



**KEEPING YOUR FACILITY UP TO SPEED**  
— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 100759**

Prepared for Axiom Impressions

11601 Otter Creek South  
Mabelvale AR 72103

# Table of Contents



Hi-Speed Industrial Service  
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## DC Repair Report

**Axiom Impressions**  
11601 Otter Creek South  
Mabelvale, AR 72103

FolderID: 100759  
FormID: 15670784



### DC Repair Report Rev. 2

**Location:** MOTOR SHOP LR

**Job Number:** 100759

**Serial Number:** N52362-1

**Status:** In For Repair

**Description:** 75HP FINCOR DC 1750RPM  
AD366AT

**Hi-Speed Job Number:** 100759

**Manufacturer:** Other

**Product Number :** 36600450A04

**Serial Number:** N52362-1

**HP/KW:** 75 (HP)

**RPM:** 1750

**Frame:** AD366AT

**Armature Voltage:** 500 (Volts)

**Armature Current:** 123 (Amps)

**Field Voltage:** 150 (Volts)

**Field Current :** 2.96 (Amps)

**J-Box Included:** No

**Bearing RTDS:** No

**Winding RTDS:** No

**Mounting Orientation :** Horizontal

Priorities Found: ☒ 1 - High ☒ 8 - Good

### Overall Condition

1. Describe the Overall Condition of the Equipment as Received

*Very dirty and commutator is very worn*

2. Nameplate Picture



3. Distance From the End of the Shaft to the end of the Face of the Sheave/Coupling

### Initial Mechanical/Electrical

- ☒ 4. Does the Shaft Turn Freely?

(Y) Yes

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5. Does Shaft Have Visible Damage?

(No) No



6. Assembled Shaft Runout	Inches
7. Assembled Shaft End Play	
8. Air Gap Variation <10%	
9. Lead Condition	(P) Pass
10. Lead Length	7 Inches
11. Frame Condition	(P) Pass



12. Fan Condition

(P) Pass



13. Brush Information		
Brush Number	Quantity	Condition
<b>8993-e3</b>	<b>4</b>	<b>replace</b>
14. Brush Holder Condition - Verify proper gap to Commutator		<b>good</b>



### Incoming Electrical Test

15. General Condition of the Armature/Commutator **commutator very worn**

*Armature is blown. Rewind*



16.	Armature Insulation Resistance to Ground		0 Megohms
17.	Field Circuit Insulation Resistance to Ground		5000 Megohms
18.	Interpole Circuit Insulation Resistance to Ground		4000 Megohms
19.	Field Drop Test Fields 1&2		
	Total AC Voltage	Field #1	Field #2
	135	0.5	0.5
20.	Field Drop Test Fields 3&4		
	Field #3	Field #4	Field #2
	0.5	0.52	
21.	Field Drop Test Fields 5&6		
	Field #5	Field #6	Field #2
22.	Field Drop Test Fields 7&8		
	Field #7	Field #8	Field #2

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23. Interpole Drop Test 1&2		
Total AC Voltage	Interpole #1	Interpole #2
10	2.8	2.8
24. Interpole Drop Test 3&4		
Interpole #3	Interpole #4	Field #2
2.8	2.8	
25. Interpole Drop Test 5&6		
Interpole #5	Interpole #6	Field #2
26. Interpole Drop Test 7&8		
Interpole #7	Interpole #8	Field #2
27. Armature Number of Bars - Bar to Bar Test		
Number of Bars	Bar to Bar Test	
<b>Mechanical Inspection</b>		
28. Shaft Runout Drive End		0.001 inches
29. Shaft Runout Armature		
Drive End Bearing Journal	Armature Core	ODE Bearing Journal
30. Drive End Bearing Number		6213 2z
31. Drive End Bearing Quantity		1



32. Drive End Bearing Type	(Ball) Ball Bearing
33. Drive End Lubrication Type	(Grease) Grease Lubricated
34. Drive End Bearing Insulation or Grounding Device?	
35. Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring

36. Drive End Bearing Condition

worn and has frosting



37. Opposite Drive End Bearing Number

6211 2z

38. Opposite Drive End Bearing Quantity

1

39. Opposite Drive End Bearing Type

(Ball) Ball Bearing



40. Opposite Drive End Lubrication Type

(Grease) Grease Lubricated

41. Opposite Drive End Bearing Insulation or Grounding Device?

42. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?

wavy washer

43. Opposite Drive End Bearing Condition

cage came apart



44. Signature of Technician who Performed Teardown

Trevor Hall

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45. List Parts Needed Prior to Reassembly

6211 2rsr  
6213 2rsr  
Rewind armature  
New commutator

**Mechanical Fits - Armature**

46. Coupling Fit Closest to Bearing Housing

0 Degrees	60 degrees	120 degrees
-----------	------------	-------------

47. Coupling Fit Closest to the End of the Shaft

0 Degrees	60 degrees	120 degrees
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48. Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
2.5595	2.5595	2.5594

49. Drive End Bearing Shaft Fit Condition (P) Pass

50. Opposite Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
2.1658	2.1658	2.1658

51. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

52. Shaft Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal
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**Mechanical Fits- Bearing Housings**

53. Drive End - End Bell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
4.7248	4.7253	4.7253

54. Drive End - Endbell Bearing Fit Condition (P) Pass





## 55. Opposite Drive End - End Bell Bearing Fit

0 Degrees

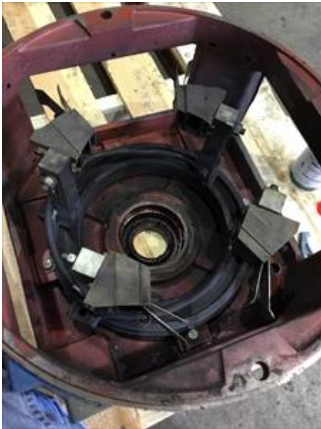
60 Degrees

120 Degrees

3.9381

3.938

3.9380



## 56. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail

Barely oversized

## 57. Bearing Cap Condition

Drive End

Opposite Drive End

pass



## 58. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

## 59. List any Machine work Needed Below

machine opposite drive  
endbell

## 60. Signature of Technician Performing Measurements

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## Root Cause of Failure

61. Failure Locations

62. Root Cause of Failure

## Commutator Data

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63. Total Copper Segment Length			
64. Number of Bars	185		
65. Number of Wires Per Copper Bar and Size			
Number of Wires per Bar	Wire Size		
66. Equalizers per Copper Bar and Equalizer Wire Size			
Equalizers per Bar	Wire Size		
67. Document Commutator Diameter, Minimum and Max			
Current Comm Diameter	Minimum Comm Diameter	Maximum Comm Diameter	
68. Commutator Shaft Diameter			
Front Shaft Diameter	Back Shaft Diameter		
69. Commutator Type			
70. Commutator Bore			
71. Signature of Technician Recording Data			
<b>Dynamic Balance Report</b>			
72. Rotor Weight and Balance Grade			
Rotor Weight	Balance Grade		
73. Initial Balance Readings			
Drive End Readings	Opposite Drive End Readings		
74. Final Balance Readings			
Drive End Readings	Opposite Drive End Readings		
75. Signature of the Balance Technician			
<b>Post Armature Rewind Testing</b>			
76. Post Rewind Armature Insulation Resistance to Ground			
77. Post Rewind Field Circuit Measure the Insulation Resistance to Ground			
78. Post Rewind Armature Number of Bars - Bar to Bar Test			
Number of Bars	Bar to Bar Test		
79. Post Rewind Field Circuit Insulation Resistance to Ground			
80. Post Rewind Interpole Circuit Insulation Resistance to Ground			
81. Post Rewind Field Drop Test Fields 1&2			
Total AC Voltage	Field #1	Field #2	
82. Post Rewind Field Drop Test Fields 3&4			
Field #3	Field #4	Field #2	
83. Post Rewind Field Drop Test Fields 5&6			
Field #5	Field #6	Field #2	
84. Post Rewind Field Drop Test Fields 7&8			
Field #7	Field #8	Field #2	

85. Post Rewind Interpole Drop Test 1&2		
Total AC Voltage	Interpole #1	Interpole #2
86. Post Rewind Interpole Drop Test 3&4		
Interpole #3	Interpole #4	Field #2
87. Post Rewind Interpole Drop Test 5&6		
Interpole #5	Interpole #6	Field #2
88. Post Rewind Interpole Drop Test 7&8		
Interpole #7	Interpole #8	Field #2
<b>Post Mechanical Repair</b>		
89. Post Repair Coupling Fit Closest to Bearing Housing		
0 Degrees	60 degrees	120 degrees
90. Post Repair Coupling Fit Closest to the End of the Shaft		
0 Degrees	60 degrees	120 degrees
91. Post Repair Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
92. Post Repair Drive End Bearing Shaft Fit Condition		
93. Post Repair Drive End Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
94. Post Repair Drive End Opposite Drive End Bearing Shaft Fit Condition		
95. Post Repair Drive End - End Bell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
96. Post Repair Drive End - Endbell Bearing Fit Condition		
97. Post Repair Opposite Drive End - End Bell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
98. Post Repair Opposite Drive End - Endbell Bearing Fit Condition		
99. Post Repair Bearing Cap Condition		
Drive End	Opposite Drive End	
100. Post Repair End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
101. Signature of Tech Performing Mechanical Repairs		
<b>Assembly</b>		
102. Take Pictures of all Major Components Prior to Reassembly		
103. Verify Brush Box Holders Have the Proper Clearance, and Brushes have been Seated Properly		
104. Assembled Shaft End Play and Runout		
Shaft Endplay	Shaft Runout	

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105.	Perform No-Load Test Run, Record Armature Voltage and Current		
	Voltage	Current	
106.	Perform No-Load Test Run, Record Field Voltage and Current		
	Voltage	Current	
107.	Document Vibration Readings Drive End		
	Horizontal	Vertical	Axial
108.	Document Vibration Readings Opposite Drive End		
	Horizontal	Vertical	Axial
109.	Perform Full-Load Test Run, Record Armature Voltage and Current		
	Voltage	Current	
110.	Perform Full-Load Test Run, Record Field Voltage and Current		
	Voltage	Current	
111.	Document Vibration Readings Under Full Load Drive End		
	Horizontal	Vertical	Axial
112.	Document Vibration Readings Under Full Load Opposite Drive End		
	Horizontal	Vertical	Axial
113.	Ambient Temperature		
114.	Drive End Bearing Temps Under Full Load		
	5 Minutes	10 Minutes	15 Minutes
115.	Opposite Drive End Bearing Temps Under Full Load		
	5 Minutes	10 Minutes	15 Minutes
116.	Final Test Run Sign-Off		
117.	Document Final Condition With Pictures		
118.	Final QC Sign-Off		



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1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
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5. **DELIVERY OF GOODS AND/OR SERVICES.** Unless otherwise identified in the quotation, all shipments are F.O.B. Hi-Speed's warehouse and the title to and all risk of loss with respect to any goods shipped shall pass to Buyer when such goods are delivered to the carrier at Hi-Speed's warehouse. Hi-Speed will use its best efforts to affect delivery by the date or dates specified in the quotation. However, Hi-Speed shall not be liable for delay in or failure to make shipment, or to perform services, by any identified date for any reason whatsoever, including but not limited to, causes beyond its reasonable control, such as strikes, fires, floods, epidemics, quarantines, restrictions, severe weather, embargos, acts of God, or public enemy, war, riot, delays in transportation or the inability to obtain necessary labor, materials or manufacturing facilities.
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