gap	6
8.5. Trip Coil Plunger Gap	6
8.6. Control Switch Adjustment	6

9. ELECTRICAL CHECKS	7
9.1. Electrical Operation	7
9.2. High-Potential Test	7
9.2.1. Primary Circuit	7
9.2.2. Secondary Circuit	7
9.3. Primary Circuit Resistance	7
9.4. Vacuum Interrupter Integrity Test	7
9.5. Insulation Tests	8
10. INTERLOCK FUNCTIONAL CHECK	8
11. MAINTENANCE	9
11.1. General	9
11.2. Service Conditions	9
11.3. Fault Interruptions	9
11.4. Contact Erosion	9
11.5. Transfer Finger Wear	9
11.6. Mechanism	10
11.7. Primary Insulation Parts	10
11.8. Lubrication	10
11.9. Recommended Maintenance	10
12. TIMING	10
13. OPENING AND CLOSING SPEED	11
14. REPAIR AND REPLACEMENT	11
14.1. General	11
14.2. Replacement of Interrupter Assemblies	11
14.3. Primary Disconnect Fingers	12
14.4. Mechanism	12
14.5. Control Switches	12
14.6. Trip Coil Replacement	12
14.7. Closing Coil Replacement	12
14.8. Auxiliary Switch Replacement	12
14.9. Motor Replacement	13
14.10 "Y" Relay Replacement	13
15. RENEWAL PARTS	13
15.1. Ordering Instructions	13
16. MECHANICAL ADJUSTMENTS	13
16.1. General	13
16.2. Wipe Adjustment	13
16.3. Contact Gap Adjustment	14
16.4. Trip Coil Plunger	14
16.5. Close Coil Plunger	14
16.6. Close Latch Stop Bolt	14
16.7. Spring Discharge Interlock	14
16.8. Negative Interlock	14

LIST OF ILLUSTRATIONS

	Page No.
FIGURE 1 RATING INTERFERENCE PLATE	15
FIGURE 2 FRONT VIEW OF POWER/VAC* BREAKER W/FRONT COVER	16
FIGURE 3 FRONT VIEW OF POWER/VAC* BREAKER W/O FRONT COVER	16
FIGURE 4 MANUAL CHARGING	17
FIGURE 5 MANUAL CHARGING	17
FIGURE 6 TOGGLE LINKAGE POSITIONS — ML-18 MECHANISM	18, 19
FIGURE 7 EROSION INDICATOR	20
FIGURE 8 OPERATING ROD ASSEMBLY	21
FIGURE 9 SCHEMATIC OF ML-18 MECHANISM	22, 23
FIGURE 10 TYPICAL WIRING DIAGRAM FOR ML-18 MECHANISM	24
FIGURE 11 POWER/VAC* BREAKER LEFT-FRONT VIEW	25
FIGURE 12 POWER/VAC* BREAKER, RIGHT-REAR VIEW	25
FIGURE 13 TRIP COIL AND LINKAGE	26
FIGURE 14 CLOSE COIL LINKAGE	27
FIGURE 15 BOTTOM VIEW OF ML-18 MECHANISM	28
FIGURE 16 CONTACT GAP ADJUSTMENT	29
FIGURE 17 SPRING DISCHARGE INTERLOCK	30
FIGURE 18 SAMPLE OPERATING SPEED GRAPHS	31
FIGURE 19 FLEX CABLE CONNECTION	32
FIGURE 20 NEGATIVE INTERLOCK	33
FIGURE C CLOSE COIL PLUNGER GAP	34
FIGURE G CONTACT GAP	35
FIGURE L CLOSE LATCH STOP	36
FIGURE S CONTROL SWITCHES	37
FIGURE T TRIP COIL PLUNGER GAP	38
FIGURE W SPRING WIPE	39

POWER/VAC* VACUUM CIRCUIT BREAKER WITH ML-18 MECHANISM

1. INTRODUCTION

1.1. SAFETY

Each user has the responsibility to instruct all personnel associated with this equipment on all safety precautions which must be observed.

The following are recommendations to be considered in a user's safety program. These recommendations are not intended to supplant the user's responsibility for devising a complete safety program and shall not be considered as such. They are rather suggestions to cover the more important aspects of personnel safety related to circuit breakers. G E neither condones nor assumes any responsibility for user practices which deviate from these recommendations.

1.1.1. GENERAL

All personnel associated with installation, operation and maintenance of power circuit breakers should be thoroughly instructed and supervised regarding power equipment in general as well as the particular model of equipment with which they are working. Instruction books and service advices should be closely studied and followed, including appropriate sections of "National Electric Safety Code" ANSI C2-1984 and revisions thereof.

Maintenance programs must be well planned and carried out consistent with both customer experience and manufacturer's recommendations including service advices and instruction books. Good maintenance is essential to breaker reliability and safety.

Local environment and breaker application must be considered in such programs, including such variables as ambient temperatures, actual continuous current, number of operations, type of interrupting duty, and any unusual local condition such as corrosive atmosphere or major insect problems.

These instructions do not purport to cover all details or variations in equipment nor to provide for every possible contingency to be met in connection with installation, operation or maintenance. Should further information be desired or should particular problems arise which are not covered sufficiently for the purchaser's purposes, the matter should be referred to the G E Co.

To the extent required, the products described herein meet applicable ANSI, IEEE and NEMA standards, but no such assurance is given with respect to local codes and ordinances because they vary greatly.

* Registered Trademark of GE.

1.1.2. SPECIFIC

DO NOT WORK ON AN ENERGIZED BREAKER. IF WORK HAS TO BE PERFORMED ON THE BREAKER, TAKE IT OUT OF SERVICE AND REMOVE IT FROM THE METALCLAD EQUIPMENT.

DO NOT WORK ON ANY PART OF THE BREAKER WITH THE TEST COUPLER ENGAGED.

All spring charged mechanisms related to a breaker must be serviced only by skilled and knowledgeable personnel capable of releasing each spring load in a controlled manner. PARTICULAR CARE MUST BE EXERCISED TO KEEP PERSONNEL CLEAR OF MECHANISMS WHICH ARE TO BE OPERATED OR RELEASED. Information on construction of such mechanisms is provided in this instruction book.

Operational tests and checks should be made on a breaker after maintenance, before it is returned to service, to insure that it is capable of operating properly. The extent of such tests and checks should be consistent with the level of maintenance performed.

If maintenance on the Power/Vac* breaker is being performed to an extended schedule such as a 5-year or 10-year program the vacuum interrupter integrity test should be performed each time the breaker is removed from the metalclad switchgear for reasons other than scheduled breaker maintenance if it has been more than one year since the last vacuum integrity test.

Interlocks are provided for the safety of the operator and correct operation of the breaker. If an interlock does not function as described DO NOT MODIFY OR DISFIGURE THE PARTS. DO NOT FORCE THE DEVICE INTO POSITION. CONTACT THE NEAREST GE APPARATUS AND ENGINEERING SERVICE OFFICE FOR INSTRUCTIONS.

2. DESCRIPTION

The Power Vac* vacuum circuit breaker is a horizontal drawout removable and interchangeable interrupting element for use in metalclad switchgear to provide protection and control of electrical apparatus and power systems. The Power Vac* Type VB1 circuit breaker with ML-18 mechanism is available in continuous current ratings of 1200 and 2000 amperes in accordance with industry standards. A combination 1200/2000 ampere breaker is also available. Refer to the breaker nameplate for complete rating information of any particular breaker. The nameplate also describes the control power requirements for that breaker. The application of a breaker must be such that its voltage, current and interrupting ratings are never exceeded. Since this book is written to include all ratings of the breaker, as well as several design variations, the instructions will be of a general character and all illustrations will be typical unless otherwise specified.

3. RECEIVING, HANDLING AND STORAGE

3.1. RECEIVING

Each breaker is carefully inspected before shipment. Immediately upon receipt of the circuit breaker, an examination should be made for any damage sustained in transit. If injury or rough handling is evident, a claim should be filed immediately with the transportation company and the nearest GE Sales Office should be notified.

It is expected that due care will be exercised during the unpacking and installation of breakers so that no damage will occur from careless or rough handling, or from exposure to moisture or dirt. Check all parts against the packing list to be sure that no parts have been overlooked.

3.2. HANDLING

When lifting the breaker, use of the specially designed lift truck is recommended. It is necessary to use the truck when placing a breaker into or removing it from the TWO-HIGH metalclad equipment. If it is necessary to lift the breaker with a hoist, use four 1/2 inch diameter hooks rated at least 500 pounds each. Lifting locations are provided in the frame side members (2, Fig. 1). Use a spreader wider than the breaker to prevent the slings from contacting the interrupter supporting insulating material parts. An optional accessory lifting sling is also available.

A front swivel wheel and two rear wheels are provided for ease of movement on flat level floors. When unattended breakers are left on a floor or when a lift truck is used, block

both rear wheels in both directions to prevent any accidental movement.

3.3. STORAGE

It is recommended that the breaker be put into service immediately in its permanent location. If this is not possible, the following precautions must be taken to assure the proper storage of the breaker.

The breaker should be carefully protected against condensation, preferably by storing it in a warm, dry room of moderate temperature such as 40° to 100° F. High humidity may have an adverse effect on the insulating parts and should be avoided. Circuit breakers for outdoor metalclad switchgear should be stored in the equipment only when power is available and the heaters are in operation to prevent condensation.

The breaker should be stored in a clean location, free from corrosive gases or fumes. Particular care should be taken to protect the equipment from moisture and cement dust, as this combination has a very corrosive effect on many parts.

Rollers, latches, etc. of the operating mechanism should be coated with 0282A2048P009 grease to prevent rusting.

If the breaker is stored for any length of time, it should be inspected periodically to see that rusting has not started and to insure good mechanical condition. Should the breaker be stored under unfavorable atmospheric conditions, it should be cleaned and dried before being placed in service.

4. INSTALLATION

4.1. SAFETY PRECAUTIONS

This circuit breaker uses powerful springs for energy storage. **DO NOT WORK ON THE INTERRUPTERS OR THE MECHANISM UNLESS THE CIRCUIT BREAKER IS IN THE "OPEN" POSITION AND BOTH THE CLOSING AND OPENING SPRINGS ARE EITHER DISCHARGED OR GAGGED AND ALL ELECTRICAL POWER IS REMOVED.** These precautions are required to prevent accidental operation. Anyone working on the circuit breaker should be familiar with the contents of this instruction book.

The circuit breaker has been shipped in the CLOSED position. After removing packing material, open the breaker by pushing in on the manual trip button (3, Fig. 2), while keeping hands away from moving parts, and verify that the operation counter advances one count.

Closing and opening springs are now in their discharged positions. Check this by first pressing the manual close button, then the manual trip button. The indicator flags on the front of the breaker should show "OPEN" and "DISCHARGED". All mechanical and electrical checks should be completed before putting breakers in service.

4.2. INTERLOCKS

Each Power/Vac* vacuum circuit breaker is provided with the following interlocks.

4.2.1. RATING INTERFERENCE PLATE

This interlock (1, Fig. 1) permits only a breaker with a matching continuous current, voltage and interrupting rating to be inserted into a metalclad compartment of identical rating.

The combination 1200/2000 ampere breaker can be used in either a 1200 or a 2000 ampere compartment. The rating interference plate must be adjusted to match the current rating of the compartment. This adjustment is done by positioning the outer interference plate so that the edge of the plate lines up with the current indicated on the label attached to the breaker just above the rating interference plate.

4.2.2. CLOSING SPRING DISCHARGE INTERLOCK

This interlock (4, Fig. 12) prevents racking into or out of the metalclad compartment a breaker that has the closing spring charged. This action is accomplished by a roller on the right side of the breaker mechanism which contacts the racking mechanism and discharges the closing spring unless the breaker is in the "DISCONNECT/TEST" position or the "CONNECT" position in the metalclad compartment. This interlock also opens the CL/MS switch in the motor circuit to prevent electrical charging of the closing spring when the breaker is between the "DISCONNECT/TEST" and the "CONNECT" position in the metalclad compartment.

4.2.3. NEGATIVE INTERLOCK ROLLER

The function of this interlock (5, Fig. 11) is to remove the trip latch from the trip roller thereby preventing a closing operation. The interlock also opens the LCS switch in the closing circuit thereby removing the close circuit power. The negative trip interlock is functional while the breaker is being moved between the "DISCONNECT/TEST" and the "CONNECT" position in the metalclad and upon withdrawal from the metalclad compartment.

4.2.4. POSITIVE INTERLOCK BAR

This interlock will prevent the racking of a closed breaker into or out of a metalclad compartment. A linkage connected to the cross shaft extends a detente angle (3, Fig. 11) out through the left side of the mechanism frame when the breaker contacts are in the closed position. If the breaker is in the "CONNECT" or "DISCONNECT/TEST" position in the metalclad the detente angle locks into the racking mechanism to prevent access to the hex section of the racking screw.

4.2.5. CLOSING SPRING GAG INTERLOCK

This interlock is provided to prevent a breaker that has a gagged closing spring from entering a metalclad unit. This function is accomplished by projecting an angle (1, Fig. 11) out of the left front side of the mechanism when the closing spring is gagged. This angle will interfere with the racking mechanism and block entry into the metalclad unit when the Closing Spring Gag Access Door is open.

5. OPERATION

The Power/Vac* vacuum circuit breaker uses a sealed vacuum power interrupter to establish and interrupt a primary circuit. Primary connections to the associated metalclad switchgear are made by horizontal bars and disconnect fingers, electrically and mechanically connected to the vacuum interrupters. Molded supports, one per pole on a three pole breaker, provide interchangeable mountings for the primary bars, interrupters, current transfer fingers, and heat dissipation fins (where used). The operating mechanism provides vertical motion at each pole location in order to move the lower contact of the vacuum interrupters from an open position to a spring-loaded closed position and then back to the open position on command.

The ML-18 mechanism (Fig. 9) is of the stored-energy type and uses a gearmotor to charge a closing spring. During a closing operation, the energy stored in the closing spring is used to close the vacuum interrupter contacts, charge the wipe springs which load the contacts, charge the opening springs, and overcome bearing and other frictional forces. The energy then stored in the wipe and opening springs will open the contacts during an opening operation.

Closing and opening operations are controlled electrically by the control switch on the metalclad door or remote relaying. Mechanical control is provided by manual close and

trip buttons on the circuit breaker. The closing spring may be manually charged, and a method for slow closing the primary contacts is available when the circuit breaker is withdrawn from the metalclad cubicle. See MECHANICAL CHECKING AND SLOW CLOSING. The mechanism will operate at the a-c or d-c voltage indicated on the circuit breaker nameplate.

5.1. CLOSE SPRING CHARGING

Figure 9 shows a front view of the ML-18 in a schematic form. The primary contacts are open and the closing springs are charged. The closing spring charging system consists of a closing spring (1,view B) mounted on the left side of the breaker and the electrical charging system mounted on the right side of the breaker. Both components are fastened to the cam shaft (2,view B). A manual charging system (3,view A) is provided so that the mechanism can be slow closed and the closing spring can be charged if there is a loss of electrical control power.

Spring charging is accomplished electrically by a rotating eccentric on the output shaft of the gear motor driving pivoted charging arms (4,view C) that oscillate about the centerline of a ratchet wheel (5,view C). A driving pawl (6,view C), mounted within the charging arms, oscillates with the charging arms. Starting from its rear-most position, as the charging arms rotate forward, a spring forces engagement of the driving pawl with a tooth on the ratchet wheel. The ratchet wheel is advanced by the rotating charging arms and pawl assembly. Advancement of one tooth spacing is provided for each oscillation of the system. The ratchet motion is restricted to one direction by a spring-loaded holding pawl that prevents the ratchet wheel from going backwards as the charging arms oscillate back to pick up the next tooth. Thirteen complete cycles of the charging arms are needed for a full charge of the closing spring. The efficient, compact gear motor accomplishes this action in just about two seconds. When the charging cycle is complete, the ratchet wheel is positioned so that a missing tooth is adjacent to the driving pawl and any motor overspin will not drive the ratchet wheel, thus preventing damage to the system.

When the spring is completely charged, the assembly is retained in that position by the close latch, until it is desired to close the circuit breaker.

The closing coil cannot be electrically energized unless the closing spring is completely charged. This action is prevented by the 52 CHG switch in the closing circuit.

The manual charging system (3,view A) works directly on the cam shaft where a one-way clutch (7,view A) driven by a manual handle provides rotation of the ratchet wheel.

Manual pumping of the handle advances the ratchet wheel and the holding pawl prevents counter-rotation while the handle is returning for another stroke. Six to eight complete strokes of the manual handle are required for one complete spring-charging operation. When the spring charge indicator (9, Fig.3) shows "CHARGED", MANUAL CHARGING MUST BE DISCONTINUED TO AVOID MECHANISM DAMAGE.

5.2. CLOSING OPERATION. (REFER TO FIG.9)

By either energizing the close solenoid or depressing the manual close button, the close latch (8,view C) is rotated, releasing the closing spring (1,view B). This action releases the energy in the closing spring and transmits it to the closing cam (9,view D) and closing roller (10,view D) and causes the linkage to rise until the prop (11,view D) can slip under the close roller (10, view D) and hold the linkage in place. As the linkage moves, the output crank (12,view D) rotates the cross shaft (13,view D) which in turn rotates the phase bell cranks (14,view E) on all three poles. The rotation of the phase bell cranks compresses the two opening springs (15,view E) on poles 1 and 3, closes the vacuum interrupters and compresses the wipe springs (16,view E) on each pole. The rotation of the cross shaft (13,view D) also changes the auxiliary switch (17, view D) position and the position flag on the front panel will then indicate "CLOSED". After the breaker is closed, the charging motor is again energized and the closing spring is charged as described under "CLOSE SPRING CHARGING". Spring charging is possible when the breaker is in the closed position because the linkage is held in place by the prop.

5.3. OPENING OPERATION. (REFER TO FIG. 9)

By either energizing the trip solenoid (18,view B) or depressing the manual trip button (23,view B), the trip latch (19,view D) is rotated, permitting the linkage to collapse and the vacuum interrupter contacts to open under the force of the wipe springs (16,view E) and opening springs (15,view E). At the end of the opening stroke the center phase wipe spring assemble hits the stop on the frame that limits overtravel and rebound. Rotation of the cross shaft from the closed to the open position operates the auxiliary switch (17,view D) which opens the trip coil circuit. If the closing spring has been recharged, the linkage will be reset and the trip latch will be in place on the trip roller ready for another closing operation.

If the closing spring has not been recharged, the trip latch may be held out of position. A latch-checking switch (21,view C) will not close unless the latch is in its normal position. The contacts of this latch-checking switch are in the closing circuit so that electrical closing is blocked when the trip latch is not reset.

5.4. TRIP-FREE OPERATION. (REFER TO FIG. 9)

The linkage is mechanically trip-free in any location on the closing stroke. Electrically energizing the trip coil while closing will, after the auxiliary switch contacts change position, rotate the trip latch and permit the circuit breaker to open fully. The linkage will reset as in a normal open operation and the closing spring will recharge as described under SPRING CHARGING.

6. CONTROL CIRCUIT

A typical POWER/VAC circuit breaker ML-18 mechanism wiring diagram is shown in Fig.10. Check the wiring diagram supplied with the actual circuit breaker for its wiring.

The close spring charging motor circuit is established through the CL/MS switch if the close latch is reset and the SM/LS switch if the closing spring is discharged. When the closing spring is charged, the SM/LS interrupts the circuit.

The close coil circuit is established through two normally closed 52Y relay contacts, and the latch checking switch LCS, if the trip latch is reset. An auxiliary switch contact 52b is also in series with the close coil and closes when the breaker is open and opens when the breaker is closed. During a close operation, cam rotation closes the SM/LS contact allowing the 52Y relay to be energized opening its contacts in the close coil circuit and sealing itself in through one of its own contacts to the close signal. This seal-in action prevents reclosing on a sustained close command as the close signal must be removed to drop out the Y relay and reestablish the closing circuit, thereby providing an anti-pump feature.

Circuit breaker mounted auxiliary switch contacts not used in the control circuit are brought out for control and indication functions. The metalclad equipment may provide a breaker-operated stationary auxiliary switch for additional contacts.

7. MECHANICAL CHECKING AND SLOW CLOSING

7.1. VISUAL INSPECTION

Visually inspect the circuit breaker for any signs of damage or loose hardware.

7.2. CLOSING SPRING CHARGING

Manually charge the breaker closing spring using the charging handle provided (1, Fig.5). The closing spring is charged by a ratcheting mechanism that advances by one ratchet tooth at a time. When the spring is fully charged and

the spring load is held by the closing latch, the spring indicator (8, Fig.2) will change from "DISCHARGED" to "CHARGED", and a positive snap will be heard as the spring travels over center. *After the spring is completely charged, as indicated above, further forcing the charging handle may cause damage to the closing latch and its associated parts.*

7.3. CLOSING SPRING GAG

Insert the closing spring gag plate (1, Fig.4) by opening the closing spring gag hole cover and inserting the tip of the gag plate between the end of the spring and the spring guide and engaging the detentes on the gag plate into the slots in the closing spring guide. Note that when the closing spring guide is exposed for gagging, an interference angle is exposed on the left side of the breaker (1, Fig.11). With the closing spring in the gagged position, this angle will provide interference preventing use of the lift truck and racking of the breaker element. No attempt should be made to alter, modify or otherwise make inoperative this safety feature. With the gag plate in position, depress the manual close button. This action will partially discharge the closing spring and also partially close the vacuum interrupter contacts. Do not energize the secondary control circuit at this time.

7.4. SLOW CLOSING

To manually slow close the breaker contacts, put the manual charge handle on the manual charge lever and move the handle up and down. The breaker will be fully closed when the spring charge indicator shows "CHARGED".

CAUTION: WITH THE GAG PLATE INSTALLED, THE BREAKER CLOSED AND OPENING SPRINGS CHARGED, THE BREAKER CAN BE TRIPPED AT FULL SPEED.

7.5. GAG PLATE REMOVAL

To remove the gag plate, the closing spring must be fully charged. If the spring charge indicator does not show "CHARGED" in the window, manually charge the spring until it does. Lift up and push in on the gag plate to clear the detentes on the gag plate from the slots in the closing spring guide. While holding the gag plate up, remove it from the opening. Close the gag hole cover. For safety, first close the breaker by depressing the manual "CLOSE" button and then depress the manual "TRIP" button. All stored energy is now removed from the breaker.

8. DIMENSIONAL CHECKS

With the breaker closed and the gag plate installed, perform the following dimensional checks:

8.1. PRIMARY CONTACT EROSION

With the closed position, the erosion disk (5, Fig. 7) below the operating rod insulator is aligned with a reference arm (4, Fig. 7) on new interrupters. As contact erosion occurs, the erosion disk will move upward from alignment with that reference arm. This is dimension E in Figure 7, Detail A. When erosion reaches 1/8 inch, the POWER/VAC* interrupters should be replaced. *Do not readjust the alignment of the erosion indicator arm except when installing a new vacuum interrupter.*

8.2. SPRING WIPE

With the breaker closed and the closing spring gagged, measure with a feeler gauge and record the distance between the top of the wipe indicator and the bottom of the erosion disk for each phase (see Figure W, Dimension W). Trip the breaker with the closing spring gag plate still installed and measure and record the distance between the wipe indicator and erosion disk. Subtract the closed position measurement from the open position measurement. The result is the amount of wipe on each individual pole. The wipe, dimension W, is to be greater than 0.075 inch. Adjustment is not required until wipe is 0.075 inch or less. If adjustment is required see WIPE ADJUSTMENT in MECHANICAL ADJUSTMENTS section.

The ML-18 mechanism is furnished with very low gradient wipe springs so that adjustment is not a precision operation and considerable loss of wipe can be tolerated without affecting performance.

8.3. CONTACT GAP

The method of measuring the contact gap is as follows: With the breaker in the open position, the closing springs charged and the closing spring gag plate installed, apply a piece of masking tape to the surface of the operating rod insulator as shown in Figure G. Using a reference block, make a mark on the tape near the top on all three poles. It is also advisable to put a reference mark on the tape to identify to which pole the tape is applied. Remove the closing spring gag plate and close the breaker. Using the same procedure as above, re-mark the tape. This new mark will be near the bottom of the tape. Trip the breaker, remove the tapes and re-apply them to a flat surface.

Measure the distance between the two lines. A caliper will give an accurate reading of the contact gap, Dimension C. The gaps must be between the 0.600 inch maximum and 0.54 inch minimum. It is not necessary that all readings correspond. A properly adjusted breaker will have more gap and wipe on the center pole than on the outside poles.

The following dimensional checks are in the operating mechanism which is accessible from the bottom. To accommodate these checks, the breaker should be turned on its right side resting on two-by-fours. **DO NOT** use the portable breaker lift truck. **CAUTION:** do not allow anything to come in contact with the interlock roller on the right side of the mechanism.

8.4. CLOSE COIL PLUNGER GAP

The close coil plunger gap is shown in Figure C. With the closing spring discharged, operate the plunger to make certain that the plunger moves freely over its full stroke in the coil. To check the closing coil plunger gap the breaker should be open and the closing spring charged and gagged. Dimension C is obtained depressing the close plunger button until resistance is felt. The gap between the plunger button and the coil housing should be between 0.250 and 0.300 of an inch.

8.5. TRIP COIL PLUNGER GAP

The trip coil plunger gap is shown in Figure T. With the breaker in the open position and the closing spring in the charged position, make certain that the trip linkage and trip shaft move freely over the full plunger travel. To check the trip coil plunger gap adjustment, the breaker is to be closed with the closing spring discharged. Dimension T between the plunger button and the coil housing should be between 0.200 and 0.250 inch. This dimension is obtained when the trip plunger button is depressed until resistance is felt. If the breaker is equipped with an optional second trip coil, use same procedure.

8.6. CONTROL SWITCH ADJUSTMENT

The breaker is to be in the open position with the opening and closing springs discharged. This results in the control switch plungers being in the depressed position. The switches to be checked are shown in Figure S. On the LCS and stacked switches (SM/LS & CHG), the plunger rod is to be recessed within the rear of the switch body and this recess is to be 0 to 1/32 inch. This is a visual check. The CL/MS switch with wiring terminals on the side is to be adjusted as described above. For the CL/MS switch with wiring terminals on the rear the plunger is set to a dimension of 0.990 to 1.010" from its mounting bracket. The breaker can now be placed in its normal upright position.

9. ELECTRICAL CHECKS

Electrical checking consists of electrical breaker operation, primary and secondary wiring high-potential testing (if required), primary circuit resistance (if required), POWER/VAC* interrupter high-potential testing, and insulation resistance to ground.

9.1. ELECTRICAL OPERATION

To check the electrical operation, attach a secondary test coupler to the circuit breaker connector. Check the control voltage on the nameplate and close and open the breaker a couple of times.

CAUTION: REPEATED OPERATIONS AT A RATE EXCEEDING TWO PER MINUTE WILL CAUSE CHARGING MOTOR OVERHEATING AND FAILURE.

Leave the circuit breaker in an open and spring discharged condition after checks are complete and refer to metalclad instruction book GEK 39672 before inserting the circuit breaker into a metalclad unit. Reinstall the front cover if it has been removed.

9.2. HIGH-POTENTIAL TEST

If high potential tests to check the integrity of the insulation are required, the A-C high potential test described below is strongly recommended. D-C high potential testing is not recommended except for the VACUUM INTERRUPTER INTEGRITY TEST. The following procedure must be adhered to.

CAUTION:
IF D-C HIGH POTENTIAL TESTING IS REQUIRED, THE D-C HIGH POTENTIAL MACHINE MUST NOT PRODUCE PEAK VOLTAGES EXCEEDING 50 KV.

9.2.1. PRIMARY CIRCUIT

The breaker should be hipotted in the closed breaker mode. An A-C hipot machine capable of producing the test voltages shown below may be used to hipot the breaker phase to phase and phase to ground.

BREAKER VOLTAGE	TEST VOLTAGE
4.16 KV	14 KV
7.2 KV	27 KV
13.8 KV	27 KV

The machine should be connected with its output potential at zero and the voltage increased to the test voltage and that voltage maintained for 60 seconds. The voltage should then be returned to zero and the hipot machine removed from the circuit. Do not exceed the test voltage indicated for the applicable breaker voltage rating.

9.2.2. SECONDARY CIRCUIT

Prior to hipotting the breaker secondary circuit, disconnect the motor leads and thread a wire connecting together all secondary disconnect pins except #24 the ground pin. Connect the hipot machine from this wire to ground. Increase the voltage to 1125 volts (rms) 60 Hz and maintain for 60 seconds. Reduce the voltage to zero and remove the hipot machine from the circuit. Remove the wire connecting the secondary disconnect pins and reconnect the motor leads.

9.3. PRIMARY CIRCUIT RESISTANCE

A resistance check of the primary circuit may be made with the breaker closed. Use a low resistance measuring instrument which measures microhms. The 100 ampere reading should be 25 to 50 microhms for a 2000 amp. breaker and 30 to 60 microhms for a 1200 amp. breaker when connected across the primary bars on the breaker side of the disconnect fingers.

9.4. VACUUM INTERRUPTER INTEGRITY TEST

CAUTION X-RADIATION WILL BE PRODUCED IF AN ABNORMALLY HIGH VOLTAGE IS APPLIED ACROSS A PAIR OF ELECTRODES IN A VACUUM. X-RADIATION WILL INCREASE AS VOLTAGE INCREASES AND/OR AS CONTACT SEPARATION DECREASES. ONLY TEST A CORRECTLY ADJUSTED CIRCUIT BREAKER.

DURING A HIGH POTENTIAL OR A VACUUM INTEGRITY TEST ANY X-RADIATION WHICH MAY BE PRODUCED WILL NOT BE HAZARDOUS AT A DISTANCE SAFE FOR HIGH POTENTIAL TESTING. IF THE TEST IS CONDUCTED AT THE RECOMMENDED VOLTAGE AND WITH THE NORMAL OPEN CIRCUIT BREAKER CONTACT GAP.

DO NOT APPLY VOLTAGE THAT IS HIGHER THAN THE RECOMMENDED VALUE. DO NOT USE CONTACT SEPARATION THAT IS LESS THAN THE RECOMMENDED OPEN-POSITION BREAKER CONTACT GAP.

This test of the vacuum interrupter will determine its internal dielectric condition and vacuum integrity. With the breaker open, individually check each interrupter by connecting the hipot machine "HOT" lead to the upper stud

and the ground lead to the lower stud. If the machine has a center point ground, the connections may be made either way. Apply 36 KV (rms) 60 Hz or 50 KV DC and hold five (5) to ten (10) seconds. If no breakdown occurs, the interrupter is in acceptable condition. If a breakdown occurs, the interrupter should be replaced.

No attempt should be made to try to compare the condition of one vacuum interrupter with another nor to correlate the condition of any interrupter to low values of D-C leakage current. There is no significant correlation.

After the high potential voltage is removed, discharge any electrical charge that may be retained.

CAUTION: MANY D-C HIGH POTENTIAL MACHINES ARE HALFWAVE RECTIFIERS. THIS TYPE OF HI-POT TESTER MUST NOT BE USED TO TEST VACUUM INTERRUPTERS. THE CAPACITANCE OF THE POWER/VAC* BOTTLES IS VERY LOW AND THE LEAKAGE IN THE RECTIFIER AND ITS D-C VOLTAGE MEASURING EQUIPMENT IS SUCH THAT THE PULSE FROM THE HALFWAVE RECTIFIER MAY BE IN THE NEIGHBORHOOD OF 120 kv WHEN THE METER IS ACTUALLY READING 40 kv. IN THIS CASE, SOME PERFECTLY GOOD BOTTLES CAN SHOW A RELATIVELY HIGH LEAKAGE CURRENT SINCE IT IS THE PEAK VOLTAGE OF 120 kv THAT IS PRODUCING ERRONEOUS BOTTLE LEAKAGE CURRENT. IN ADDITION, ABNORMAL X-RADIATION WILL BE PRODUCED.

An acceptable high potential machine is available from: Medium Voltage Switchgear Operations, Burlington, Iowa, Catalog Number 282A2610P001. The following machines are also acceptable.

Hipotronics	Model 860PL
Hipotronics	Model 880PL
Hipotronics	Model 7BT 60A
James G. Biddle	Catalog 222060

9.5. INSULATION TESTS

Since definite limits cannot be given for satisfactory insulation values, a record should be kept of the megohmmeter readings as well as temperature and humidity readings. This record should be used to detect any weakening of the insulation from one check period to the next. Generally readings should equal or exceed 10,000 megohms.

The primary circuit insulation on the breaker may be checked phase to phase and phase to ground using a 2500 V or other suitable megohmmeter.

To measure the breaker secondary circuit insulation resistance, disconnect the motor leads and thread a wire connecting together all secondary disconnect pins except #24 the ground pin. The measurement is made by connecting a 500 V megohmmeter from the wire to ground.

10. INTERLOCK FUNCTIONAL CHECK

Verify that spacing between the lower inside edges of the breaker roller track in the metalclad compartment is 29.807" min. to 29.857" max. Check that the breaker is OPEN and that the closing spring is DISCHARGED. Install the POWER/VAC* circuit breaker into the DISCONNECT/TEST position in the metalclad compartment. CAUTION IF THE COMPARTMENT SECONDARY CONTROL CIRCUITS ARE ENERGIZED, THE FOLLOWING PROCEDURE MUST BE FOLLOWED TO PREVENT ARCING AND BURNING OF THE MOTOR CIRCUIT PINS IN THE SECONDARY CONTACT BLOCKS. Either charge the closing spring MANUALLY, or push in and hold the manual CLOSE button to open the motor circuit, then pull down the handle and extend the breaker secondary control contact block to FIRMLY engage with its mating secondary control contact block in the compartment. Release CLOSE button to activate spring charging motor. If control power is available, close the circuit breaker using the control switch on the compartment door. This operation will check the adjustment of the 52/LCS switch. If the breaker will not close electrically, recheck the 52/LCS adjustment. If control power is not available push the manual close button and recharge the closing spring manually. Spring charging will occur automatically if control power is connected.

With the breaker in the CLOSED condition, attempt to install the racking crank. The racking crank should be blocked by the POSITIVE INTERLOCK. Trip the breaker and install the racking crank and rack the breaker toward the connected position five (5) complete turns. During the five turns, usually between the third and fourth turns, the spring discharge interlock will discharge the closing spring. The contacts of the circuit breaker should remain open. If adjustment is required see INTRODUCTION, SPECIFIC, par. 6. and MECHANICAL ADJUSTMENTS sections 16.7 and 16.8. Rack the breaker into the CONNECTED position and charge the closing spring. If secondary control power is available the closing spring will charge automatically. Assure that the breaker is in the OPEN condition.

Rack the breaker toward the TEST/DISCONNECT position three (3) complete turns. During the three turns, the spring discharge interlock should discharge the closing spring and the breaker contacts should remain OPEN. If adjustment is required see INTRODUCTION, SPECIFIC, par. 6.

11. MAINTENANCE

11.1. GENERAL

POWER/VAC* circuit breakers have been designed to be as maintenance-free as practicable. They include features such as sealed vacuum interrupters and long-life synthetic greases which contribute to many years of trouble-free performance with a minimum amount of maintenance.

POWER/VAC* INTERRUPTER

The POWER/VAC* interrupter used in this breaker is a reliable, clean interrupting element. Since the contacts are contained in a vacuum chamber, they remain clean and require no maintenance at any time. The metallic vapors eroded from the contact surfaces during high current interruption remain in the chamber and are deposited on metal shields thus insuring a high dielectric value of the vacuum and the walls of the interrupter.

TROUBLE REPORTING

Although all reputable manufacturers design their products to perform satisfactorily with a minimum of problems, the IEEE Switchgear Committee, an organization of both users and manufacturers, recognized the need for a common trouble reporting format. A reproducible copy of this form is included inside the rear cover of this book and is recommended for use with any manufacturer's circuit breakers.

The intent is for each maintenance organization to keep specific problem files with this information documented. If the problem is serious or repetitive, a summary should be sent to the appropriate MANUFACTURER for action. The level of detail included on the form is considered very desirable so that the manufacturer's investigator may more thoroughly understand and solve the reported problem.

11.2. SERVICE CONDITIONS

The frequency of required maintenance depends on the severity of the service conditions of the switchgear application. If the service conditions are mild, the interval between maintenance operations may be extended to 10 years or 10,000 no load or normal load switching operations. Mild service conditions are defined as an environment in which the switchgear is protected from the deleterious effects of conditions such as:

Salt spray
Changes in temperature that produce condensation
Conductive and/or abrasive dust
Damaging chemicals and fumes
Vibration or mechanical shock
High relative humidity (90%)
Temperature extremes (below -30° C or above 40° C)

BEFORE ANY MAINTENANCE WORK IS PERFORMED, MAKE CERTAIN THAT ALL CONTROL CIRCUITS ARE DE-ENERGIZED AND THAT THE BREAKER IS REMOVED FROM THE METALCLAD UNIT. DO NOT WORK ON THE BREAKER OR MECHANISM WHILE IT IS IN THE CLOSED POSITION WITHOUT TAKING PRECAUTIONS TO PREVENT ACCIDENTAL TRIPPING. DO NOT WORK ON THE BREAKER WHILE THE CLOSING SPRING IS CHARGED UNLESS IT IS SECURED IN THAT POSITION BY THE CLOSING-SPRING GAG.

11.3. FAULT INTERRUPTIONS

The erosion rate of the primary contacts in the vacuum interrupters is very low for no-load and normal load switching operations. However, fault current interruptions at or near the breaker rating may result in appreciable contact erosion. With frequent fault interruptions it is necessary to perform maintenance based on the number of interruptions. After each 15 fault interruptions the following should be performed:

1. Contact erosion check.
2. Wipe and gap check.
3. Vacuum interrupter integrity test

11.4. CONTACT EROSION

Check in the breaker-closed position per PRIMARY CONTACT EROSION section 8.1. When erosion reaches 1/8 inch, the interrupter should be replaced.

11.5. TRANSFER FINGER WEAR

With the breaker open, examine the moving contact rod projecting below the transfer fingers (10, Fig.8). Wipe off the lubricant in order to see the metal surface condition. The finger locations should present a burnished silver contact without copper appearance at more than one location. If copper is visible at more than one location per pole or the silver plating is torn, the interrupter assembly should be replaced. Relubricate with 0282A2048P009.

11.6. MECHANISM

Check all items covered in INSTALLATION and readjust or tighten hardware as required. Lubricate as recommended under LUBRICATION.

11.7. PRIMARY INSULATION PARTS

Using dry non-linting cloth or industrial-type wipers, clean accessible insulation surfaces on the interrupter supports and operating rod insulators. In service locations where contamination is heavy or external flashovers have occurred during interrupter high-potential testing, remove the interrupter assemblies per the procedure in REPAIR AND REPLACEMENT and clean the inside surfaces of the interrupter supports and the outer insulation surfaces of the POWER/AC* interrupters. Be sure to discharge the interrupter mid-band ring before removing the interrupter assemblies. Removal and reassembly of interrupter assemblies will normally not require adjustment due to the design of the interrupter operating rod insulator connection. They should be returned to the same location from which they were removed.

11.8. LUBRICATION

Proper lubrication is important for maintaining reliable circuit breaker performance. The ML-18 mechanism uses bearings which have a synthetic lining in some locations. These bearings do not require lubrication to maintain low friction, but lubrication does not harm them and oiling lightly is recommended. Sleeve bearings are used in some linkage locations and needle or roller bearings are used for low friction on trip shaft and close shaft.

Bearings are lubricated during factory assembly with grease and oil, but all lubricants have a tendency to deteriorate with age. Providing a fresh lubricant supply at periodic intervals is essential to proper breaker operation, especially where frequent operation may have forced lubricant out of the bearing surfaces. Apply a few drops of light synthetic machine oil such as Mobile 1 at each bearing. Apply a coat of 0282A2048P009 grease on the four corners of the closing spring guide where it enters inside the spring.

Metal-to-metal contact surfaces should be cleaned and lubricated with 0282A2048P009. This grease is available packaged in a pint can to provide cleanliness and prevent oxidation.

Electrical primary contact surfaces also require periodic lubrication to inhibit oxidation and minimize friction. At each inspection and maintenance interval, do the following:

Silvered primary contact surfaces such as the movable contact rod of the interrupter and the primary disconnect fingers should be wiped clean and lightly coated with 0282A2048P009.

Pins of the secondary disconnect coupler should be cleaned and lightly coated with 0282A2048P009.

11.9. RECOMMENDED MAINTENANCE

The following operations should be performed at each maintenance check:

1. Perform a visual inspection of the breaker. Check for loose or damaged parts.
2. Perform slow closing operation described under MECHANICAL CHECKING AND SLOW CLOSING.
3. Check the erosion indicator and the wipe and gap as described under DIMENSIONAL CHECKS.
4. Perform the vacuum interrupter integrity test as described under ELECTRICAL CHECKS.
5. Lubricate the breaker operating mechanism as described under LUBRICATION.
6. Check the electrical operation using the test cabinet (if available) or the test position in the metalclad switchgear.

CAUTION REPEATED OPERATIONS AT A RATE EXCEEDING TWO PER MINUTE WILL CAUSE CHARGING MOTOR OVERHEATING AND SUBSEQUENT MOTOR FAILURE.

7. Examine the movable contact rod of the vacuum interrupter. With the breaker open, wipe the lubricant off the rod and examine the silver surface. The rod should have a burnished appearance without copper appearing through the silver. If copper is visible at more than one location per pole, or if the silver plating is torn, the interrupter assembly should be replaced. Relubricate movable contact rod with 0282A2048P009 grease.

8. If desired, perform the additional electrical tests (Megger, Primary and Secondary High Potential, and Primary Circuit Resistance). See ELECTRICAL CHECKS

12. TIMING

Timing and speed checks are optional and also depend on the level of maintenance performed. Generally these tests are not required for normal maintenance. If a new mechanism has been installed or extensive repair, replacement or major disassembly has been performed, it is recommended that these tests be performed.

To determine contact velocity, a travel recorder and oscillograph are required. Optional travel recorders can be obtained through your local GE Sales Office by ordering part number 0144D123SG001. A typical travel trace and interpretation are shown in Fig. 18.

Timing may be checked by monitoring control circuit voltage and using no more than six volts DC and one ampere through the vacuum interrupter contact to indicate closed or open condition. Typical time ranges vary with coil voltage, but nominal values are:

- Initiation of trip signal to contact parting
32-45 Milliseconds
- 2 Milliseconds maximum pole spread
- Initiation of close signal to contact closing
35-75 Milliseconds
- 2 Milliseconds maximum pole spread.

Trip-free operation may be checked by applying a simultaneous close and trip signal, and a minimum reclose operation may be checked by tripping a charged breaker open while maintaining a close signal.

Instantaneous reclose time* 85-150 Milliseconds.

*Time from application of trip signal until breaker contacts reclose.

13. OPENING AND CLOSING SPEED

The opening speed is modified by moving the speed adjusting nuts on the opening spring assemblies. A change in the opening speed affects the closing speed. Reference Figure 16.

The operating speeds are as follows:

Operation	Feet Per Second
Open	5.0 nominal, 4.5 minimum
Close	3.5 nominal, 4.0 maximum

14. REPAIR AND REPLACEMENT

14.1. GENERAL

The following information covers in detail the proper method of removing various parts of the breaker in order to make any necessary repairs. This section includes only those repairs that can be made at the installation site on parts of the breaker that are most subject to damage.

Important: Upon completion of any kind of repair work, all interrupter and mechanism adjustments must be checked.

Refer as needed to sections on mechanical and electrical adjustments.

14.2. REPLACEMENT OF INTERRUPTER ASSEMBLIES

Interrupters are supplied in complete interrupter assemblies which include the vacuum interrupter mounted in the interrupter support, the primary studs and disconnect fingers.

CAUTION: DO NOT ATTEMPT TO REMOVE OR RE-INSERT THE VACUUM INTERRUPTER IN THE INTERRUPTER SUPPORT ASSEMBLY. SPECIAL TOOLS AVAILABLE ONLY AT THE FACTORY ARE REQUIRED.

1. Close the breaker and remove the coupling clamp, (8, Fig. 8). Hold hex projection (6, Fig. 8) at the bottom of the operating rod insulator with a one inch wrench and loosen the adjacent lock nut with a 3/4 inch wrench. Screw down the lock nut and the operating rod insulator until clear of interrupter rod. Remove the four bolts holding the pole assembly to the mechanism and remove the old pole assembly.

2. Set the new pole assembly in place and install the four mounting bolts. Set the pole assembly so that the distance between the primary studs and the studs on the adjacent pole are ten (10) inches center line to center line.

3. Screw the operating rod insulator up to mate with the base of the interrupter rod. Install coupling clamp. Tighten coupling clamp cap screws, then loosen them 1-2 turns.

a. With continuity indicator across the contacts, back off the operating rod until the contacts separate, (continuity indicator off).

b. Advance operating rod until contacts touch, (continuity indicator on).

c. Advance operating rod two and one-half (2 1/2) additional turns.

d. Tighten lock nut to 40-50 foot pounds and the coupling clamp cap screws to 8-10 foot pounds.

e. Check wipe - must be .155-.180 inch (set all three phases before measuring). It is not necessary that all three poles have the same wipe measurement as long as all three poles fall within the specified limits.

f. Check gap - must be .545-.600 inch. Adjust if needed per CONTACT GAP ADJUSTMENT in MECHANICAL ADJUSTMENT section.

4. If new interrupter assembly is installed, check and adjust the erosion indicator (4, Fig. 7) by bending the indicator to line up with erosion disk.

5. Perform the VACUUM INTERRUPTER INTEGRITY TEST as described in ELECTRICAL CHECKS section.

CAUTION

PRIMARY DISCONNECT WIPE CAN ONLY BE CHECKED WHEN THE SWITCH GEAR IS DEENERGIZED.

14.3. PRIMARY DISCONNECT FINGERS

The primary disconnect finger assemblies can be removed by removing two roll pins which hold them in place on the primary studs. Finger contact surfaces should be coated with 0282A2048P009 lubricant.

14.4. MECHANISM

Pin Retaining Rings - These rings are widely used in the ML-18 mechanism to retain pins. They can be installed and removed with a pair of standard pliers. Reuse is not recommended. To remove, slowly squeeze the removal ears while pulling. To install, position in the pin groove and squeeze the installation ears closed leaving no more than 1/16 inch gap between ears. Retaining rings can be obtained from your local GE Sales office by ordering part number 0282A2015G001.

14.5. CONTROL SWITCHES

Control switches may be removed from their mounting brackets by disconnecting the wires and removing the mounting hardware. When replacing the switches, check that the correct type, normally open or normally closed, is used. Reinstall, wire and adjust per DIMENSIONAL CHECKS CONTROL SWITCH ADJUSTMENT.

14.6. TRIP COIL REPLACEMENT

TOOLS REQUIRED

- 5/16" Allen wrench
- Needle nose pliers
- 7/16" Socket wrench
- 7/16" Box/combo wrench
- 1/4" Square drive ratchet
- 1/4" Square 3" extension
- Loctite #271 or equivalent

Perform the operation in the following sequence:

1. Charge closing spring and install gag plate.
2. Depress the close and then the trip buttons.

3. Pump the manual close handle 3 - 4 times.
4. With the 5/16" Allen wrench, remove the pivot bolt (10, Fig. 15) on the closing spring (1, Fig. 15).
5. Remove the closing spring.
6. Disconnect the trip linkage tension spring.
7. Loosen the interlock bracket (11, Fig. 15).
8. Remove the 4 bolts from the coil bracket leaving the two bolts nearest the front of the breaker in place in the mechanism frame.
9. Cut coil leads and remove the coil and armature.

To install the new coil, reverse the above procedure and connect leads with insulated butt connectors. See TRIP COIL PLUNGER in MECHANICAL ADJUSTMENTS section for setting the stroke of the armature. Apply Loctite to the threads of the pivot bolt (10, Fig. 15) when it is replaced. Charge the breaker and electrically close and trip it to make certain it has been reassembled correctly.

14.7. CLOSING COIL REPLACEMENT

Disconnect the close linkage tension spring then remove the retaining ring from the close linkage pivot pin (17, Fig. 15) and disconnect the linkage. Remove the closing coil and housing (6, Fig. 15). Cut the leads to the closing coil and remove the coil. Reassemble the coil and housing with armature and butt-splice the new coil into the wiring harness. Reassemble linkage and spring. Readjust the closing coil armature travel in accordance with instructions in MECHANICAL ADJUSTMENTS section under CLOSE COIL PLUNGER.

14.8. AUXILIARY SWITCH REPLACEMENT

With the breaker open and the closing spring discharged, remove retaining clip from auxiliary switch shaft, or loosen clamping bolt in operating link. Observe and make note of the direction of the index mark on the end of the shaft. Remove mounting hardware securing auxiliary switch to mechanism plate. Slide auxiliary switch and shaft out of operating link. Before removing any wires from switch terminals, make sure they are properly tagged with switch terminal numbers to assure proper placement on new switch. Remove wires.

To install new switch, attach leads then install switch, or install switch then attach leads depending upon type of switch and its terminal accessibility. Install switch shaft in operating link with index mark aligned as noted above. Reverse above procedure to complete installation.

14.9. MOTOR REPLACEMENT

With the breaker open and the closing spring discharged, remove auxiliary switch as described above but do not disconnect leads. Move switch toward side of mechanism far enough to clear motor and tie there temporarily. Disconnect motor leads and remove the "C" ring retaining the charge linkage arms to the motor output shaft. Remove the long bolt and spacer securing the motor to the mechanism mid-plate. Remove the two socket head cap screws securing the motor to the mechanism top plate. Disengage the motor output shaft from the charge linkage arms and withdraw motor.

To install the new motor, reverse the above procedure.

14.10. "Y" RELAY REPLACEMENT

Before removing the "Y" relay, make sure all leads are marked with terminal locations. Next, disconnect all leads and remove the two fasteners securing the "Y" relay's shock absorbing mounting bracket to the mechanism rear plate. Withdraw relay and bracket. Remove fasteners securing relay to mounting bracket.

Reverse above procedure to install new relay.

15. RENEWAL PARTS

It is recommended that sufficient renewal parts be carried in stock to enable the prompt replacement of any worn, broken or damaged parts. A stock of such parts minimizes service interruptions caused by breakdowns, and saves time and expense. When continuous operation is a primary consideration, more renewal parts should be carried, the amount depending upon the severity of the service and the time required to secure replacements.

Renewal parts which are furnished may not be identical to the original parts, but they will be interchangeable.

A separate Renewal Parts Bulletin is available from your local GE Sales office by asking for GEK 90218.

15.1. ORDERING INSTRUCTIONS

1. Always specify the complete nameplate data of both the breaker and the mechanism.
2. Specify the quantity, catalog number (if listed), reference number (if listed), and description of each part ordered, and the parts bulletin number.
3. Standard hardware, such as screws, bolts, nuts, washers, etc. is not listed in this bulletin. Such items should be purchased locally.
4. For prices or information on parts not listed in the Renewal Parts Bulletin, refer to the nearest GE office.

16. MECHANICAL ADJUSTMENTS

16.1. GENERAL

The ML-18 Mechanism has been designed for extended intervals between maintenance. In most cases only the wipe and gap adjustments will require re-setting throughout the life of the circuit breaker.

16.2. WIPE ADJUSTMENT

Wipe is the additional compression of a preloaded spring, used to apply force to the vacuum interrupter contacts and to provide opening kick-off force.

An indicator is provided on the wipe spring assembly with graduations given in 0.050 inch on which the wipe is indicated directly. See Figure 8.

Improvement in the accuracy of the wipe measurement may be obtained by using a feeler gauge between the top of the wipe indicator and the erosion disk. The difference in readings recorded on each pole with the breaker closed and open will be the contact wipe. After adjustment the wipe should be 0.155-0.180 inch.

To adjust the primary contact wipe, close the breaker and proceed as follows:

1. Loosen but do not remove the two screws (9, Fig. 8) holding the interrupter clamp.
2. Check that the interrupter clamp is loose. A light pry at the clamp half-junction may be required to loosen the wedging action of the clamp.
3. Hold the hexagon projection (6, Fig. 8) at the bottom of the operating rod insulator (1 inch wrench) and loosen the adjacent locknut (3/4 inch wrench). Refer to (4, Fig. 8). Adjust by rotating the operating rod insulator. The thread is 1/2-13 and each turn will give about 0.078 inch change in primary wipe. Screw the operating rod insulator toward the interrupter to increase wipe.
4. After setting the contact wipes on each phase, torque the operating rod locknut (9, Fig. 8) to 40-50 foot pounds while preventing the operating rod insulator (7) from turning. Tighten the clamp screws (6) to 8-10 foot pounds and trip the breaker open. This procedure prevents accidental twisting of the interrupter's operating rod by loading the contacts with the wipe springs and forcing relative rotation to occur at the clamp interface.

After adjustment, remeasure the wipe dimensions. If the wipe settings are within the required limits, there is an adequate contact closing relationship between the poles.

16.3. CONTACT GAP ADJUSTMENT

The gap adjustment refers to the separation, or gap, between the primary contacts within the vacuum interrupter. Before attempting to measure or set the gap adjustment, verify that the wipe settings are within acceptable limits. Any change of the wipe settings will affect the gap settings.

1. With the breaker in the open position and the closing spring discharged, locate the gap adjusting nuts on the opening spring rods connected to the outer phase bell cranks (Fig.16). Loosen the jam nut on both rods. Back off the adjusting bolt on the center phase VI stop (Fig.16).
2. Advance or retard the adjusting nuts depending on which way you want to change the gap. Move both nuts the same amount.
3. Lock the jam nuts after setting the adjusting nuts. Operate the breaker a few times and remeasure the gap following the procedure described in DIMENSIONAL CHECKS, item 3.
4. Readjust the center phase VI stop (Figure 16). Set adjusting screw for no clearance between stop and wipe spring rod striker with the breaker open.

16.4. TRIP COIL PLUNGER

To adjust trip coil plunger gap (Figure T), lift locktab away from adjusting nut. Turn adjusting nut until trip pin makes contact with trip arm while maintaining dim. T. Bend locktab to secure adjusting nut.

Reference DIMENSIONAL CHECKS for breaker position and spring status.

16.5. CLOSE COIL PLUNGER

To adjust close coil plunger gap (Figure C), lift locktab away from adjusting nut. Turn adjusting nut until close latch actuator makes contact with close latch while maintaining dim. C. Bend locktab to secure adjusting nut.

Reference DIMENSIONAL CHECKS for breaker position and spring status.

16.6. CLOSE LATCH STOP BOLT

SHOULD NOT BE ROUTINELY ADJUSTED - WILL AFFECT SPRING DISCHARGE INTERLOCK SETTING.

This adjustment is shown in Figure L and is obtained with the breaker in the open position and the closing spring charged. The setting is checked by advancing the adjusting screw until the breaker closes. Back adjusting screw off 1/2 turn (3 flats). Check function by opening the breaker and charging the closing spring. If the latch slips off the roller and the breaker closes, back the adjusting screw off 1 additional flat. Check function.

16.7. SPRING DISCHARGE INTERLOCK

THIS INTERLOCK IS FACTORY SET AND SHOULD NOT BE ROUTINELY ADJUSTED IN THE FIELD. The adjustment for this interlock is as follows. (See Fig. 17).

The breaker should be open with the closing spring charged.

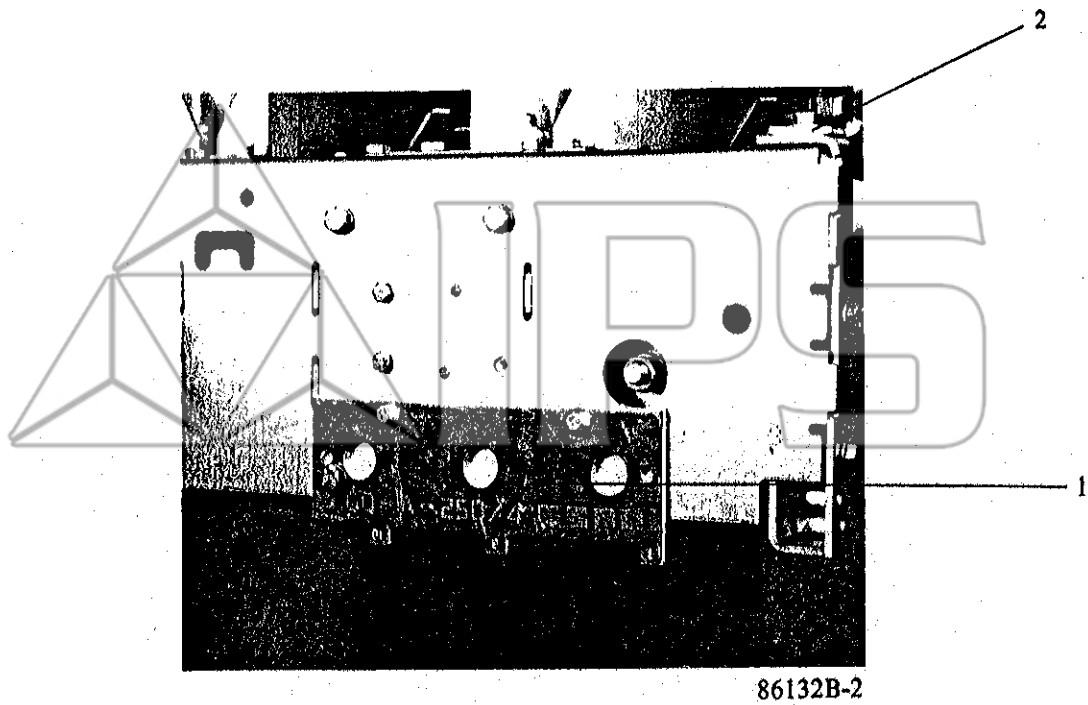
1. Back off 1/4 inch adjusting screw.
2. While holding roller at 0.995 inch dim., advance adjusting screw to just touch interlock lever.
3. Check that spring discharges with roller at 0.561 inch min. dim.
4. Close latch must reset as indicated.

16.8. NEGATIVE INTERLOCK

THIS INTERLOCK IS FACTORY-SET AND SHOULD NOT BE ROUTINELY ADJUSTED IN THE FIELD. The negative interlock is adjusted with the breaker closed and the closing spring discharged. (See Fig. 20).

1. Hold roller at 0.670 inch from mechanism side plate. Adjust linkage so the striker just makes contact with trip linkage.
2. Lock in place with 1/4 inch hardware and rivet.
3. Check that breaker trips with roller at 0.561 inch min. dim.
4. Check that linkage moves freely.

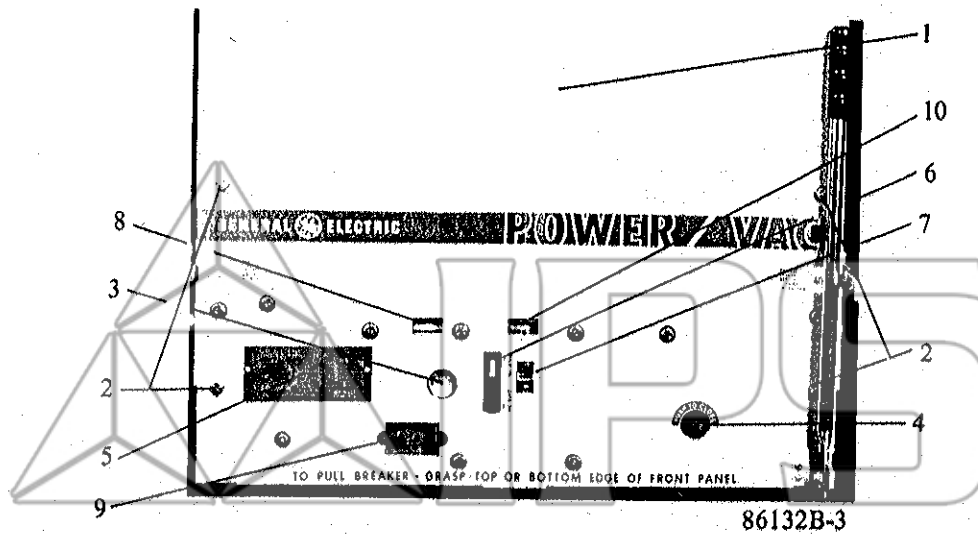
FIGURE 1 RATING INTERFERENCE PLATE



1. Rating Interference Plate
2. Lifting Locations (3/4" dia. hole at all four corners)

store.ips.us

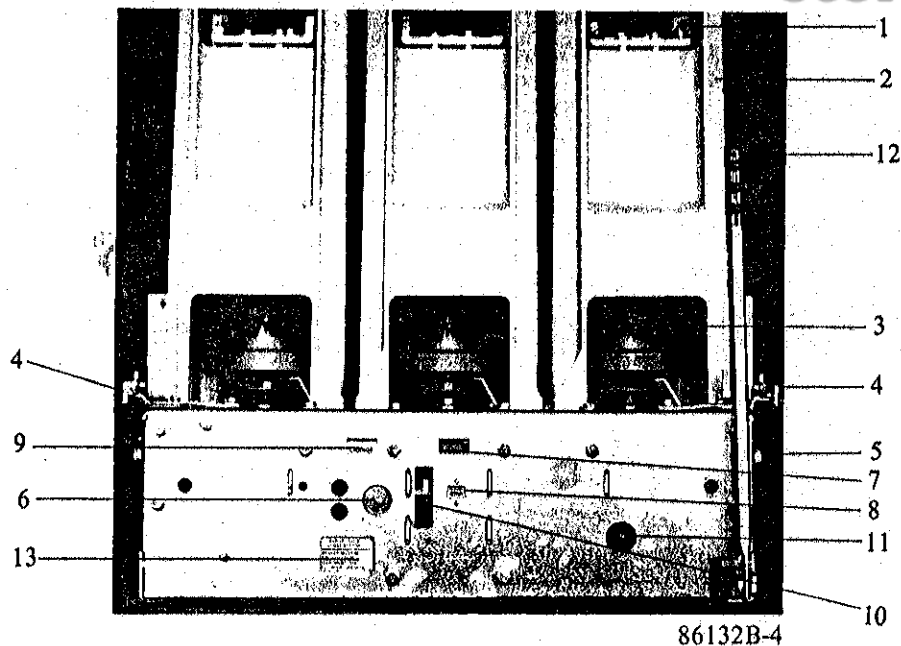
FIGURE 2 FRONT VIEW OF POWER/VAC* BREAKER
WITH FRONT COVER



- 1. Front cover
- 2. Cover mounting bolts
- 3. Manual trip button
- 4. Manual close button
- 5. Nameplate

- 6. Manual charge lever
- 7. Counter
- 8. Spring charge indication
- 9. Closing spring gag access
- 10. Open/Close indicator

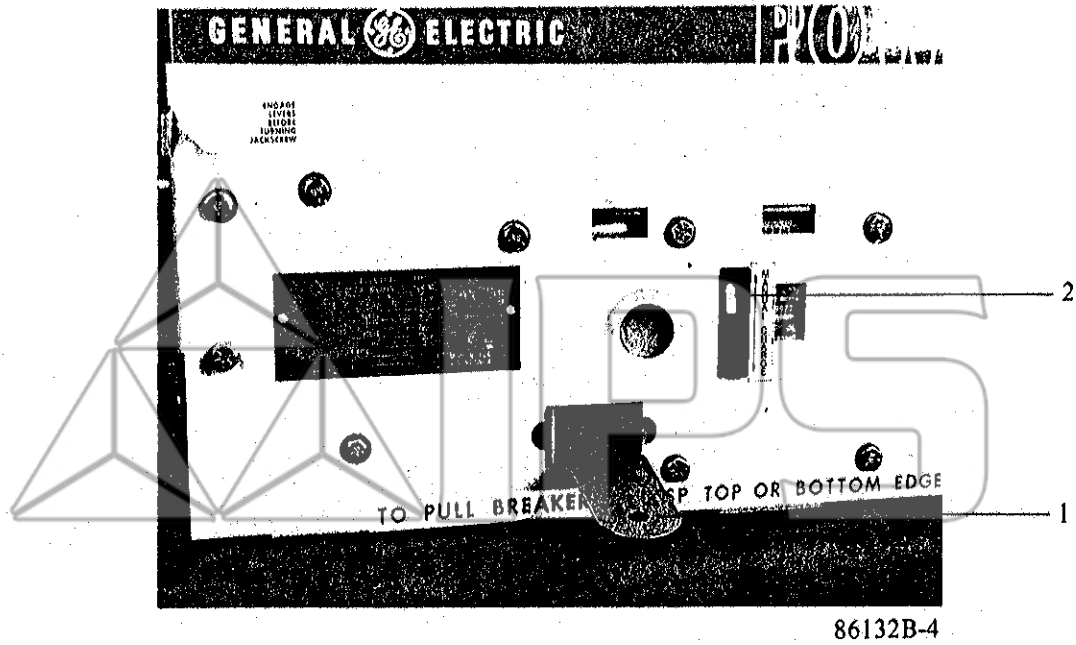
FIGURE 3 FRONT VIEW OF POWER/VAC* BREAKER
WITHOUT FRONT COVER



- 1. Upper interrupter connection
- 2. Interrupter support
- 3. Operating rod
- 4. Racking arm
- 5. Compartment track rollers
- 6. Manual trip button
- 7. Open/Close indicator

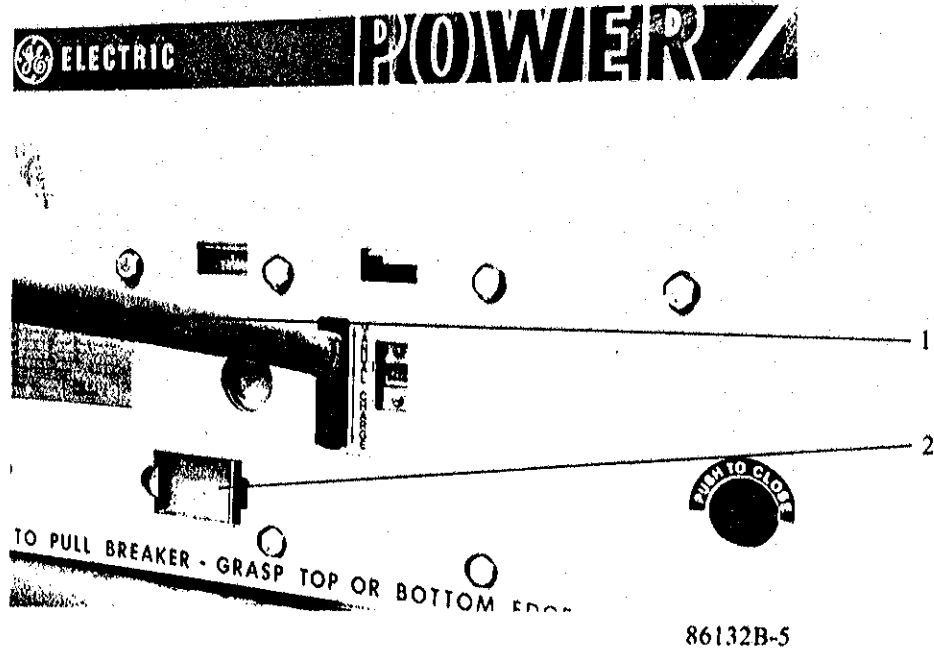
- 8. Counter
- 9. Spring charge indicator
- 10. Manual charge lever
- 11. Manual close button
- 12. Handle to connect secondary disconnects in test position
- 13. Closing spring gag access

FIGURE 4 MANUAL CHARGING



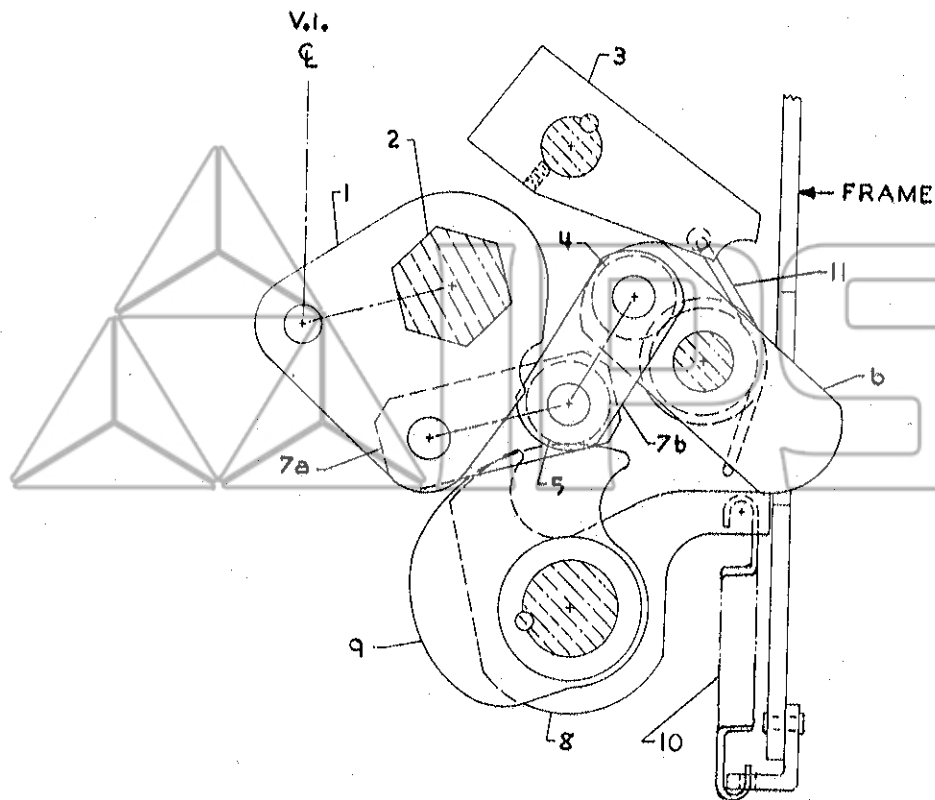
1. Closing spring gag plate
2. Manual charging lever

FIGURE 5 MANUAL CHARGING



1. Manual charging handle
2. Closing spring gag hole
(shown in closed position)

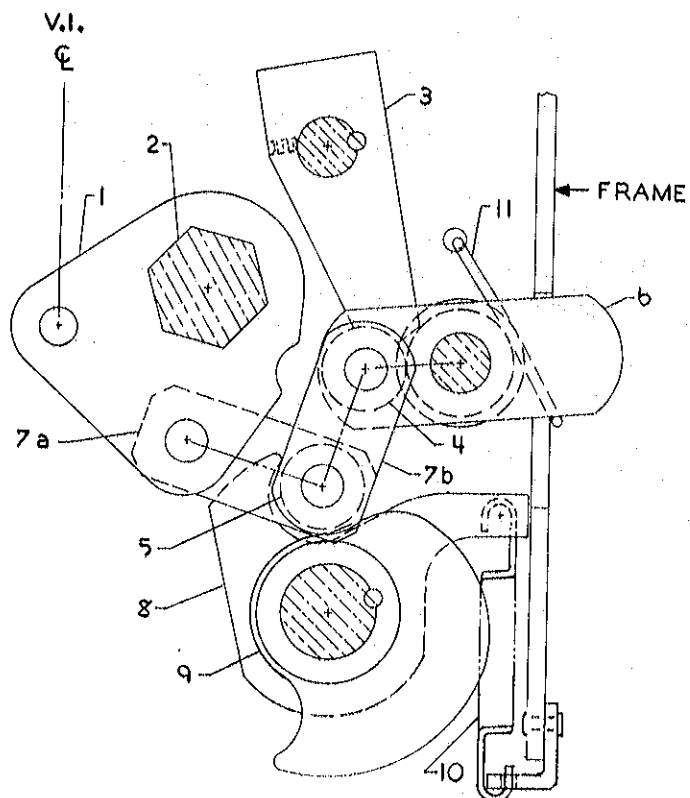
FIGURE 6 TOGGLE LINKAGE POSITIONS OF THE ML-18 MECHANISM
(Viewed from right side) Contd. on next page



(A) BREAKER OPEN — SPRING DISCHARGED

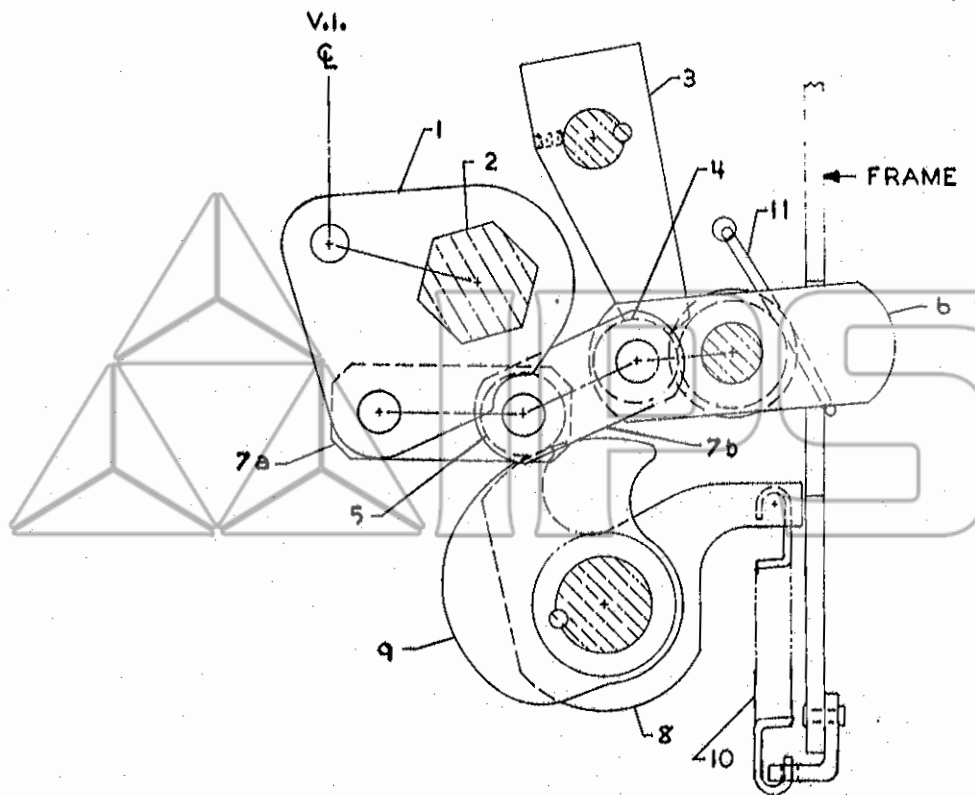
- 1 OUTPUT CRANK
- 2 JACKSHAFT
- 3 TRIP LATCH
- 4 TRIP ROLLER
- 5 CLOSING ROLLER
- 6 TRIP LINK
- 7a CLOSING TOGGLE
- 7b CLOSING TOGGLE
- 8 PROP
- 9 CLOSING CAM
- 10 PROP SPRING
- 11 LINKAGE RETURN SPRING

NOTE: SHADING INDICATES
FIXED PIVOTS

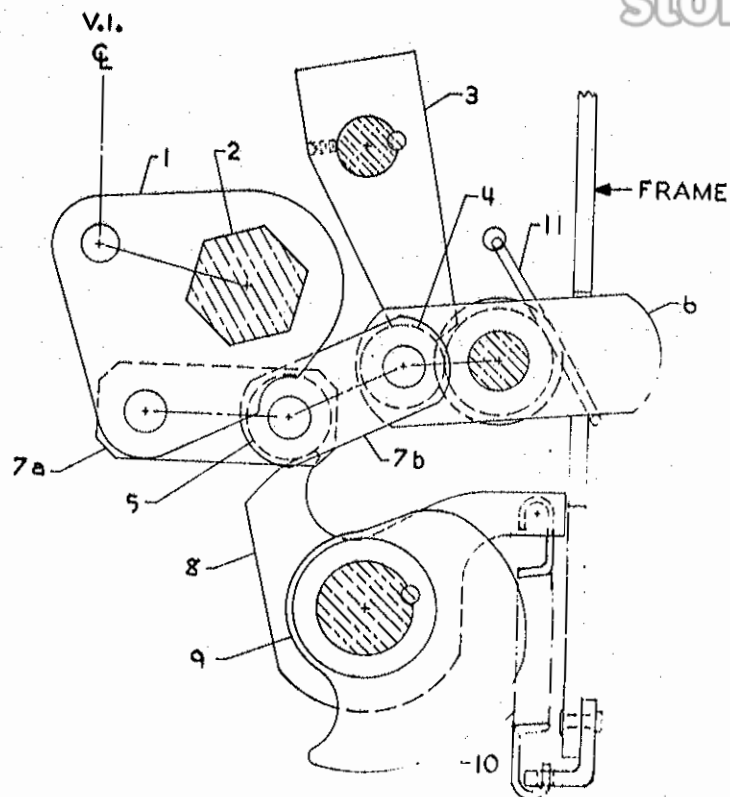


(B) BREAKER OPEN — SPRING CHARGED

FIGURE 6 CONTD.



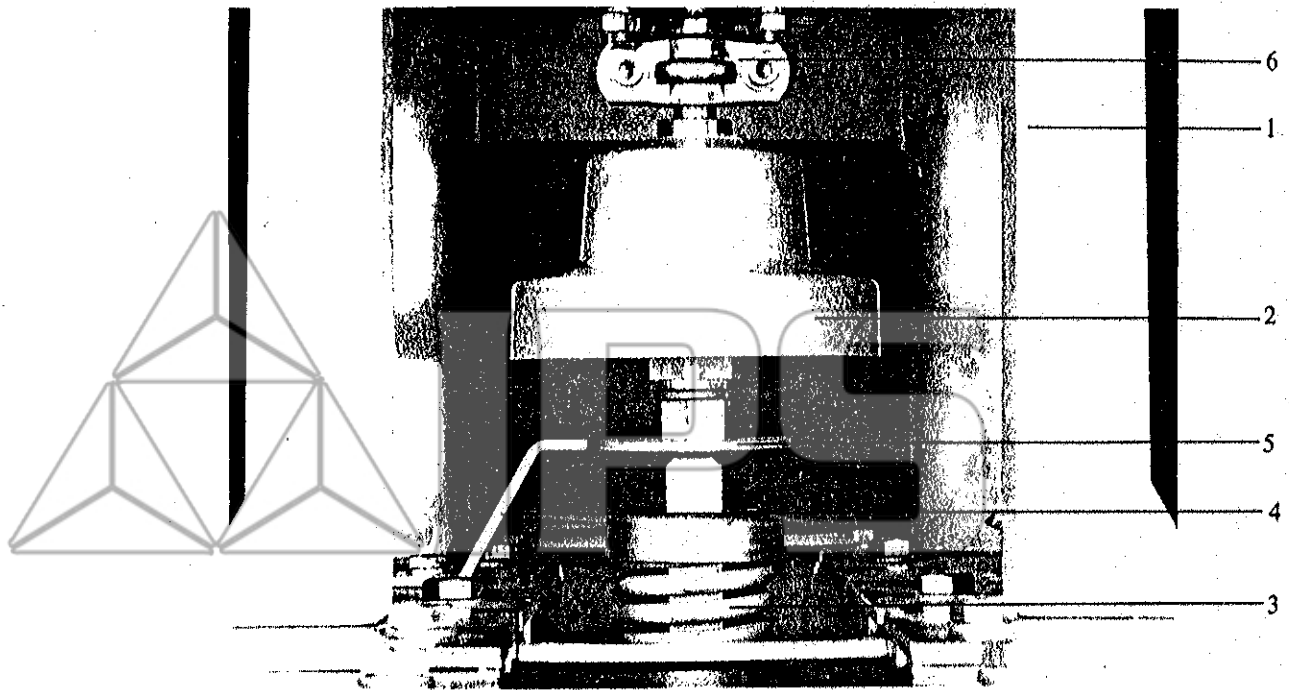
(C) BREAKER CLOSED — SPRING DISCHARGED



(D) BREAKER CLOSED — SPRING CHARGED

store.ips.us

FIGURE 7 EROSION INDICATOR



86132B-6

- 1. Interrupter support
- 2. Operating rod insulator
- 3. Wipe spring
- 4. Erosion indicator

- 5. Erosion disk
(Shown in closed position
with no contact erosion)
- 6. Coupling clamp

store.ips.us

DETAIL A

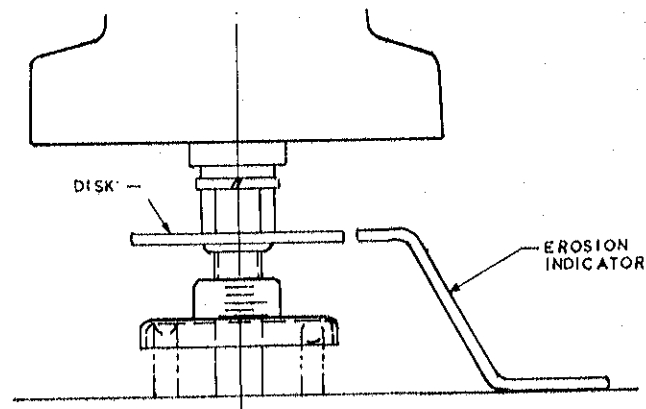
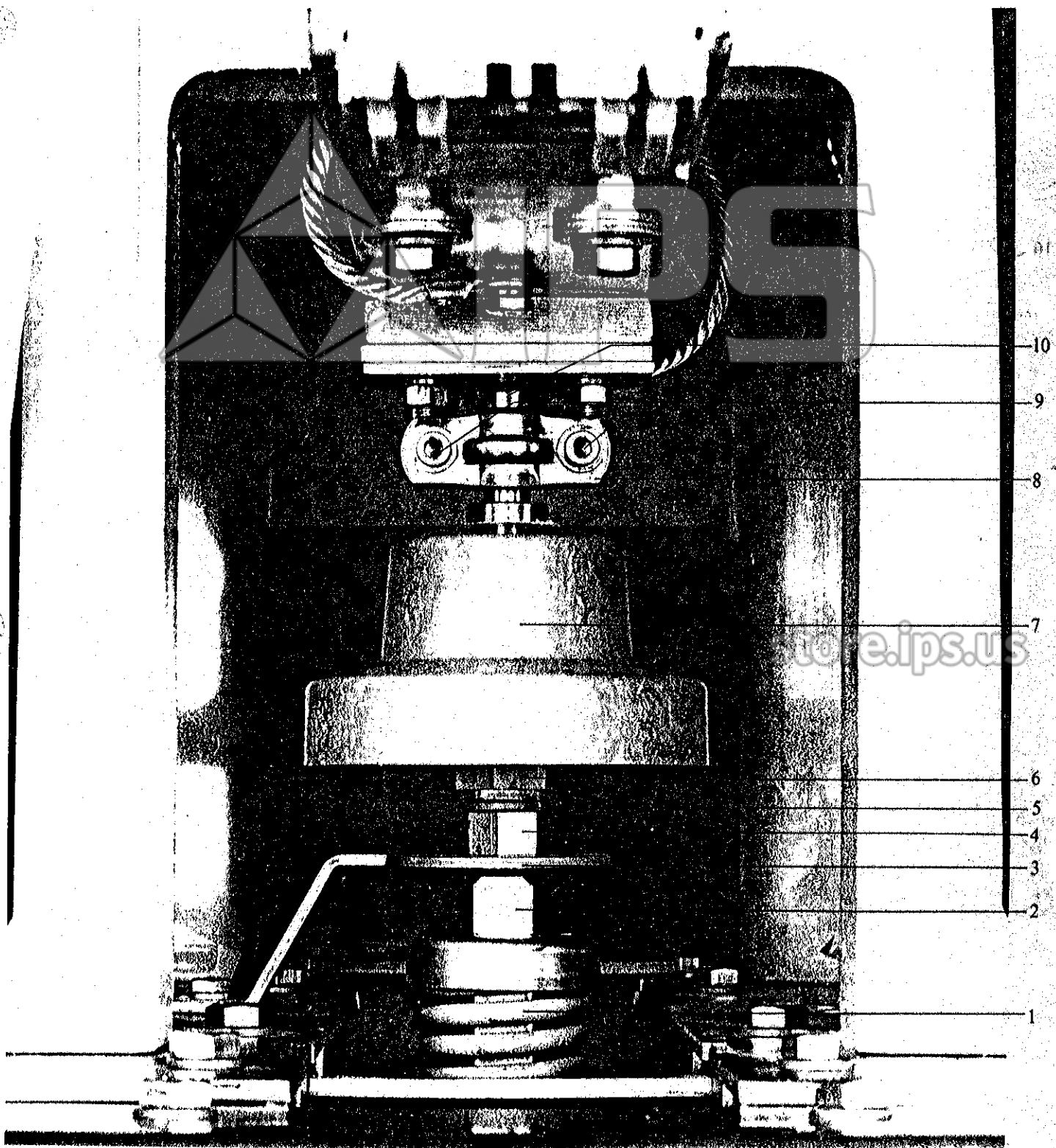


FIGURE 8 OPERATING ROD ASSEMBLY

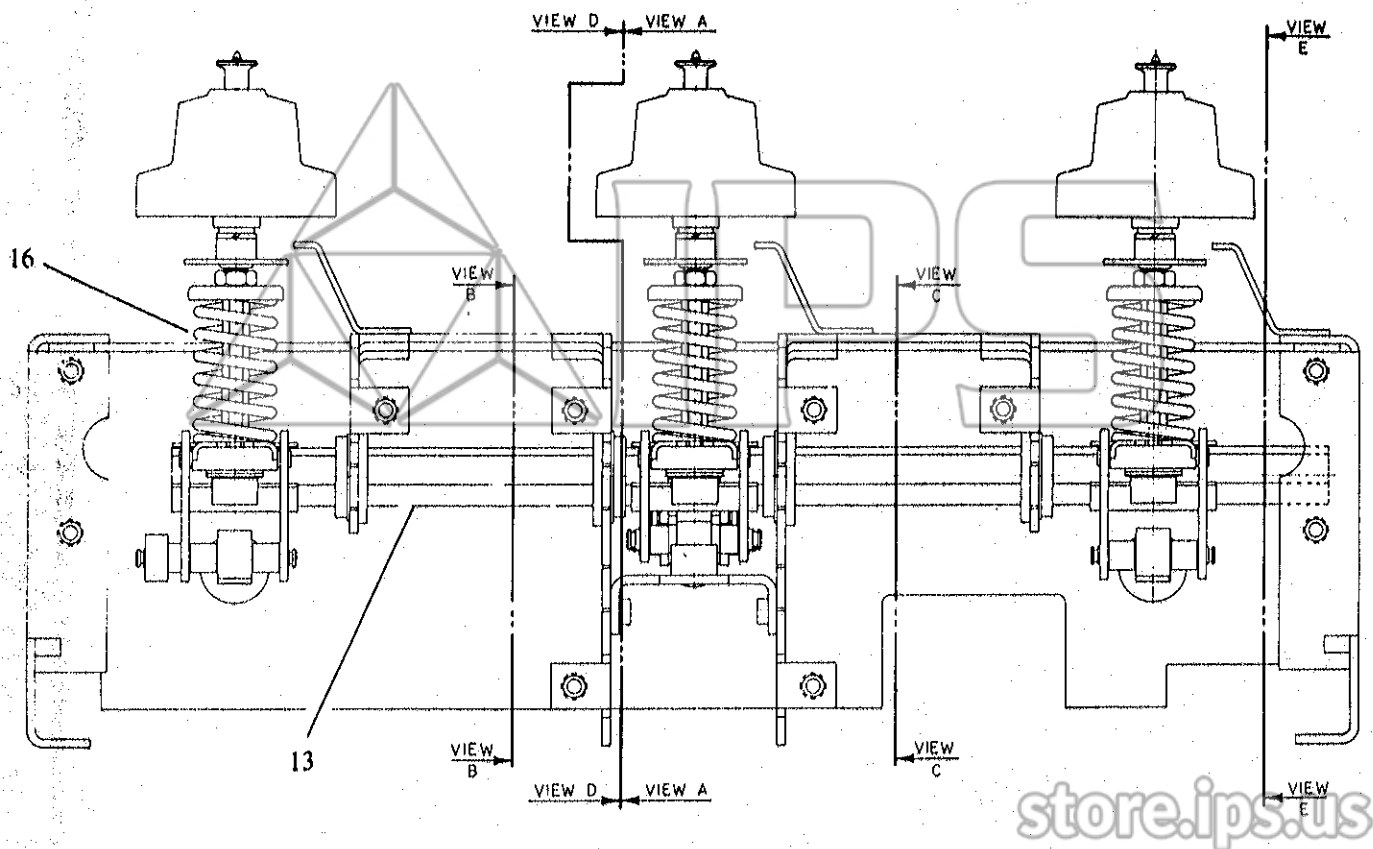


1. Wipe spring
2. Wipe indicator
3. Erosion disk
4. Lock nut
5. Lock washer

6. Hexagon projection
7. Operating rod insulator
8. Coupling clamp
9. Clamp screws
10. Interrupter movable contact rod

86132B-6

FIGURE 9 SCHEMATIC OF ML-18 MECHANISM



1. Close spring
2. Cam shaft
3. Manual charge
4. Charging arms
5. Ratchet wheel
6. Driving pawl
7. One-way clutch
8. Close latch
9. Close cam
10. Close roller
11. Prop

12. Output crank
13. Cross shaft
14. Bell cranks
15. Opening springs
16. Wipe springs
17. Auxiliary switch
18. Trip solenoid
19. Trip latch
20. Over-travel stop
21. Latch check switch
22. Gear motor
23. Manual trip button

(Contd. on next page)

FIGURE 9 Contd.

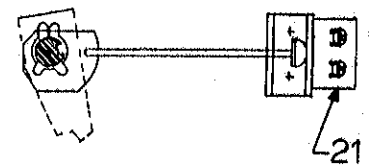
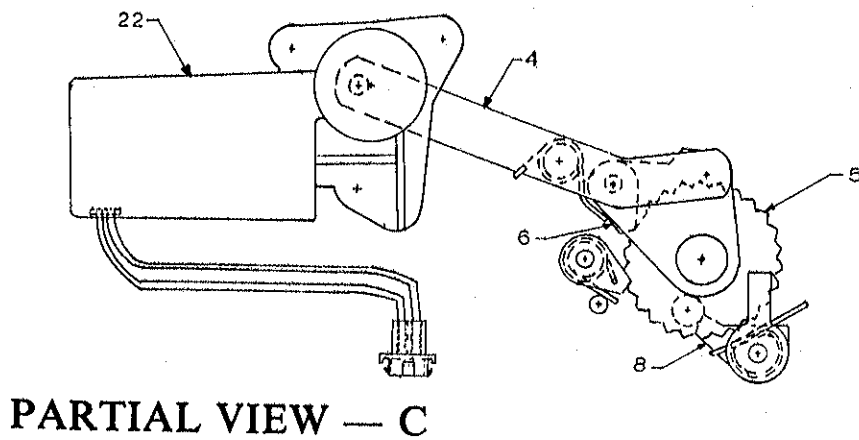
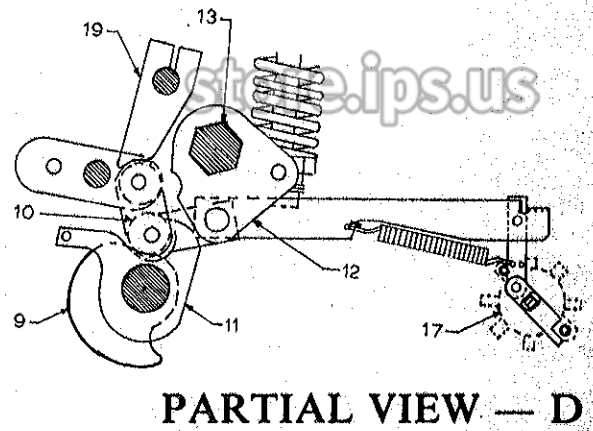
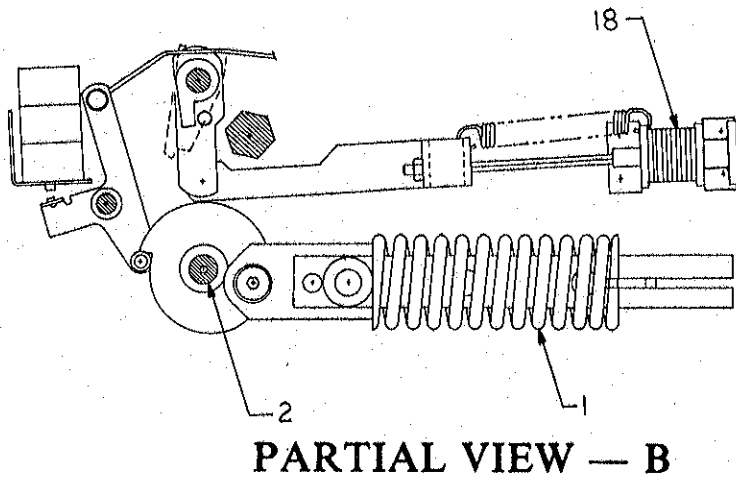
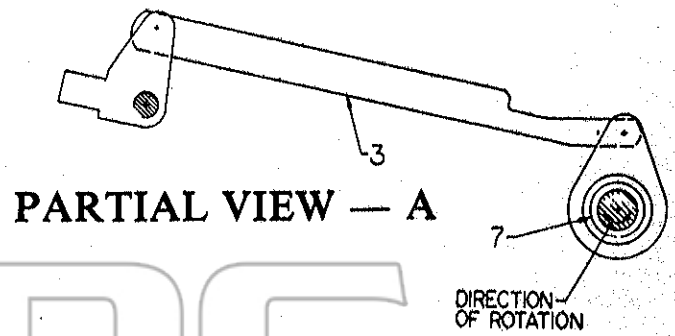
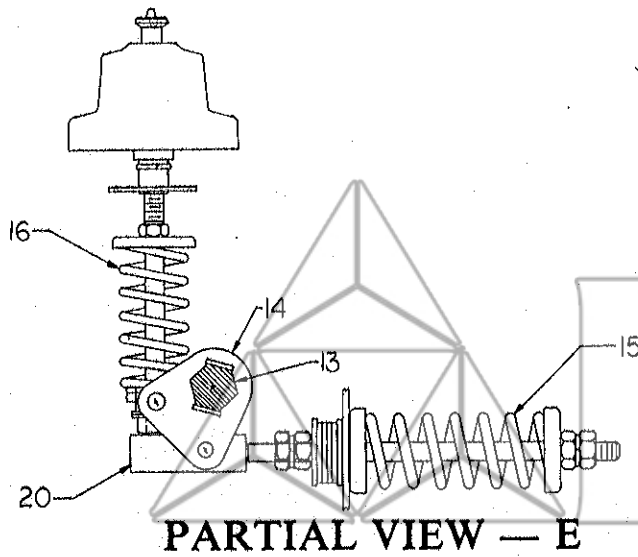


FIGURE 10 TYPICAL WIRING DIAGRAM FOR ML-18 MECHANISM

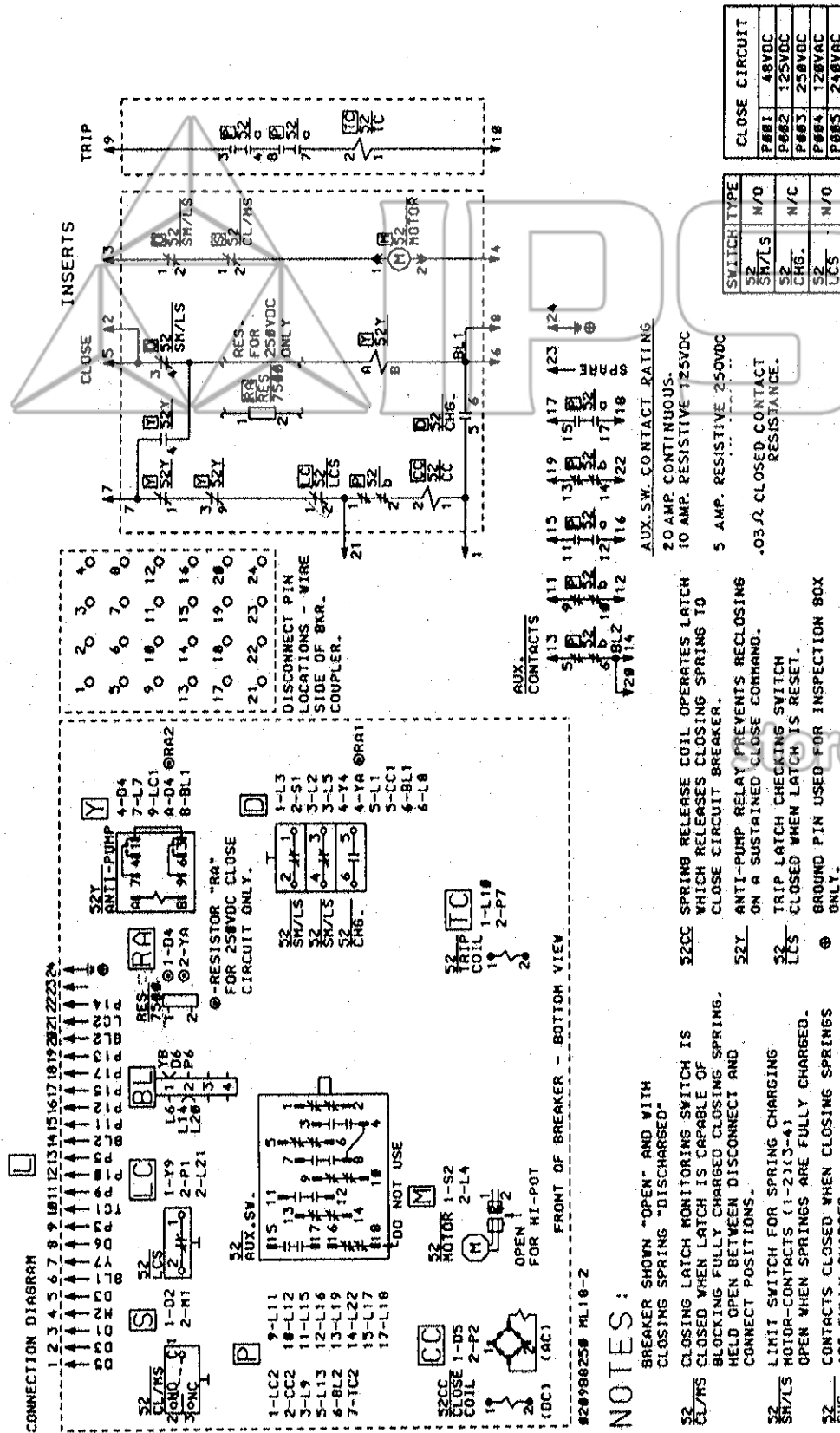
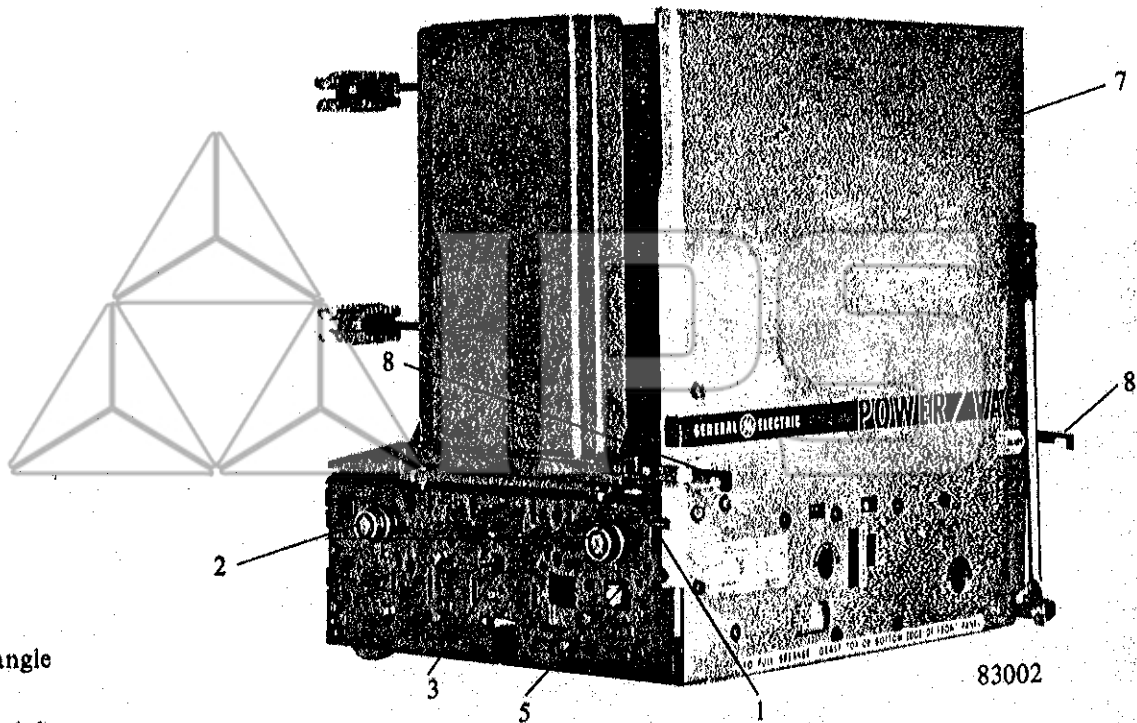


FIG. 10 TYPICAL WIRING DIAGRAM P/V ML-18 MECHANISM

FIGURE 11 POWER/VAC* BREAKER LEFT-FRONT VIEW



1. Gag interlock angle
2. Track rollers
3. Positive interlock bar
4. Closing spring discharge roller
5. Negative interlock roller
6. Rating interference plate
7. Front cover
8. Racking engagement lever
9. Secondary coupler

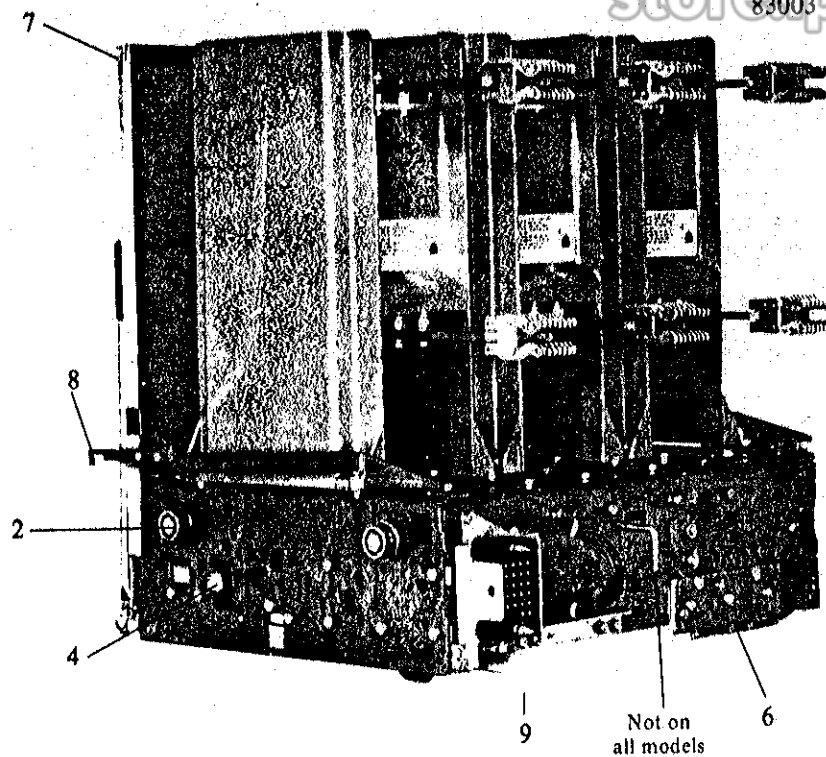
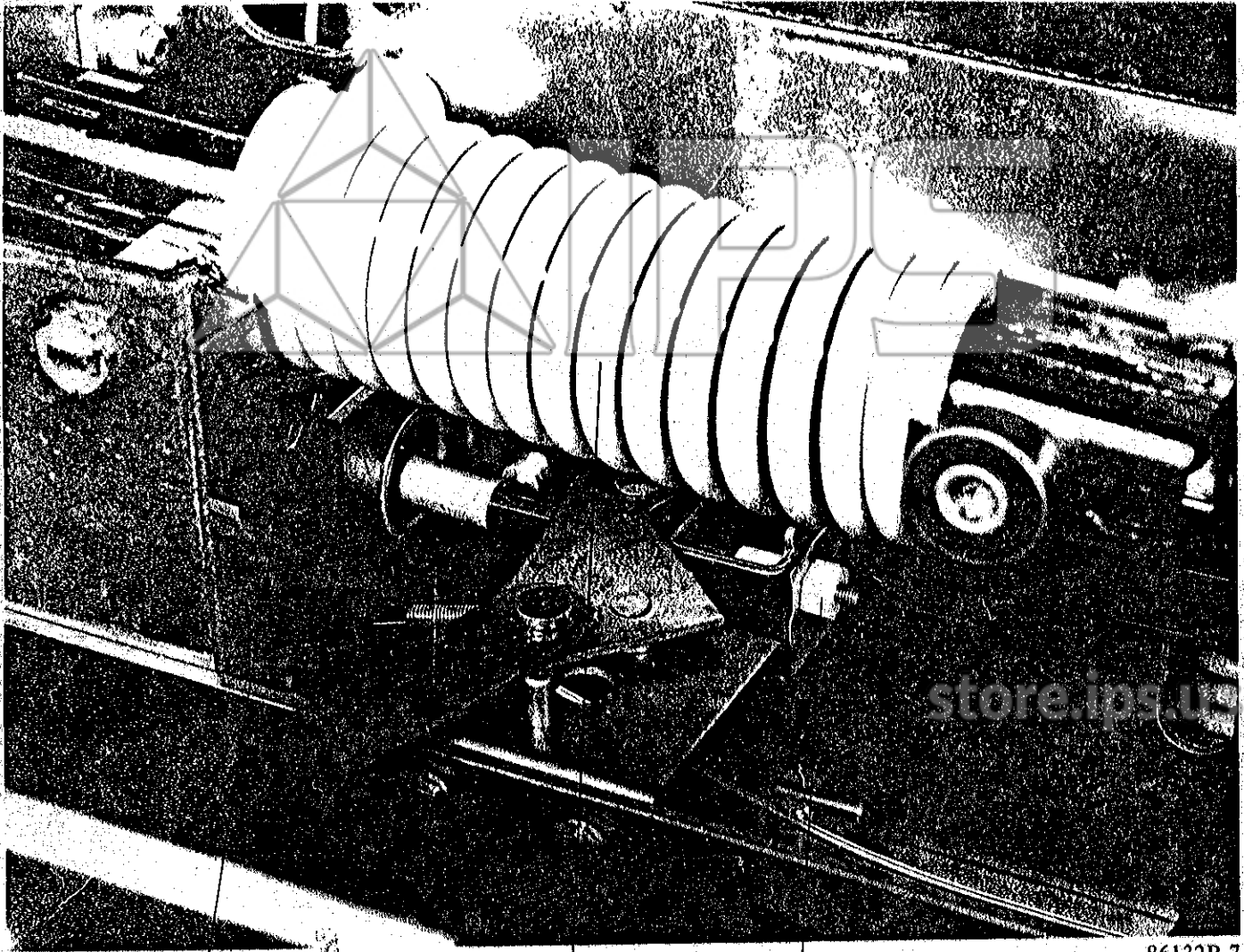


FIGURE 12 POWER/VAC* BREAKER RIGHT-REAR VIEW

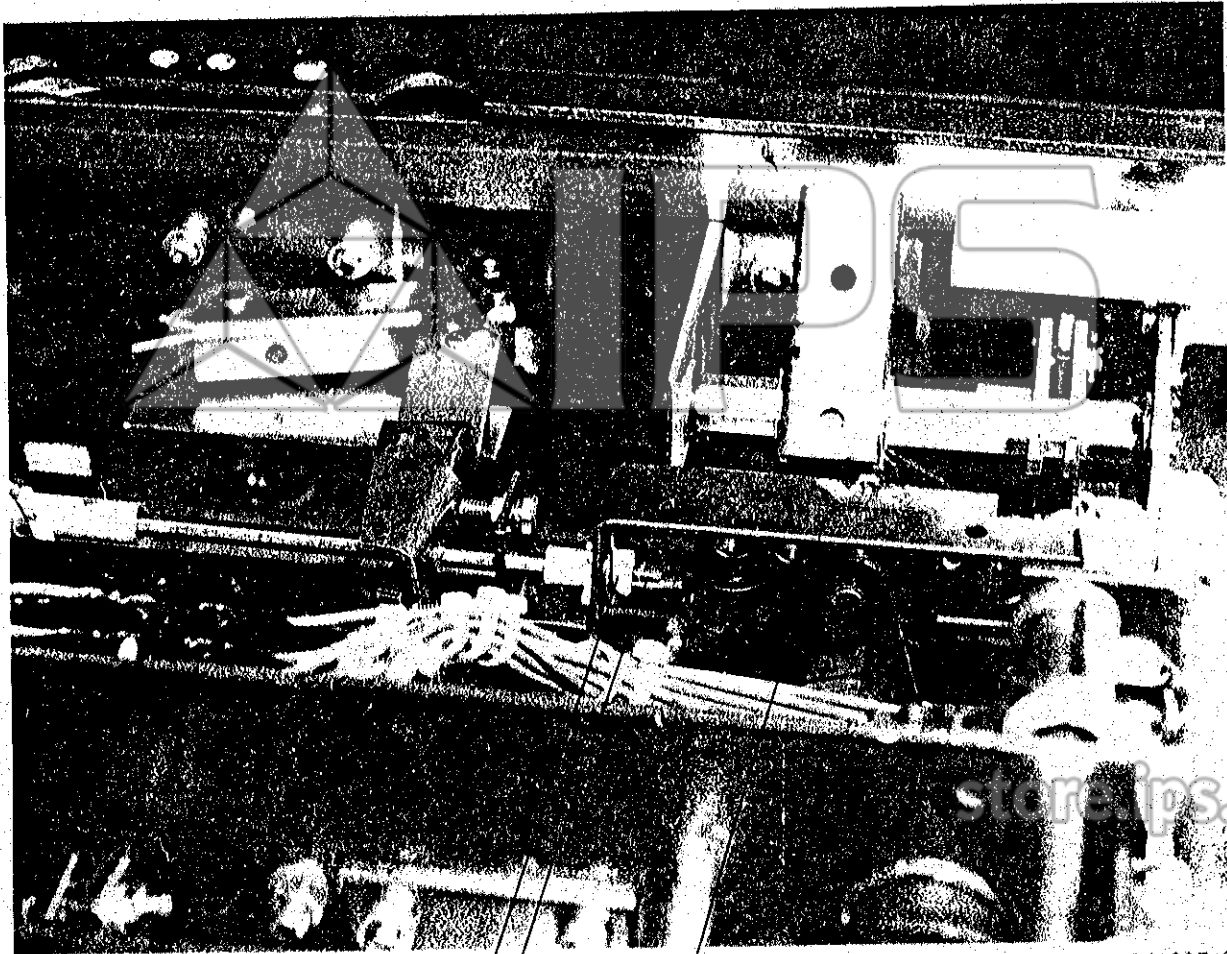
FIGURE 13 TRIP COIL AND LINKAGE



86132B-7

1. Trip coil
2. Closing spring
3. Trip linkage adjusting rod and nut

FIGURE 14 CLOSE COIL LINKAGE

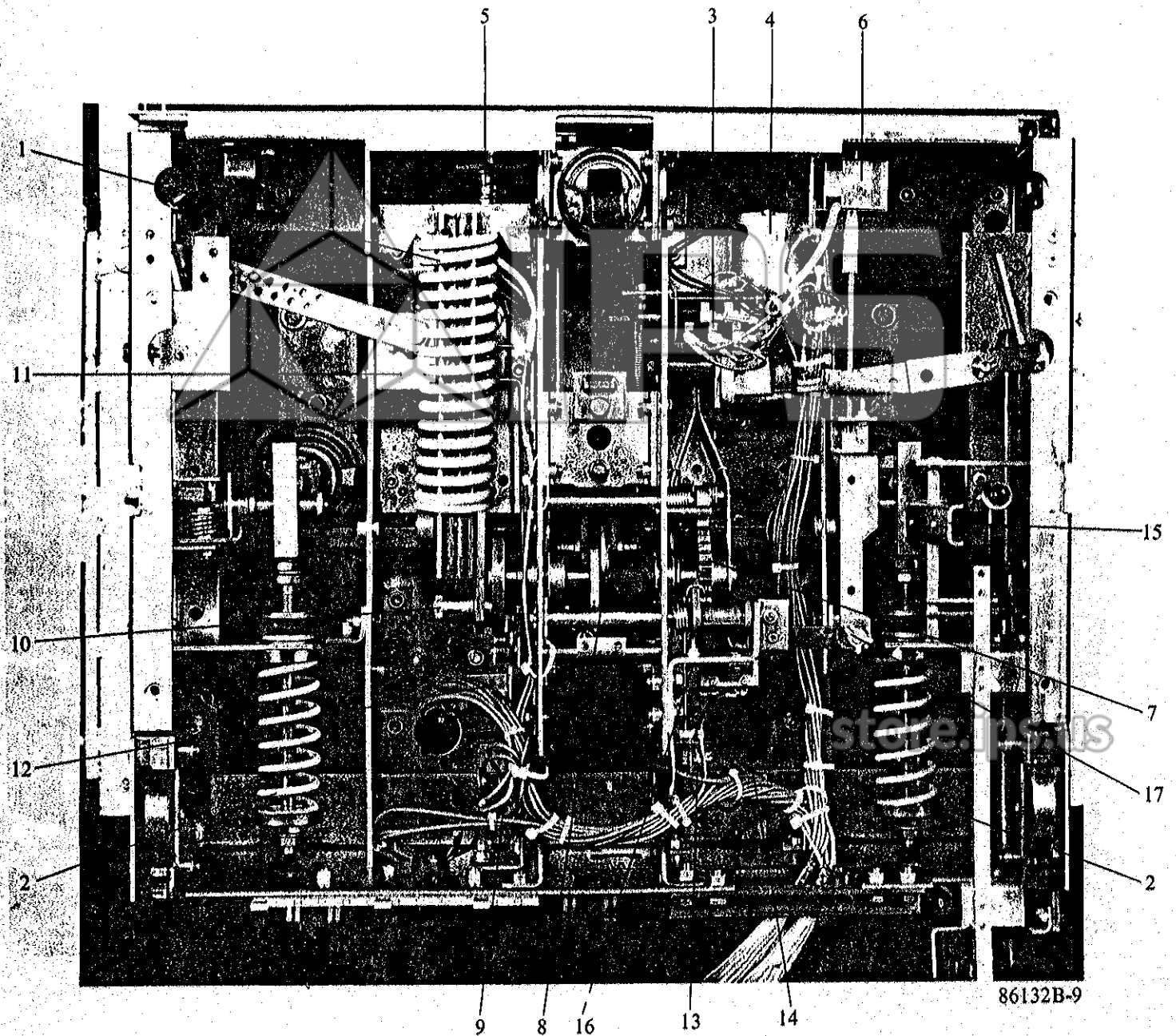


86132B-8

1 2 3

- 1. Close linkage adjusting nut
- 2. Close linkage adjusting rod
- 3. Link to close latch actuator

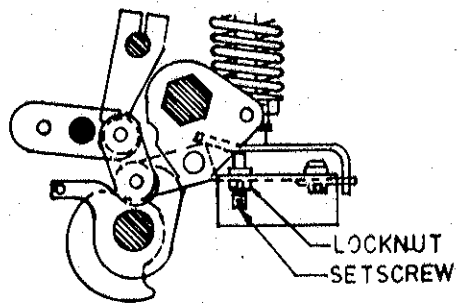
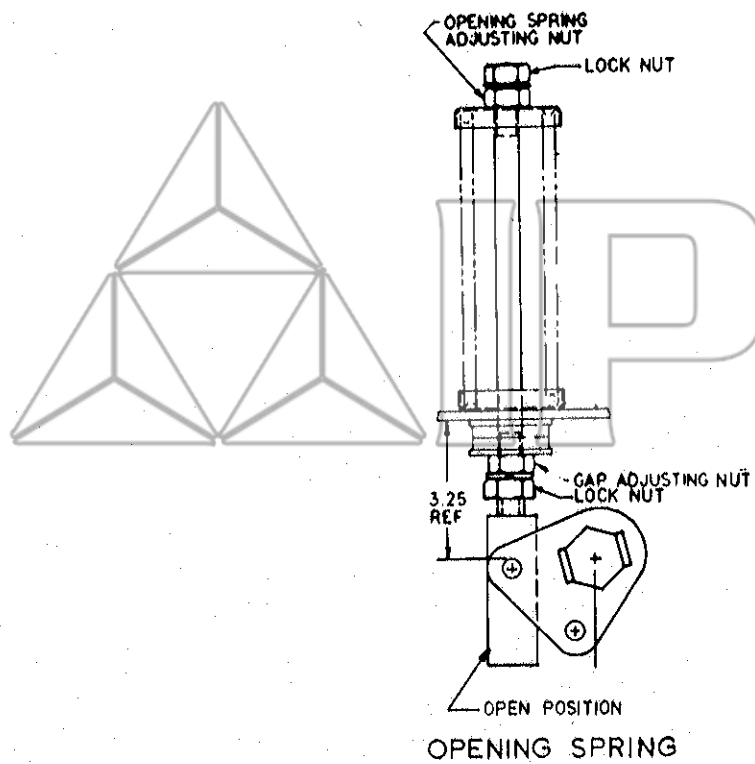
FIGURE 15 BOTTOM VIEW OF ML-18 MECHANISM



1. Closing spring
2. Opening springs
3. Auxiliary switch
4. Spring charging motor
5. Trip coil
6. Close coil
7. Ratchet wheel
8. Closing cam

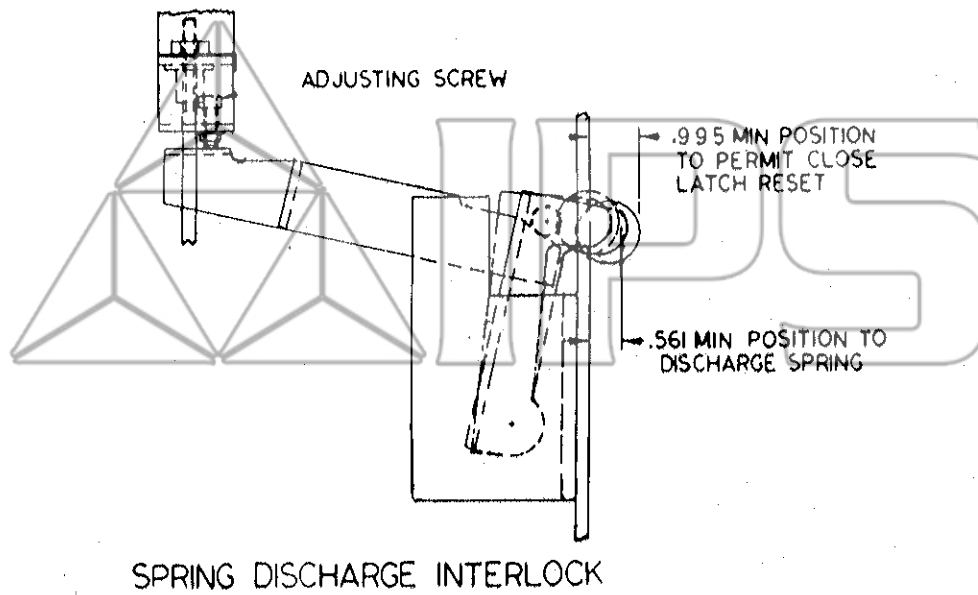
9. 52Y relay
10. Pivot bolt
11. Interlock bracket
12. SM/LS motor control switch
13. LCS latch checking switch
14. CL/MS close latch monitor switch
15. Stationary aux. switch operator
16. Close latch adjustment screw
17. Close linkage pivot

FIGURE 16 CONTACT GAP ADJUSTMENT



V.I. STOP CENTER PHASE

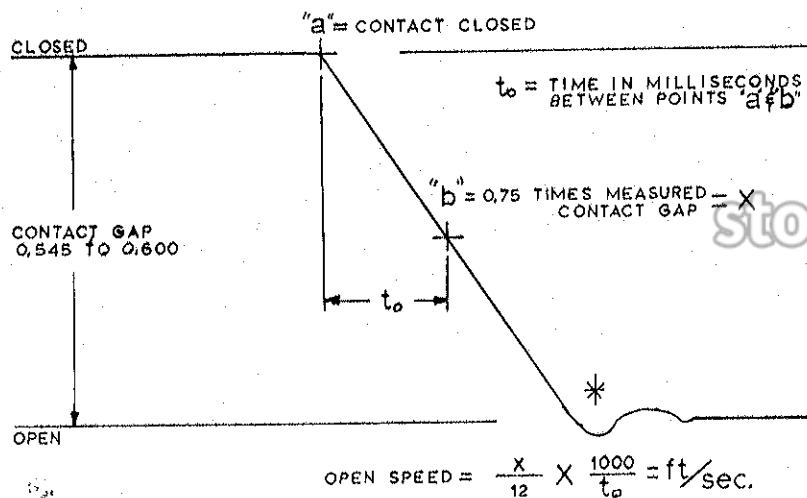
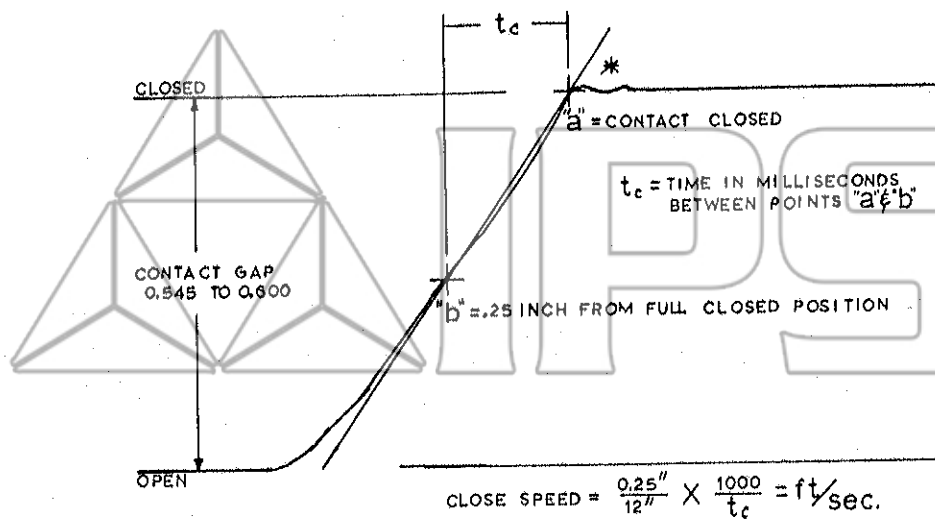
FIGURE 17 SPRING DISCHARGE INTERLOCK



**CAUTION THIS IS A SAFETY FEATURE
NOT A ROUTINE MAINTENANCE ITEM**

store.ips.us

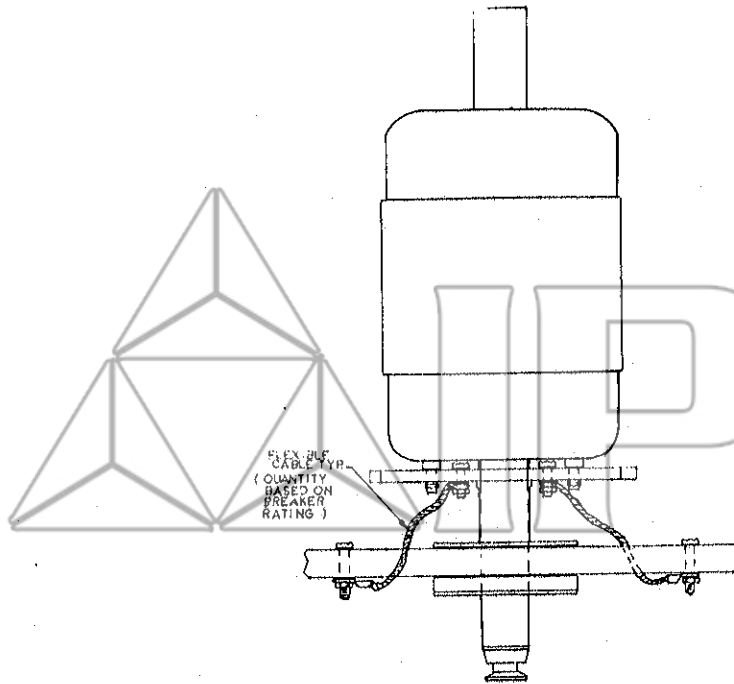
FIGURE 18 SAMPLE OPERATING SPEED GRAPHS



* FOR BREAKERS EQUIPPED WITH AN OPENING DASHPOT, THERE IS VIRTUALLY NO OVERTRAVEL OR REBOUND.

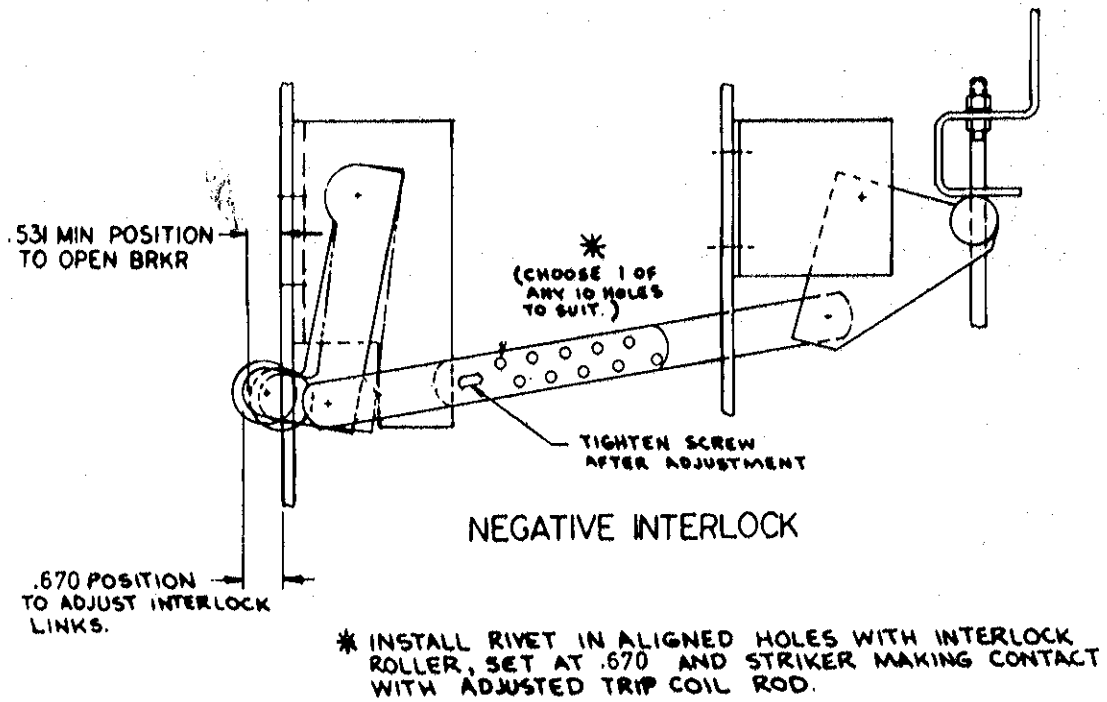
OPERATING SPEED GRAPHS

FIGURE 19 FLEX CABLE CONNECTION



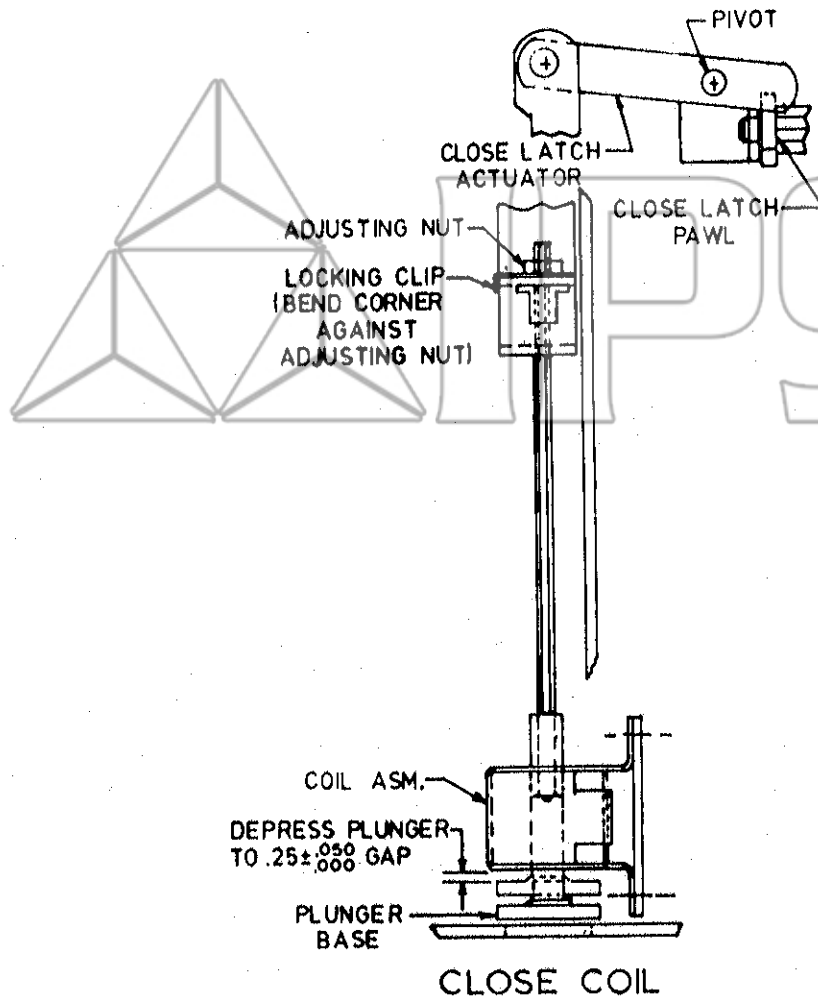
FLEX CABLE CONNECTION

FIGURE 20 NEGATIVE INTERLOCK



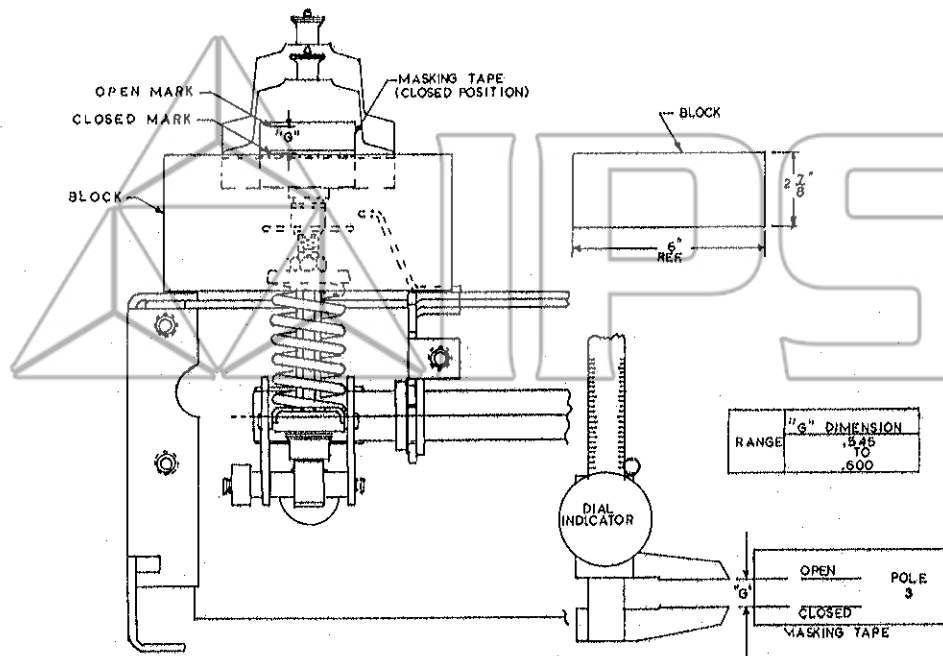
NEGATIVE INTERLOCK

FIGURE C CLOSE COIL PLUNGER GAP



store.ips.us

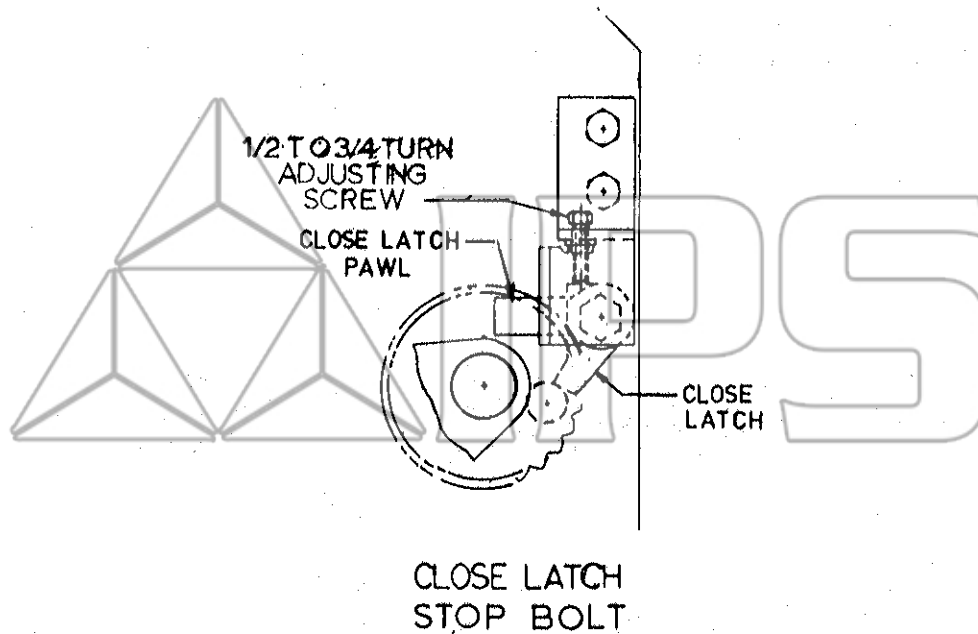
FIGURE G CONTACT GAP



CONTACT GAP

store.ips.us

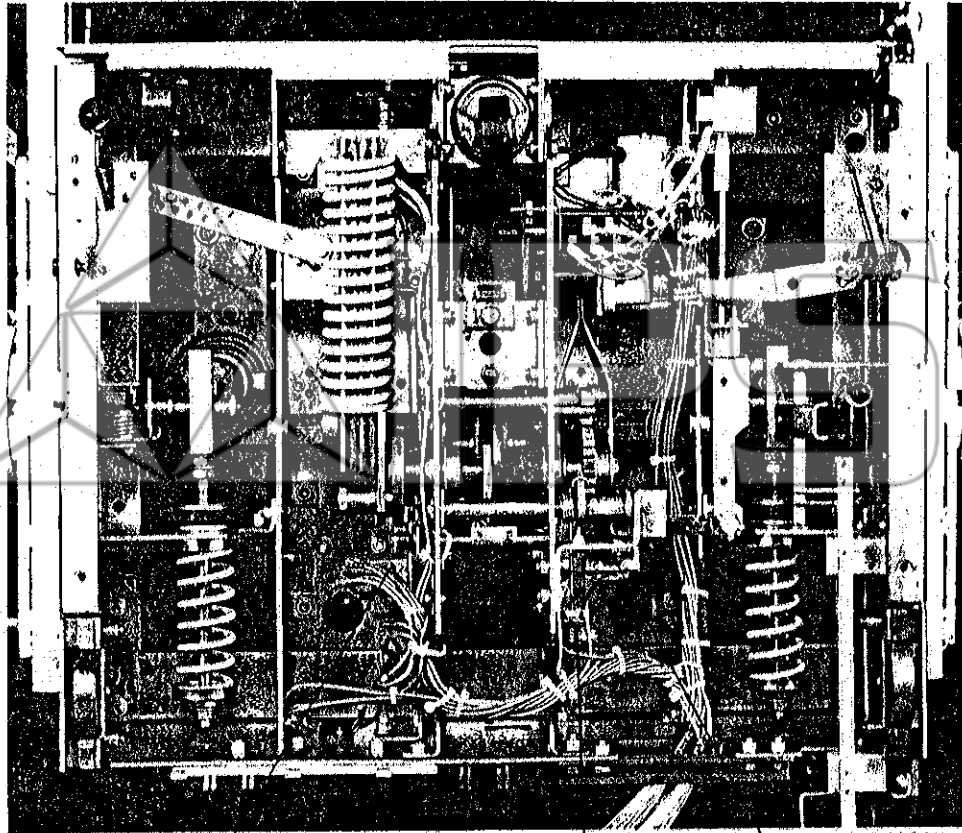
FIGURE L CLOSE LATCH STOP



**CAUTION THIS IS A SAFETY FEATURE
NOT A ROUTINE MAINTENANCE ITEM**

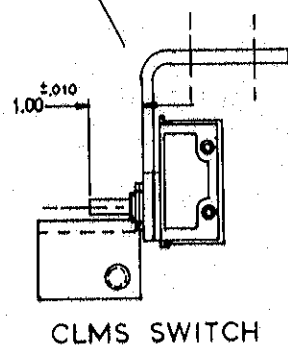
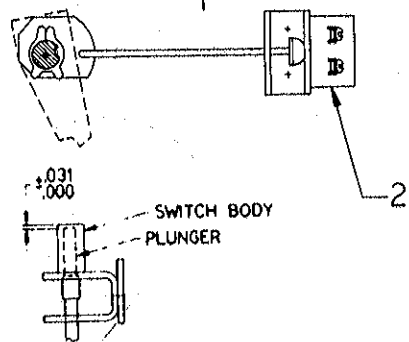
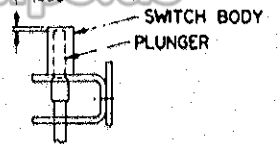
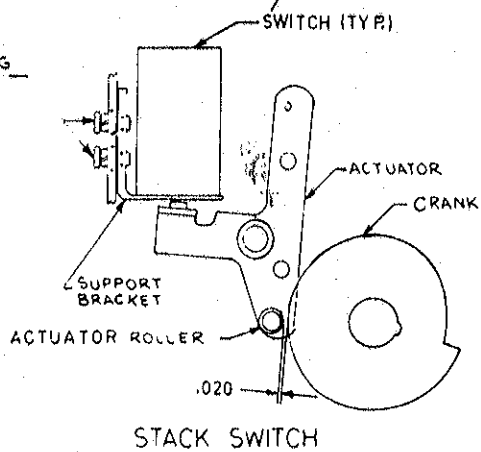
**A CHANGE IN THE SETTING OF THE CLOSE LATCH STOP BOLT WILL
AFFECT THE ADJUSTMENT OF THE SPRING DISCHARGE INTERLOCK**

FIGURE S CONTROL SWITCHES



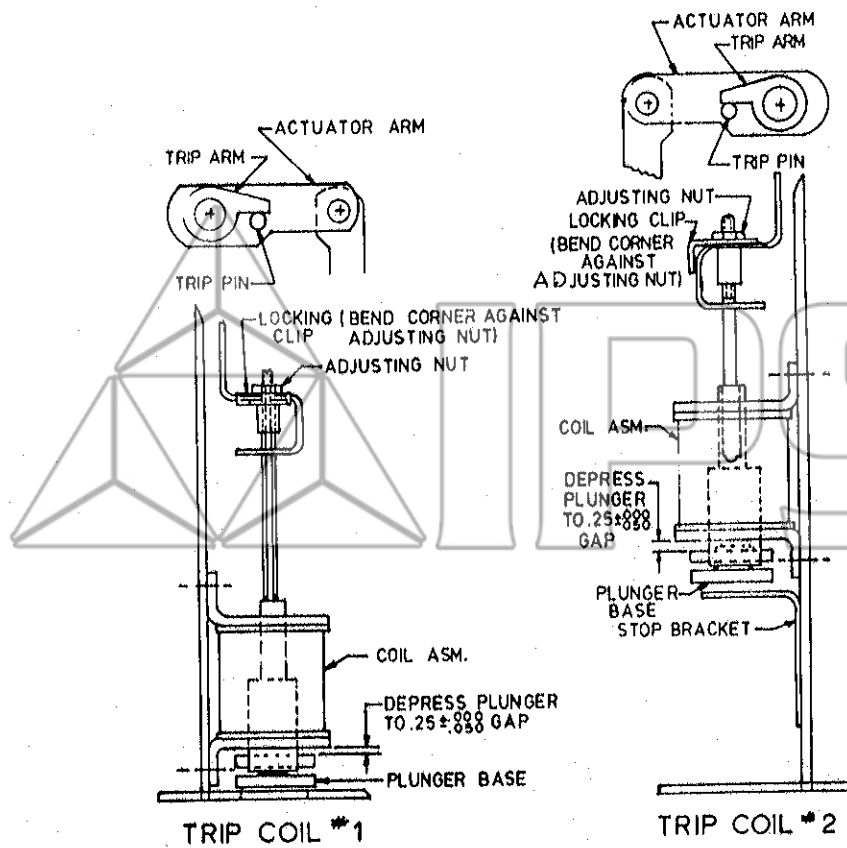
86132B-9

store.ips.us



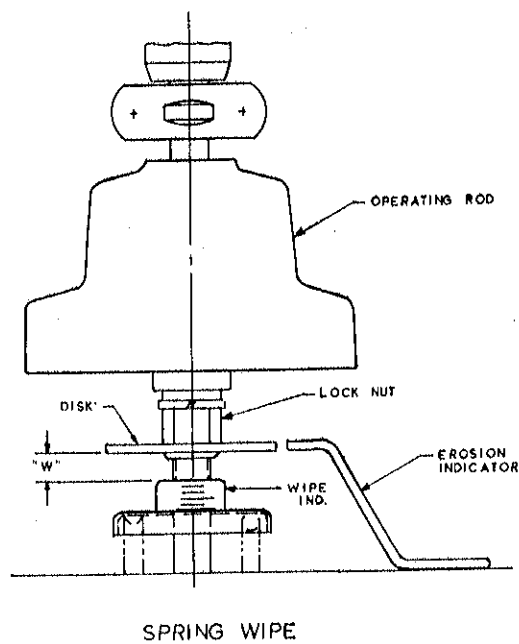
LCS SWITCH

FIGURE T TRIP COIL PLUNGER GAP



store.ips.us

FIGURE W SPRING WIPE



INDEX

A

Auxiliary Switch Replacement 12

C

Close Coil Plunger 6, 12, 14
Close Coil Plunger Gap 6
Close Latch Stop Bolt 14
Close Spring Charging 4
Closing Coil Replacement 12
Closing Operation 4
Closing Spring Charging 5
Closing Spring Discharge Interlock 3
Closing Spring Gag 3, 5
Closing Spring Gag Interlock 3
Contact Erosion 6, 9
Contact Gap 6, 7, 11, 13
Contact Gap Adjustment 13
Control Circuit 5, 9
Control Switch Adjustment 6, 12

D

Description 2
Dimensional Checks 6, 10, 12, 13, 14
Dimensional Checks
Close Coil Plunger Gap 6
Contact Gap 6, 7, 11,
Control Switch Adjustment 6, 12
Primary Contact Erosion 6, 9
Spring Wipe 6
Trip Coil Plunger Gap 6

E

Electrical Checks 7, 10, 11
Electrical Operation 7
High-Potential Test 7
Insulation Tests 8
Primary Circuit 7
Primary Circuit Resistance 7
Secondary Circuit 7
Interrupter Integrity Test 7
Electrical Operation 7

F

Fault Interruptions 9

G

Gag Plate Removal 5
General 1, 9, 11, 13

H

Handling 2
High-Potential Test 7

I

Install Front Cover 7
Installation 2, 9
Insulation Tests 8
Interlock Functional Check 8
Interlocks 1, 3
Spring Discharge Interlock 3
Closing Spring Gag Interlock 3
Negative Interlock Roller 3
Positive Interlock Bar 3
Rating Interference Plate 3
Introduction 1, 8

L

Lubrication 9, 10

M

Maintenance
Contact Erosion 6, 9
Fault Interruptions 9
General 1, 9, 11, 13
Lubrication 9, 10
Mechanism 1, 2, 4, 9, 11
Power/Vac* Interrupter 9
Primary Insulation Parts 9
Service Conditions 9
Transfer Finger Wear 9
Mechanical Adjustments
Close Coil Plunger 6, 12, 14
Close Latch Stop Bolt 14
Contact Gap 6, 13
Negative Interlock 3, 14
Spring Discharge Interlock 3, 14
Trip Coil Plunger 6, 14
Wipe Adjustment 6, 13
Mechanical Checking and Slow
Closing 4, 5, 10
Mechanism 1, 2, 4, 9, 11
Motor Replacement 12

N

Negative Interlock 3, 14
Negative Interlock Roller 3

O

Opening and Closing Speed 11
Opening Operation 4
Operation 3, 4, 5, 7, 10
Ordering Instructions 13

P

Positive Interlock Bar 3
Power/Vac* Interrupter 9
Primary Circuit 7
Primary Circuit Resistance 7
Primary Contact Erosion 6, 9
Primary Disconnect Fingers 11
Primary Insulation Parts 9

R

Rating Interference Plate 3
Receiving 2
Recommended Maintenance 10
Renewal Parts 12
Ordering Instructions 13
Repair and Replacement
"Y" Relay 12
Auxiliary Switch 12
Closing Coil 12
Control Switches 12
Interrupter Assemblies 11
Motor 12
Primary Disconnect Fingers 11
Trip Coil 12

S

Safety 1, 2
General 1, 9, 11, 13
Specific 1, 8
Safety Precautions 2
Secondary Circuit 7

Service Conditions 9

Slow Closing 4, 5, 10
Spring Discharge Interlock 3, 14
Spring Wipe 6
Storage 2

T

Timing 10
Instantaneous Reclose Time 10
Trip-Free Operation 10
Transfer Finger Wear 9
Trip Coil Plunger 6, 12, 14
Trip Coil Plunger Gap 6
Trip Coil Replacement 12
Trip-Free Operation 5

V

Vacuum Interrupter Integrity Test 7, 11

W

Wipe Adjustment 6, 13

Y

"Y" Relay Replacement 12

store.ips.us

TROUBLE REPORTING FORM FOR POWER CIRCUIT BREAKERS

USER REPORT NO.

Check all appropriate blocks and provide information indicated. For major trouble provide additional information requested on back of page supplemented with additional pages if necessary.

EQUIPMENT:

Equipment Nameplate Information

Station _____ User Ident of Breaker _____
 Mfr. _____ Type _____ Serial # _____
 KV _____ Inter Amps/MVA _____ Continuous Amps _____ Bil _____

Brkr Background:

Shipped _____, Installed _____, Maintained _____, Modernized _____, Trouble Date _____
 (Mo/Yr) (Mo/Yr) (Mo/Yr) (Mo/Day/Yr)

Operational Counter Reading _____

Location: ☐ Indoor ☐ Outdoor

Enclosure: ☐ Non-metal Clad, ☐ Metalclad, ☐ GIS

Interrupter: ☐ Air Blast, ☐ Air Magnetic, ☐ Oil, ☐ SF₆, ☐ Vacuum, Other _____

ENVIRONMENT:

General: ☐ Industrial, ☐ Urban, ☐ Suburban, ☐ Rural, ☐ Sea Coast, ☐ Above 3300', ☐ High Contamination, Other _____

Weather Conditions: ☐ Dry, ☐ Rain, ☐ Lightning in Area, ☐ Snow, ☐ Fog, ☐ Freezing Rain, ☐ Frost, ☐ Condensation, Temp. Trend -- ☐ Rising, ☐ Falling, ☐ Steady, ☐ Extreme Cold, Temperature _____ °F, Wind -- ☐ Calm, ☐ Light, ☐ Strong-Steady, ☐ Strong-Gusty

External Mechanical Stresses Involved: ☐ Normal, ☐ Earthquake, ☐ Wind, ☐ Abnormal Terminal Loading, Other _____

Nominal System voltage _____

TROUBLE:

When Discovered: ☐ Installation, ☐ In Service, ☐ Maintenance, ☐ Test, Other _____

Breaker Mode at Time of Trouble: ☐ De-energized, ☐ Closed, ☐ Open, ☐ Tripping, ☐ Closing, ☐ Reclosing, ☐ Fault Interruption, ☐ Load Switching, ☐ Line Switching

Breaker Response at Time of Trouble: ☐ Not Called Upon to Operate, ☐ Performed as Intended, ☐ Unsatisfactory Operation, ☐ Failed to Operate

Subsystem in Trouble: ☐ External Insulation to Grnd, ☐ Internal Insulation to Grnd, ☐ Insulating Medium, ☐ Isolating Contact, ☐ Bushing, ☐ Interrupter, ☐ Seals-Gaskets, ☐ Air System, ☐ SF₆ System, ☐ C.T., ☐ Resistor Sw or Aux. Int., ☐ Voltage Grading Dev, ☐ Line Terminals, ☐ Compressor, ☐ Heater, ☐ Electrical Controls, ☐ Wiring, ☐ Operating Mechanism, ☐ Mechanical Linkage, ☐ Other _____

State Specifically What Failed (With Instr. Book Ref.): _____

Has it occurred before on this type of brkr? ☐ No, ☐ Yes, How many times _____

State How Problem was Corrected: _____

POSSIBLE CAUSE: ☐ Design/Manufacture, ☐ Shipping, ☐ Storage, ☐ Installation, ☐ Instructions, ☐ Maintenance, ☐ Wear/Aging, ☐ Animal/Birds, ☐ Other, ☐ Not Obvious

Comments and Suggestions: _____

EFFECT:

Breaker Down Time: ☐ No Interruption, ☐ 30 Min or Less, ☐ 1 Hr, ☐ 2 Hr, ☐ 6 Hr, ☐ 12 Hr, ☐ 24 Hr, Other _____

Repair Time: ☐ Less than 30 Min, ☐ 1 Hr, ☐ 2 Hr, ☐ 6 Hr, ☐ 1 Day, ☐ 2 Days, ☐ 3 Days, ☐ 1 Week, Other _____

Breaker Outage Status: ☐ Immediate Forced Outage, ☐ Outage Within 20 Min., ☐ Required Subsequent Outage, ☐ Repair Deferred Until Regular Maintenance, ☐ No Outage for Repair

User Person

Completing Report _____ Date _____

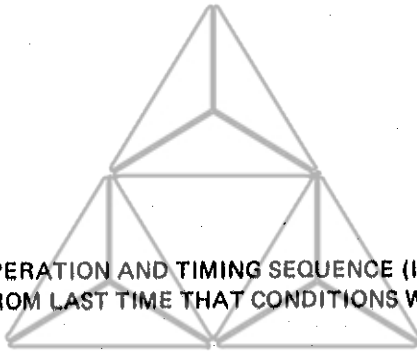
User Approval Name _____ Date _____

User Contact Name _____ Telephone Number _____

User Company _____

**ADDITIONAL INFORMATION REQUIRED FOR ANALYSIS OF MAJOR OR
SYSTEM RELATED TROUBLE
(USE ADDITIONAL PAGES AS NECESSARY)**

- (1) SINGLE-LINE STATION DIAGRAM SHOWING INVOLVED BREAKERS



- (2) OPERATION AND TIMING SEQUENCE (INCLUDING ALL ALARMS) OF THIS AND RELATED BREAKERS FROM LAST TIME THAT CONDITIONS WERE DEFINITELY NORMAL

store.ips.us

- (3) LINE CONDITIONS BEFORE, DURING, AND AFTER FAILURE

- (4) OSCILLOGRAMS – ATTACH WITH EXPLANATION & INTERPRETATION

- (5) ATTACH A DESCRIPTION OF THE EXACT POSITION OF ALL MECHANICAL COMPONENTS FROM THE CONTROL SOLENOID THROUGH ALL INTERRUPTER CONTACTS AS APPLICABLE. (PHOTOGRAPH EACH IN DETAIL BEFORE MECHANISMS ARE MOVED; SUPPLY COPIES OF PHOTOS WITH REPORT.)

- (6) DESCRIBE ARC DAMAGE AND LOCATION OF ARC PRODUCTS RELATIVE TO VALVE SEALS. (PHOTOGRAPH EACH IN DETAIL BEFORE ANY CLEAN UP OR POST FAILURE MECHANISM MOVEMENT; SUPPLY COPIES OF PHOTOS WITH REPORT.)



G E CONSTRUCTION EQUIPMENT BUSINESS
SWITCHGEAR OPERATION
BURLINGTON, IOWA 52601

store.ips.us