



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

LR Motor Shop Repairs

**Job Number 101876**

Prepared for ARKANSAS INDUSTRIAL MACHINERY

3804 N. NONA ST  
NORTH LITTLE ROCK AR 72118

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AC Inspection as Found - *Shop*

AC Inspection - Rev. 2: *E0910/811871 68 003*

**1.0**

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Hi-Speed Industrial Service  
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901-873-5300


**AC Inspection as Found**  
**ARKANSAS INDUSTRIAL MACHINERY**  
3804 N. NONA ST  
NORTH LITTLE ROCK, AR 72118

FolderID: 101876  
FormID: 17904569

**AC Inspection - Rev. 2**

**Location:** Shop  
**Serial Number:** E0910/811871 68 003  
**Description:** 37KW SIEMENS 1800RPM 200L

<b>Hi-Speed Job Number:</b>	101876
<b>Manufacturer:</b>	Siemens
<b>Product Number:</b>	1LA5207-4AA99-ZT00
<b>Serial Number:</b>	E0910/811871 68 003
<b>HP/kW:</b>	37 (kW)
<b>RPM:</b>	2700 (RPM)
<b>Frame:</b>	200L
<b>Voltage:</b>	460
<b>Current:</b>	80
<b>Phase:</b>	Three
<b>Hz:</b>	91 (Hz)
<b>Enclosure:</b>	TEFC
<b>J-box Included:</b>	Complete
<b>Coupling/Sheave:</b>	Gear
<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 - 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
5. Distance from the end of the shaft to the Coupling/Sheave

#### Initial Mechanical/Electrical

6. Does Shaft Turn Freely?

7. Does Shaft Have Visible Damage?

(No) No



8. Assembled Shaft Runout

9. Assembled Shaft End Play

10. Air Gap Variation <10%

● 11. Lead Condition

(P) Pass



12. Lead Length

84.09999999999999 Inches

13. Lead Numbers

u1-v1-w1

14. Frame Condition

pass

● 15. Fan Condition

(P) Pass

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16. Broken or Missing Components	none	
Initial Electrical Inspection		
17. Insulation Resistance/Megger		
18. Winding Resistance		
1-2	1-3	2-3
19. Perform Surge Test		



20.	Number of Stator Slots	48
21.	Stator Condition	
22.	Stator Thermistors/Ohms	
23.	Stator Overloads/Ohms	
Mechanical Inspection		
24.	Drive End Bearing Brand	SKF
25.	Drive End Bearing Number-	NU 212
26.	Drive End Bearing Qty.	1

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27. Drive End Bearing Type

(Roller) Roller Bearing



28. Drive End Lubrication Type	(Oil) Oil Lubricated
29. Drive End Bearing Insulation or Grounding Device?	none
30. Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
31. Drive End Bearing Condition	replace
32. Opposite Drive End Bearing Brand	SKF
33. Opposite Drive End Bearing Number-	6212 2Z / C4



34. Opposite Drive End Bearing Qty.	1
35. Opposite Drive End Bearing Type	(Ball) Ball Bearing
36. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
37. Opposite Drive End Bearing Insulation or Grounding Device?	none
38. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
39. Opposite Drive End Bearing Condition	replace
40. Drive End Seal	



41. Opposite Drive End Seal

none

### Rotor Inspection

42. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast



43. Growler Test

(Pass) Pass

44. Number of Rotor Bars

36

45. Rotor Condition

pass

46. List the Parts needed for the Repair Below

*Rebuild kit provided by customer.*

47. Signature of Technician that Disassembled Motor

Terrence Holland

### Mechanical Fits- Rotor

48. Shaft Runout

0.002 inches

49. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

50. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

51. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
52. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.363	2.363	2.363
53. Drive End Bearing Shaft Fit Condition		(P) Pass
54. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.3636	2.3625	2.3625
55. Opposite Drive End Bearing Shaft Fit Condition		(P) Pass
56. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
<b>Mechanical Fits- Bearing Housings</b>		
57. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
4.3314	4.3315	4.3315
58. Drive End - Endbell Bearing Fit Condition		(P) Pass
59. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
4.3314	4.3316	4.3317
60. Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
61. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
pass		



62. End Bell Air Seal Fits	
Drive End Air Seal	Opposite Drive End Air Seal
63. List Machine Work Needed Below	

64. Technician

Terrence. Holland


**Dynamic Balance Report**

65. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

66. Initial Balance Readings

Drive End

Opposite Drive End

67. Final Balance Readings

Drive End

Opposite Drive End

68. Technician

**Rewind**

69. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

70. Core Hot Spot Test

Pre-Burnout

Post-Burnout

71. Post Rewind Electrical Test- Insulation Resistance

72. Post Rewind Polarization Index

73. Post Rewind Winding Resistance

1-2

1-3

2-3

74. Post Rewind Surge Test

75. Post Rewind Hi-Pot

76. Technician

**Root Cause of Failure**

77. Failure locations

78. Root cause of failure

**Mechanical Fits- Rotor - Post Repair**

79. Shaft Runout Post Repair

80. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

81. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

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

0 Degrees

60 Degrees

120 Degrees

83. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

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

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