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LR Motor Shop Repairs

**Job Number 102047**

Prepared for Almatris Inc/RCP Bauxite (10014)

4701 Alcoa Road  
Bauxite AR 72011

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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: 102047  
FormID: 18306264

**AC Inspection - Rev. 2**

**Location:** LR Motor Shop  
**Serial Number:** JN 383005  
**Description:** 100HP GE 3600RPM 405Z

<b>Hi-Speed Job Number:</b>	102047
<b>Manufacturer:</b>	GE
<b>Product Number:</b>	5K405BK170B1
<b>Serial Number:</b>	JN 383005
<b>HP/kW:</b>	100 (HP)
<b>RPM:</b>	3560 (RPM)
<b>Frame:</b>	405Z
<b>Voltage:</b>	230 / 460
<b>Current:</b>	232/116
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b>Service Factor:</b>	1.0
<b>Enclosure:</b>	TEFC
<b>J-box Included:</b>	None
<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: ● 5 - High ● 4 - Good

**Overall Condition**

- |                      |            |
|----------------------|------------|
| 1. Report Date       | 11/03/2023 |
| 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

*Serviceable*

### Initial Mechanical/Electrical

5. Does Shaft Turn Freely? (No) No

*Completely locked up.*

6. Does Shaft Have Visible Damage? (Yes) Yes



7. Assembled Shaft Runout Inches

*Unable to perform due to locked up shaft.*

8. Assembled Shaft End Play inches

*See above.*

9. Air Gap Variation <10%

*Na*

10. Lead Condition

(P) Pass



11. Lead Length	15 Inches
12. Lead Numbers	1-3
13. Frame Condition	pass
14. Fan Condition	(P) Pass



15. Broken or Missing Components	connection box
Initial Electrical Inspection	
16. Insulation Resistance/Megger	Megohms
Na	





17. Winding Resistance		
1-2	1-3	2-3
Na.		



18. Perform Surge Test	(F) Fail
------------------------	----------



19. Number of Stator Slots	60
20. Stator Condition	rewind
21. Stator Thermistors/Ohms	na
22. Stator Overloads/Ohms	na
<b>Mechanical Inspection</b>	
23. Drive End Bearing Brand	SKF

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24. Drive End Bearing Number-

6316 2Z/C3



25. Drive End Bearing Qty.	1
26. Drive End Bearing Type	(Ball) Ball Bearing
27. Drive End Lubrication Type	(Grease) Grease Lubricated
28. Drive End Bearing Insulation or Grounding Device?	none
29. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
30. Drive End Bearing Condition	complete cage failure



31. Opposite Drive End Bearing Brand

skf

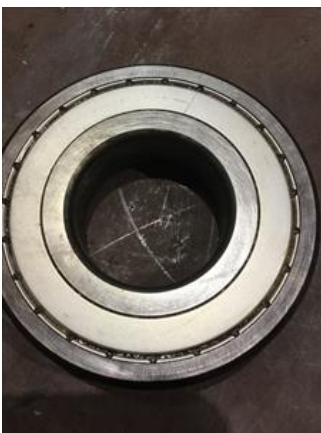




32. Opposite Drive End Bearing Number-	<b>6312 2Z/ C3</b>
33. Opposite Drive End Bearing Qty.	<b>1</b>
34. Opposite Drive End Bearing Type	<b>(Ball) Ball Bearing</b>
35. Opposite Drive End Lubrication Type	<b>(Grease) Grease Lubricated</b>



36. Opposite Drive End Bearing Insulation or Grounding Device?	<b>none</b>
37. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>none</b>
38. Opposite Drive End Bearing Condition	<b>flaking</b>



39. Drive End Seal	<b>none</b>
40. Opposite Drive End Seal	<b>none</b>

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## Rotor Inspection

41. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast



42. Growler Test

(Pass) Pass

43. Number of Rotor Bars

46

44. Rotor Condition

Pass surge test

☐ Rotor shaft require machine work.

45. List the Parts needed for the Repair Below

316 & 312 sleeves. 6316 & 6312 bearings. New shaft.

46. Signature of Technician that Disassembled Motor

Terrence Holland

## Mechanical Fits- Rotor

47. Shaft Runout

inches

☐ Unable to perform due to d.e shaft bearing journal being damaged.



48. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

☐ Na

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1.9





49. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
Na		
50. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
Na		
51. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
Bearing was seized on shaft		



52. Drive End Bearing Shaft Fit Condition	(F) Fail
---	----------



53. Opposite Drive End Bearing Shaft Fit			
0 Degrees		60 Degrees	120 Degrees
2.3624		2.3625	2.3625
	54. Opposite Drive End Bearing Shaft Fit Condition		(P) Pass
55. Shaft Air Seal Fits			
Drive End Air Seal		Opposite Drive End Air Seal	
	Na		

## Mechanical Fits- Bearing Housings

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56. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
<div> <div></div> <div>Bearing seized to shaft</div> </div>		
57. Drive End - Endbell Bearing Fit Condition		(F) Fail
<div> <div></div> <div>Excessive wear from total bearing cage failure.</div> </div>		



58. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
<div> <div></div> <div>Lip worn in due to bearing failure on both ends</div> </div>		
59. Opposite Drive End - Endbell Bearing Fit Condition		(F) Fail
<div> <div></div> <div>Lip worn in fit. Bearing failed from flaking.</div> </div>		



## 60. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass

pass



## 61. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

## 62. List Machine Work Needed Below

*Re-sleeve both end-bell housing fits, repair or replace tapered shaft. Minor core repair on stator.*

63. Technician

Terrence Holland

## Dynamic Balance Report

## 64. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

0

0

## 65. Initial Balance Readings

Drive End

Opposite Drive End

0

3.59

## 66. Final Balance Readings

Drive End

Opposite Drive End

0

.16

67. Technician

David Maclin

## Rewind


## 68. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

na

na

69.	Core Hot Spot Test		
	Pre-Burnout		Post-Burnout
	na		na
70.	Post Rewind Electrical Test- Insulation Resistance		2000 Megohms
71.	Post Rewind Polarization Index		0 Polarization Index
72.	Post Rewind Winding Resistance		
	1-2	1-3	2-3
	0	0	0
73.	Post Rewind Surge Test		(Pass) Pass
74.	Post Rewind Hi-Pot		0 micro-amps
75.	Technician		Bob Roberson
			

#### Root Cause of Failure

76. Failure locations	<i>Bearing, stater contact</i>	
77. Root cause of failure	<i>Bearing failure</i>	


#### Mechanical Fits- Rotor - Post Repair

78. Shaft Runout Post Repair	0 inches	
79. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0	0	0
80. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
0	0	0
81. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
0	0	0
82. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
3.15	3.1502	3.1502



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83. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
0	0	0
84. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
ok	ok	
85. Shaft Repair Sign-off		Gary
		
Mechanical Fits- Bearing Housings - Post Repair		
86. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
6.6935	6.6936	6.6936



87. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
5.1185	5.1185	5.1186	



88. Bearing Cap Condition Post Repair			
Drive End Bearing Cap		Opposite Drive End Bearing Cap	
ok		ok	

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# 89. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

ok

ok



# 90. End Bell Repair Sign-off

Gary

*[Handwritten signature]*

## Assembly

# 91. QC Check All Parts for Cleanliness Prior to Assembly

David Maclin

*[Handwritten signature]*

# 92. Photograph All Major Components prior to assembly

(Complete) Complete







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93. Final Insulation Resistance Test	2000 Megohms		
94. Assembled Shaft Endplay	0 inches		
95. Assembled Shaft Runout	0 inches		
96. Test Run Voltage			
Volts	Volts	Volts	
460	460	460	



97. Test Run Amperage			
Amps	Amps	Amps	
25.5	25.2	25.6	

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98. Drive End Vibration Readings - Inches Per Second			
Horizontal		Vertical	Axial
0.0103		0.0245	0.0315
99. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal		Vertical	Axial
0.0246		0.0215	0.0276
100. Ambient Temperature - Fahrenheit			70
101. Drive End Bearing Temps - Fahrenheit			
5 Minutes		10 Minutes	15 Minutes
0		0	0
102. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes		10 Minutes	15 Minutes
0		0	0
103. Document Final Condition with Pictures after paint			clean
104. Final Pics and QC Review			David Maclin
			
 Testing witnessed by Trevor Hall			



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

## AC Random Coil Rewind Report

FolderID: 102047  
FormID: 18313769

Almatis Inc/RCP Bauxite (10014)  
4701 Alcoa Road  
Bauxite, AR 72011

Priorities Found:

General	
1. Job Number	102047
2. Report Date	11/01/2023
3. Customer	Almatis



### Stator Winding

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#### 4. Core Length

"



#### 5. Core ID

"

#### 6. Back Iron Depth

"

#### 7. Slot Depth

"

#### 8. Tooth Width

#### 9. Number of Vents

#### 10. Vent Width

"

#### 11. Before Burnout Core loss

#### 12. Flux Before Burnout

#### 13. Watts before burnout

#### 14. Watts loss per lb. before burnout

#### 15. After Burnout Core Loss

#### 16. Flux After burnout

#### 17. Watts After Burnout

#### 18. Watts loss per lb After Burnout

#### 19. Core Iron Condition

#### 20. RTD's

#### 21. RTD's Reading

#### 22. Motor Heaters

#### 23. Heater Qty.

#### 24. Heater Voltage

#### 25. Heater Wattage

#### 26. Thermistors

#### 27. Number of Poles

#### 28. Slots

#### 29. Number of Coils

#### 30. Coil Weight

#### 31. Lead Markings

#### 32. Grouping

#### 33. Multiple Wires

#### 34. Wire Size

#### 35. Turns per coil

#### 36. Pitch 1 to:

#### 37. Connection

#### 38. Lead Length

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39.	Lead Size
40.	Number of Leads
41.	Megger Reading After Rewind
42.	Coil Machine Slot
43.	Coil Machine Tip
44.	Coil Machine Pitch
45.	Hi Pot Reading After Rewind
46.	Surge Pattern After Rewind
47.	Service Technician



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13. **FORCE MAJEURE.** Neither party shall be responsible for any delay or failure in performance of any party of the quotation, purchase order or these Standard Terms and Conditions to the extent that such delays or failures are caused by fire, flood, earthquake, explosion, war, embargo, government requirement, civil or military authority, acts of God, or any other circumstances beyond its reasonable control and not involving any fault or negligence on the party affected ("Condition"). If any such Condition occurs, the party delayed or unable to perform shall promptly give written notice to the other party and, if such Condition remains at the end of thirty (30) days, the party affected by the other party's delay and inability to perform may elect to (i) terminate such order or part thereof, or (ii) suspend the order for the duration of the Condition, if the Buyer is the suspending party, buy elsewhere comparable material to be sold under the order and apply to any commitment the purchase price of such purchase, and resume performance of the order once the Condition ceases, with an option in the affected party to extend the period of this order up to the length of the time the Condition endures.
14. **NONWAIVER.** No course of dealing or failure of either party to strictly enforce any term, right, or condition of these Standard Terms and Conditions will be construed as a waiver of such term, right or condition. Any waiver by Hi-Speed will only be in writing and will waive no succeeding breach of a term, right or condition.
15. **ASSIGNMENT.** The rights and obligations of the parties shall neither be assigned nor delegated without the prior written consent of the other party. However, any party may assign or delegate its respective rights and obligations, in whole or in part, (i) to any subsidiary, (ii) pursuant to other financing, merger or reorganization or (iii) pursuant to any sale or transfer of substantially all of the assets of the assigning party. These Standard Terms and Conditions shall bind the heirs, successors and assigns of the parties hereto.
16. **NO INDIVIDUAL LIABILITY.** Notwithstanding any other agreement to the contrary, the Buyer agrees that in no event will the Buyer hold and Hi-Speed owner, director, officer or employee personally liable for unintentional tortious conduct or conduct that constitutes the breach of any contract between Hi-Speed and the Buyer, even if the Hi-Speed owner, director, officer or employee is or could be construed to be a party to such contract.