

Schedule of charges

Standard charge (based on one nominal day @ £40 per hour plus standard components. All prices are ex-VAT)	Additional work, time or programming equipment	Typical additional charge (see comments)
£355.00 The standard charge includes research, telephone and email advice, external & electrical analysis, disassembly and mechanical analysis. The four page assessment schedule is used as the basis for the engineer's quote. Re-assembly includes replacement bearings, oil seals (if there is provision for an oil seal), sealant (where appropriate), setting phase relationships, final tests and cosmetic finishing.	No unusual work, time or equipment needed. Resolvers or simple incremental encoder analyses are included in standard charge.	£0.00
	Complex feedback hours and programming interfaces	£200.00
	Multilayer feedback (eg, DriveCliq or early Indramat interfaces).	£300.00
	Minor machining/ manual mechanical corrections	£40.00
	Minor electrical repairs	£40.00
	stone oil seal wear using lathe	£40.00
	Install shaft protector	£50.00
	Re-sleeve shaft oil seal journal	£120.00
	Machine rotor to fit stub shaft	from £270.00 §
	Straighten shaft	from £120.00
	Balance shaft (heavy/high speed/short body/highly magnetic shafts take longer and cost higher)	from £50.00
	Machine bearing housing to fit insert (large housing costs vary)	£150.00
	Refurbish/ repair brake, re-insulate wires, replace TVS device, clean, hand-condition, set gap, build-rebuild to achieve maximum torque, etc	from £180.00
	Cleaning/ treatment of stator	from £50
	Repair shaft (stabilise fixing, replace magnets, re-band, ensure trueness of mounted magnets, temperature cure, etc.)	From £150
	Rewind stator or brake.	From £600 §
	Reverse engineer and fabricate thermal feedback device	£50.00
	Replace feedback	from £340
	Unwieldy/highly magnetic motor take longer and may need manufactured tooling @ £40 per hour)	@ £40.00 p.h
	Special/oversize bearings/oil seal	Varies
	Calculate, measure and adjust bearings tension correctly using tensioning washers and machined shims	£60.00
	Replace chassis plug	from £85.00
	Courier/packing	from £30.00

§ Some clients have their own rewinding or machining facilities: QSRL tolerances and guidelines must be used for non-QSRL engineering work. A charge for assessment of completed work will be made. Work which does not conform to QSRL tolerances will be rejected, with detailed comments.