



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

LR Motor Shop Repairs

Job Number 100503

Prepared for ARKANSAS INDUSTRIAL MACHINERY

3804 N. NONA ST
NORTH LITTLE ROCK AR 72118

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

AC Recondition As Found
ARKANSAS INDUSTRIAL MACHINERY
3804 N. NONA ST
NORTH LITTLE ROCK, AR 72118

FolderID: 100503
FormID: 14934310

AC Recondition - Rev. 2

Location: Shop
Serial Number: 1708/203492701
Description: 315KW SIEMENS 1800RPM 315L

Hi-Speed Job Number:	100503
Manufacturer:	Siemens
Product Number:	1LG 312-4MA91-Z 315L
Serial Number:	1708/203492701
HP/kW:	315 (kW)
RPM:	2515 (RPM)
Frame:	315L
Voltage:	460
Current:	540
Phase:	Three
Hz:	84 (Hz)
Service Factor:	1.25
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Bearing Housing Machined	Yes
Fit Repairs Required:	
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: 4 - High 5 - Good

Overall Condition

1. Report Date
2. Nameplate Picture

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1.0

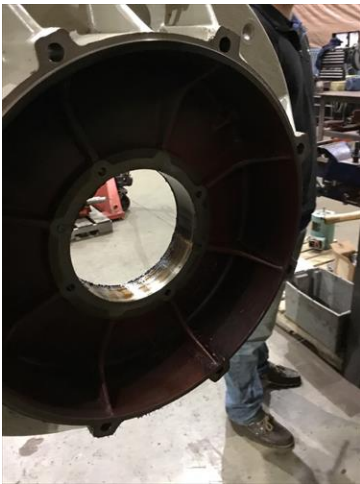


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1.1

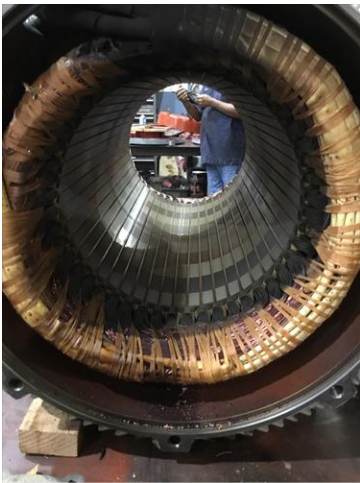


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1.2



3. Photos of all six sides of the machine.

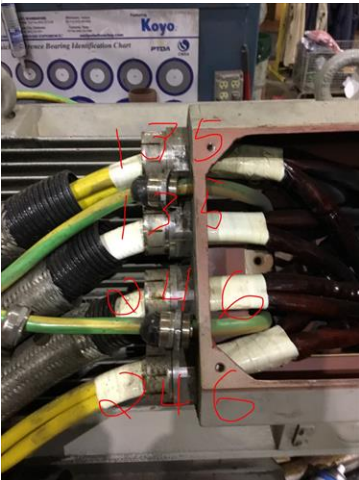




4. Describe the Overall Condition of the Equipment as Received

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	inches
9. Air Gap Variation <10%	
10. Lead Condition	(P) Pass
11. Lead Length	131 Inches



12. Frame Condition	good
13. Fan Condition	(P) Pass
14. Broken or Missing Components	none
Initial Electrical Inspection	
15. Insulation Resistance/Megger	0 Megohms
585 ohm varistor	
16. Winding Resistance	
1-2	1-3 2-3
17. Perform Surge Test	(F) Fail
18. Stator Condition	blown
Mechanical Inspection	

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19. Drive End Bearing Number-

6319



20. Drive End Bearing Qty.	1
21. Drive End Bearing Type	(Ball) Ball Bearing
22. Drive End Lubrication Type	(Grease) Grease Lubricated
23. Drive End Bearing Insulation or Grounding Device?	none
24. Drive End Wavy Washer/Snap-Ring Other Retention Device?	spring loaded cap
25. Drive End Bearing Condition	bad
26. Opposite Drive End Bearing Number-	6319
27. Opposite Drive End Bearing Qty.	1
28. Opposite Drive End Bearing Type	(Ball) Ball Bearing
29. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
30. Opposite Drive End Bearing Insulation or Grounding Device?	none
31. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
32. Opposite Drive End Bearing Condition	bad
33. Drive End Seal	none
34. Opposite Drive End Seal	none


Rotor Inspection

35. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
36. Growler Test	(Pass) Pass
37. Number of Rotor Bars	39
38. Rotor Condition	good
39. List the Parts needed for the Repair Below <i>6319; 6319, rewind, sleeve ode, sleeve de</i>	
40. Signature of Technician that Disassembled Motor	David Maclin


Mechanical Fits- Rotor

41. Shaft Runout			0.001 inches
42. Rotor Runout			
Drive End Bearing Fit		Rotor Body	Opposite Drive End Bearing
0.001		0.001	0

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43. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
44. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
45. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
3.7405	3.7405	3.7405
46. Drive End Bearing Shaft Fit Condition		(P) Pass
47. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
3.7405	3.7404	3.7404
48. Opposite Drive End Bearing Shaft Fit Condition		(P) Pass
49. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings		
50. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
7.8762	7.8762	7.8763
51. Drive End - Endbell Bearing Fit Condition		(F) Fail
52. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
7.8762	7.8762	7.8762
53. Opposite Drive End - Endbell Bearing Fit Condition		(F) Fail
54. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
Good		
55. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
56. List Machine Work Needed Below		
Sleeve both end bells		
57. Technician		David Maclin
		
Dynamic Balance Report		
58. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
59. Initial Balance Readings		
Drive End	Opposite Drive End	
2.4	1.7	

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60. Final Balance Readings			
Drive End		Opposite Drive End	
.9		1.1	
61. Technician			David Maclin
			
Rewind			
62. Core Test Results - Watts loss per Pound			
Pre-Burnout		Post Burnout	
63. Core Hot Spot Test			
Pre-Burnout		Post-Burnout	
64. Post Rewind Electrical Test- Insulation Resistance			
65. Post Rewind Polarization Index			
66. Post Rewind Winding Resistance			
1-2	1-3	2-3	
67. Post Rewind Surge Test			
68. Post Rewind Hi-Pot			
69. Technician			
Root Cause of Failure			
70. Failure locations			
<i>Connection at windings burned</i>			
71. Root cause of failure			
<i>Overload</i>			
Mechanical Fits- Rotor - Post Repair			
72. Shaft Runout Post Repair			
73. Rotor Runout Post Repair			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
74. Coupling Fit Closest to Bearing Housing Post Repair			
0 Degrees	90 Degrees	120 Degrees	
75. Coupling Fit Closest to the end of the Shaft Post Repair			
0 Degrees	60 Degrees	120 Degrees	
76. Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
77. Opposite Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
78. Shaft Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		

79. Shaft Repair Sign-off

Mechanical Fits- Bearing Housings - Post Repair

80. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

7.8748

7.8749

7.8749



81. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

7.8749

7.8748

8.874700000000001



82. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Installed Agis ring drive end.



83. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

84. End Bell Repair Sign-off

Assembly

85. Photograph All Major Components prior to assembly



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86. Final Insulation Resistance Test

87. Assembled Shaft Endplay

88. Assembled Shaft Runout

89. Test Run Voltage

Volts

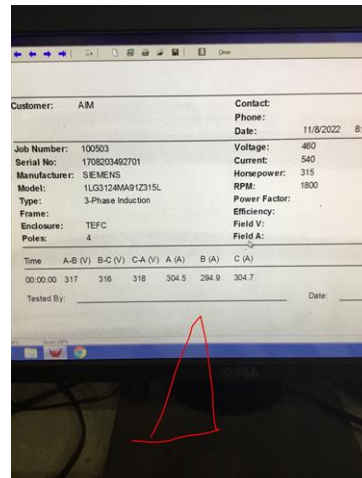
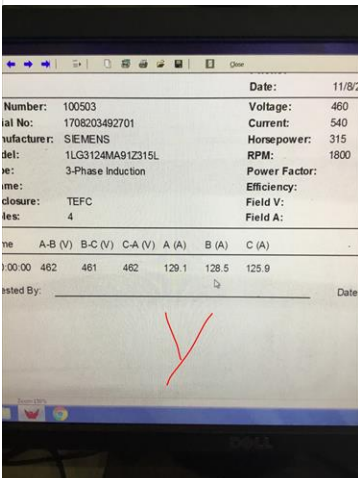
317

Volts

316

Volts

318



90. Test Run Amperage

Amps

304.5

Amps

294.9

Amps

304.7

91. Drive End Vibration Readings - Inches Per Second

Horizontal

0.0566

Vertical

0.0655

Axial

0.0286

92. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

0.0455

Vertical

0.0677

Axial

0.0355

93. Ambient Temperature - Fahrenheit

94. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

95. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

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96. QC Check All Parts for Cleanliness Prior to Assembly

97. Document Final Condition with Pictures after paint



98. Final Pics and QC Review

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

AC Random Coil Rewind Report

FolderID: 100503
FormID: 15020960

ARKANSAS INDUSTRIAL
MACHINERY
3804 N. NONA ST
NORTH LITTLE ROCK, AR 72118

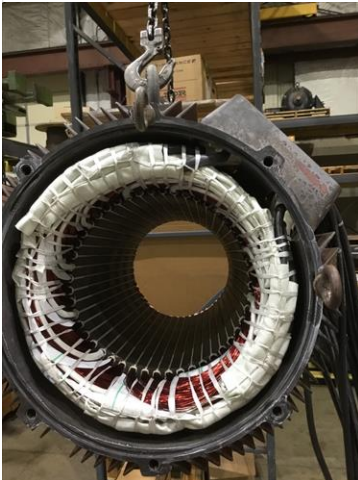
Priorities Found: ● 2 - Good

General

1. Job Number	100503
2. Report Date	11/06/2022
3. Customer	AIM

Stator Winding

4. Core Length	26.125 "
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5. Core ID	13 "
6. Back Iron Depth	1.625 "
7. Slot Depth	1.25 "
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	

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22. Motor Heaters	
23. Heater Qty.	
24. Heater Voltage	
25. Heater Wattage	
26. Thermistors	(Y) Yes
27. Number of Poles	4
28. Slots	48
29. Number of Coils	36
30. Coil Weight	263 Lbs.
31. Lead Markings	
32. Grouping 12 of 3	
33. Multiple Wires	(Y) Yes
34. Wire Size 2#14 10#15 6#16	
35. Turns per coil	
36. Pitch 1 to: 8-10 12-14	
37. Connection 2+4	
38. Lead Length	13 "
39. Lead Size	2
40. Number of Leads	12
41. Megger Reading After Rewind	Mohms
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	Robert Roberson





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3. **SCOPE OF GOODS AND/OR SERVICES.** The goods and/or services provided by Hi-Speed pursuant to any quotation shall be limited exclusively to those goods and/or services expressly identified therein. Hi-Speed does not assume any responsibility and/or liability for the failure to provide any other goods and/or services not identified in any quotation. Modifications, additions or deletions to or from the scope referenced in any quotation shall only be effective if evidenced in writing and signed by Hi-Speed. The sale of any of all goods and/or services affected by such modification, addition or deletion shall be subject to these same Standard Terms and Conditions whether or not referenced therein.
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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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11. **GOVERNING LAW AND JURISDICTION.** Any controversy arising out of any quotation, the purchase order, the goods sold or delivered, repair or replacement thereof, or any services provided pursuant to any quotation or any purchase order, or these Standard Terms and Conditions shall be governed by the laws of the state of Tennessee without regard to any choice of law provisions and any cause of action related in any manner thereto shall be brought only in the state or federal courts of Shelby County, Tennessee.
12. **ABANDONED EQUIPMENT.** Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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.
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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.