



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

LR Motor Shop Repairs

**Job Number 101960**

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: 16-9447-001

**1.0**

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*Printed on 12/7/2023*

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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: 101960  
FormID: 18100108

**AC Inspection - Rev. 2**

**Location:** LR Motor Shop

**Serial Number:** 16-9447-001

**Description:** 350HP LOUIS ALLIS 437RPM  
7110Z

**Hi-Speed Job Number:** 101960

**Manufacturer:** Louis Allis

**Product Number:** FR35087110ZZV

**Serial Number:** 16-9447-001

**HP/kW:** 350 (HP)

**RPM:** 437 (RPM)

**Frame:** 7110Z

**Voltage:** 460

**Current:** 297

**Phase:** Three

**Hz:** 60 (Hz)

**Service Factor:** 1.15

**Enclosure:** WPI

**J-box Included:** Complete

**Coupling/Sheave:** None

**Bearing RTDs:** No

**Stator RTDs:** No



**Repair Stage:** Final

**Rewind:** Yes

**Heaters:** No

**Winding Type :** Random Wound

**Bearing Type:** Rolling Element

Priorities Found:  **4 - High**  **4 - Good**

**Overall Condition**

1. Report Date

**10/10/2023**

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1.0

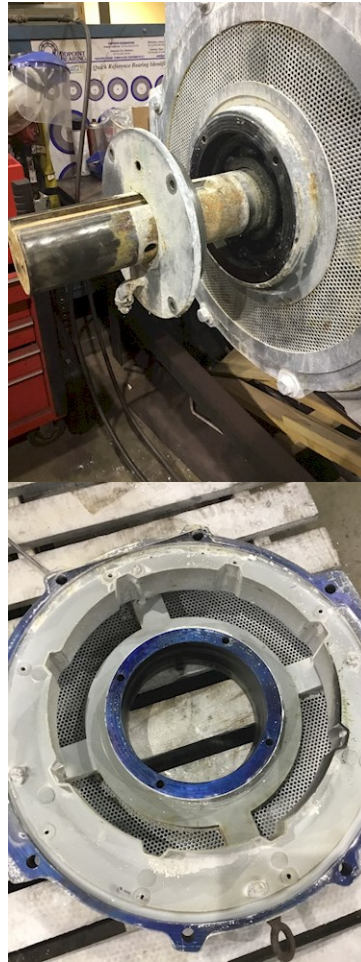
## 2. Nameplate Picture

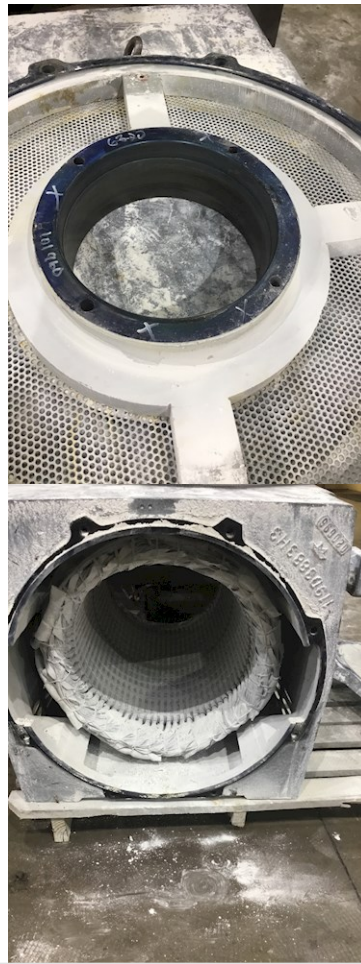
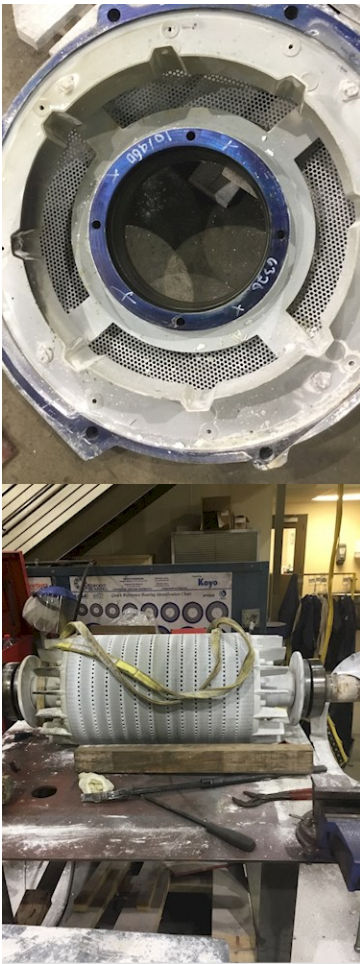


## 3. Photos of all six sides of the machine.

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4. Describe the Overall Condition of the Equipment as Received  
*Dirty. Covered in white powder.*

#### Initial Mechanical/Electrical

5. Does Shaft Turn Freely?	(Yes) Yes
6. Does Shaft Have Visible Damage?	(No) No
7. Assembled Shaft Runout	0.0003 Inches
8. Assembled Shaft End Play	0 inches
9. Air Gap Variation <10%	
10. Lead Condition	(P) Pass
11. Lead Length	18 Inches
12. Lead Numbers	1-3
13. Frame Condition	god
14. Fan Condition	(N) NA
15. Broken or Missing Components	none

#### Initial Electrical Inspection

16.	Insulation Resistance/Megger	0 Megohms	
17.	Winding Resistance		
	1-2	1-3	2-3
	0	0	0
	Shorted		
	18.	Perform Surge Test	(F) Fail
	19.	Number of Stator Slots	72

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## 20. Stator Condition

shorted, rewind



## 21. Stator Thermistors/Ohms

176 Ohms




## 22. Stator Overloads/Ohms

no overloads



**Mechanical Inspection**

23. Drive End Bearing Brand	skf
24. Drive End Bearing Number-	6320
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	
31. Opposite Drive End Bearing Brand	
32. Opposite Drive End Bearing Number-	6320
33. Opposite Drive End Bearing Qty.	1
34. Opposite Drive End Bearing Type	(Ball) Ball Bearing
35. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
36. Opposite Drive End Bearing Insulation or Grounding Device?	none
37. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
38. Opposite Drive End Bearing Condition	
39. Drive End Seal	none
40. Opposite Drive End Seal	none

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Rotor Inspection			
41. Rotor Type/Material	(Copper Barred) Copper Barred Rotor		
42. Growler Test	(Pass) Pass		
43. Number of Rotor Bars	86		
44. Rotor Condition	good		
45. List the Parts needed for the Repair Below 6320,6320, rewind			
46. Signature of Technician that Disassembled Motor	David Maclin		
			
Mechanical Fits- Rotor			
47. Shaft Runout	0.0001 inches		
48. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
0	0	0	
49. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
3.8784	3.8784	3.8783	
50. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
3.8751	3.8753	3.8753	
51. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
3.9377	3.9377	3.9377	
52. Drive End Bearing Shaft Fit Condition	(P) Pass		
53. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
3.9377	3.9377	3.9377	
54. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass		
55. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
pass	pass		
Mechanical Fits- Bearing Housings			



56. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
8.468999999999999	8.463800000000001	8.462
		
57. Drive End - Endbell Bearing Fit Condition		(F) Fail
58. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
8.465	8.4598	8.461
59. Opposite Drive End - Endbell Bearing Fit Condition		(F) Fail
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	
pass	pass	
62. List Machine Work Needed Below		
Sleeve BOTH end bells. Machine ALL 4 CAPS to fit sleeves		
63. Technician		David Maclin
		
<b>Root Cause of Failure</b>		
64. Failure locations		
65. Root cause of failure		
<b>Dynamic Balance Report</b>		
66. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	

## 67. Initial Balance Readings

Drive End

Opposite Drive End



## 68. Final Balance Readings

Drive End

Opposite Drive End



## 69. Technician

Cw

Rewind

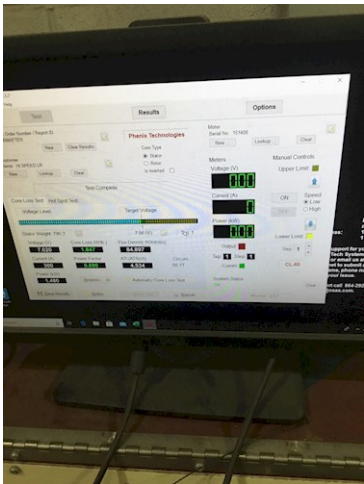
70. Core Test Results - Watts loss per Pound

Pre-Burnout

2.08

Post Burnout

1.847



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71. Core Hot Spot Test

Pre-Burnout

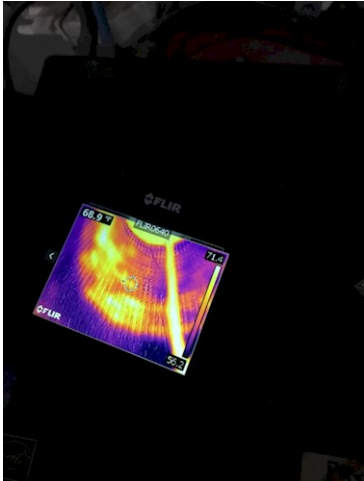
Post-Burnout

50

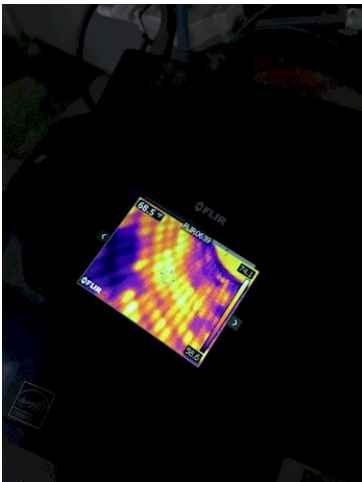
10



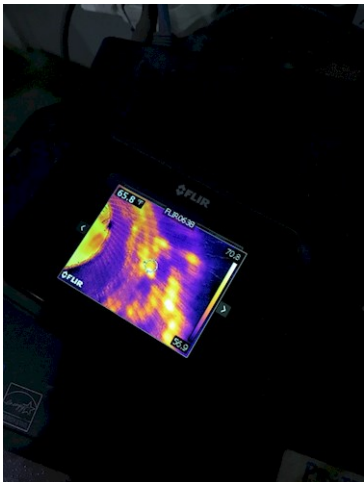
Before



Before



Before



Before



After hottest spot had a 10 degree rise after 2 minutes

72. Post Rewind Electrical Test- Insulation Resistance

23000 Megohms

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73. Post Rewind Polarization Index

74. Post Rewind Winding Resistance

1-2

1-3

2-3

.0192

.0192

.0193



75. Post Rewind Surge Test

(Pass) Pass





*B. Goines*



### Mechanical Fits- Rotor - Post Repair

78. Shaft Runout Post Repair

79. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

80. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

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

0 Degrees

60 Degrees

120 Degrees

82. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

83. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
84. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
85. Shaft Repair Sign-off		
Mechanical Fits- Bearing Housings - Post Repair		
86. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
8.4648	8.4648	8.4648



87. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
<b>8.465</b>	<b>8.465</b>	<b>8.4651</b>

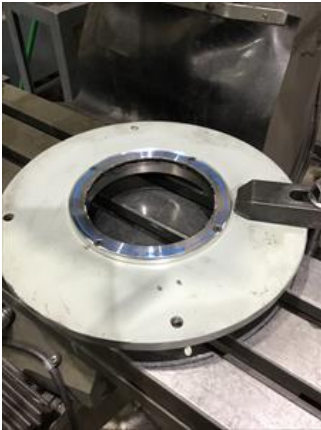


88. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Installed Agis ring on D.E. Inner bearing cap.



89. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

90. End Bell Repair Sign-off

Gary

*[Handwritten signature]*

Assembly

91. QC Check All Parts for Cleanliness Prior to Assembly

Cw

*[Handwritten signature]*

92. Photograph All Major Components prior to assembly







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93. Final Insulation Resistance Test	Megohms	
Na		
94. Assembled Shaft Endplay	inches	
Na		
95. Assembled Shaft Runout	inches	
0.002		
96. Test Run Voltage		
Volts	Volts	Volts
460	459	461

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97. Test Run Amperage

Amps	Amps	Amps
159.3	157.3	158.2



98. Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
0.0539	0.0392	0.0525

99. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
0.0411	0.0327	0.0344

100. Ambient Temperature - Fahrenheit

Na

101. Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes
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Na

102. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes
-----------	------------	------------

Na

103. Document Final Condition with Pictures after paint

done

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104. Final Pics and QC Review

Cw

*Chris*



Co sign: TREVOR HALL





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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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