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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 101529**

Prepared for Almatris Inc/RCP Bauxite (10014)

4701 Alcoa Road  
Bauxite AR 72011

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AC Inspection as Found - *LR Motor Shop*

AC Inspection - Rev. 2: *C 05 7768296-0205 M 0002*

**1.0**

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*Printed on 6/21/2023*

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Hi-Speed Industrial Service  
7030 Ryburn Dr  
Millington, Tn 38053  
901-873-5300

**AC Inspection as Found**  
**Almatis Inc/RCP Bauxite (10014)**  
4701 Alcoa Road  
Bauxite, AR 72011

FolderID: 101529  
FormID: 17112073

**AC Inspection - Rev. 2**

**Location:** LR Motor Shop  
**Serial Number:** C 05 7768296-0205 M 0002  
**Description:** 30HP US MOTORS 1800RPM 286T

<b>Hi-Speed Job Number:</b>	101529
<b>Manufacturer:</b>	US Motors/Nidec
<b>Product Number:</b>	HD30P2F
<b>Serial Number:</b>	C 05 7768296-0205 M 0002
<b>HP/kW:</b>	30 (HP)
<b>RPM:</b>	1775 (RPM)
<b>Frame:</b>	286T
<b>Voltage:</b>	230 / 460
<b>Current:</b>	70/35
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b>Service Factor:</b>	1.15
<b>Enclosure:</b>	TEFC
<b>J-box Included:</b>	Complete
<b>Coupling/Sheave:</b>	None
<b>Bearing RTDs:</b>	No
<b>Stator RTDs:</b>	No
<b>Repair Stage:</b>	Final
<b>Heaters:</b>	No
<b>Winding Type :</b>	Random Wound
<b>Bearing Type:</b>	Rolling Element

Priorities Found: ● **6 - High** ● **3 - Good**

**Overall Condition**

1. Report Date
2. Nameplate Picture



3. Photos of all six sides of the machine.

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4. Describe the Overall Condition of the Equipment as Received

*Rotor is loose*

#### Initial Mechanical/Electrical

● 5. Does Shaft Turn Freely?	(Yes) Yes
6. Does Shaft Have Visible Damage?	(No) No
● 7. Assembled Shaft Runout	0.001 Inches
8. Assembled Shaft End Play	0.001 inches
9. Air Gap Variation <10%	
● 10. Lead Condition	(F) Fail



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11.	Lead Length	10 Inches	
12.	Frame Condition		
<div><div></div></div> 13.	Fan Condition	(P) Pass	
14.	Broken or Missing Components		
Initial Electrical Inspection			
15.	Insulation Resistance/Megger	2000 Megohms	
16.	Winding Resistance		
	1-2	1-3	2-3
<div><div></div></div> 17.	Perform Surge Test	(P) Pass	
18.	Number of Stator Slots	48 Megohms	
19.	Stator Condition		
20.	Stator Thermistors/Ohms		
21.	Stator Overloads/Ohms		
Mechanical Inspection			
22.	Drive End Bearing Brand	skf	
23.	Drive End Bearing Number-	6310 2zc3	
24.	Drive End Bearing Qty.	1	
25.	Drive End Bearing Type	(Ball) Ball Bearing	
26.	Drive End Lubrication Type	(Grease) Grease Lubricated	
27.	Drive End Bearing Insulation or Grounding Device?		
28.	Drive End Wavy Washer/Snap-Ring Other Retention Device?		
29.	Drive End Bearing Condition	fail	
30.	Opposite Drive End Bearing Brand	skf	
31.	Opposite Drive End Bearing Number-	6210 2zc3	
32.	Opposite Drive End Bearing Qty.	1	
33.	Opposite Drive End Bearing Type	(Ball) Ball Bearing	
34.	Opposite Drive End Lubrication Type	(Grease) Grease Lubricated	
35.	Opposite Drive End Bearing Insulation or Grounding Device?		
36.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer	
<div><div></div></div> 36.	Broken		
37.	Opposite Drive End Bearing Condition	fail	
38.	Drive End Seal		
39.	Opposite Drive End Seal		
Rotor Inspection			
40.	Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast	
41.	Growler Test	(Pass) Pass	
42.	Number of Rotor Bars	56	
43.	Rotor Condition		
44.	List the Parts needed for the Repair Below		
	6310 2zc3		
	6210 2zc3		
	Possibly new shaft		

45. Signature of Technician that Disassembled Motor

Trevor Hall



### Mechanical Fits- Rotor

46. Shaft Runout 0.001 inches

47. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

48. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

1.8749

1.8749

1.8749

49. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

1.8744

1.8745

1.8745

50. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.9684

1.9684

1.9684

51. Drive End Bearing Shaft Fit Condition

(F) Fail

 *Undersized*

52. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.9685

1.9685

1.9685

53. Opposite Drive End Bearing Shaft Fit Condition

(F) Fail

 *Undersized*

54. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

### Mechanical Fits- Bearing Housings

55. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

4.3321

4.332

4.332

56. Drive End - Endbell Bearing Fit Condition

(F) Fail

57. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

3.5449

3.5448

3.5448

58. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail

59. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

60. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

61. List Machine Work Needed Below

*Shaft fits and end bell fits*



62. Technician

Trevor Hall


**Dynamic Balance Report**

63. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

64. Initial Balance Readings

Drive End

Opposite Drive End

65. Final Balance Readings

Drive End

Opposite Drive End

66. Technician

**Rewind**

67. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

68. Core Hot Spot Test

Pre-Burnout

Post-Burnout

69. Post Rewind Electrical Test- Insulation Resistance

70. Post Rewind Polarization Index

71. Post Rewind Winding Resistance

1-2

1-3

2-3

72. Post Rewind Surge Test

73. Post Rewind Hi-Pot

74. Technician

**Root Cause of Failure**

75. Failure locations

76. Root cause of failure

**Mechanical Fits- Rotor - Post Repair**

77. Shaft Runout Post Repair

78. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

79. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

80. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

81. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

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82. Opposite Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
83. Shaft Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
84. Shaft Repair Sign-off			
<b>Mechanical Fits- Bearing Housings - Post Repair</b>			
85. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
86. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
87. Bearing Cap Condition Post Repair			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
88. End Bell Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
89. End Bell Repair Sign-off			
<b>Assembly</b>			
90. QC Check All Parts for Cleanliness Prior to Assembly			
91. Photograph All Major Components prior to assembly			
92. Final Insulation Resistance Test			
93. Assembled Shaft Endplay			
94. Assembled Shaft Runout			
95. Test Run Voltage			
Volts	Volts	Volts	
96. Test Run Amperage			
Amps	Amps	Amps	
97. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
98. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
99. Ambient Temperature - Fahrenheit			
100. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
101. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
102. Document Final Condition with Pictures after paint			
103. Final Pics and QC Review			

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