



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

LR Motor Shop Repairs

Job Number 102118

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: *U3970108908*

1.0

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Printed on 11/28/2023

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

FolderID: 102118
FormID: 18517482

AC Inspection - Rev. 2

Location: Shop
Serial Number: U3970108908
Description: 50HP LINCOLN 1800RPM 326TSC

Hi-Speed Job Number:	102118
Manufacturer:	Other
Product Number:	TV4667A1C
Serial Number:	U3970108908
HP/kW:	50 (HP)
RPM:	1770 (RPM)
Frame:	326TSC
Voltage:	230 / 460
Current:	125/62.5
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	ODP
J-box Included:	Complete
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound

Priorities Found: ● 4 - High ● 6 - Good

Overall Condition

1. Report Date
2. Nameplate Picture



3. Photos of all six sides of the machine.

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Test Time	9:51:45 AM	9:40:50 AM
Resist Status	PASS	No Test
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.195 Corr: 0.1...	
L2-L3 (Ohms)	0.195 Corr: 0.1...	
L3-L1 (Ohms)	0.194 Corr: 0.1...	
Max Delta R %	0.214	
Coil 1 (Ohms)	0.097 Corr: 0.0...	
Coil 2 (Ohms)	0.097 Corr: 0.0...	
Coil 3 (Ohms)	0.097 Corr: 0.0...	
Megohm Stat...	PASS	No Test
Volts (V)	501	
I (μA)	0.1434	
Resist	3494	
At 40°C	943	
PI Status	No Test	No Test
Volts (V)		
Nameplate	Application	Results Summary

Coil 2 (Ohms)	0.097 Corr: 0.0...	
Coil 3 (Ohms)	0.097 Corr: 0.0...	
Megohm Stat...	PASS	No Test
Volts (V)	501	
I (μA)	0.1434	
Resist	3494	
At 40°C	943	
PI Status	No Test	No Test
Volts (V)		
Nameplate	Application	Results Summary



4. Describe the Overall Condition of the Equipment as Received

Dirty

Initial Mechanical/Electrical

5. Does Shaft Turn Freely?	(Yes) Yes
6. Does Shaft Have Visible Damage?	(No) No
7. Assembled Shaft Runout	0.002 Inches
8. Assembled Shaft End Play	inches
Na	

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9. Air Gap Variation <10%	Na
10. Lead Condition	(P) Pass
Recommend new conduit	
11. Lead Length	8 Inches
12. Lead Numbers	1-12
13. Frame Condition	pass
14. Fan Condition	(N) NA
15. Broken or Missing Components	na
Initial Electrical Inspection	
16. Insulation Resistance/Megger	3494 Megohms

Test Time	9:51:45 AM	9:40:50 AM
Resist Status	PASS	No Test
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.195 Corr: 0.1...	
L2-L3 (Ohms)	0.195 Corr: 0.1...	
L3-L1 (Ohms)	0.194 Corr: 0.1...	
Max Delta R %	0.214	
Coil 1 (Ohms)	0.097 Corr: 0.0...	
Coil 2 (Ohms)	0.097 Corr: 0.0...	
Coil 3 (Ohms)	0.097 Corr: 0.0...	
Megohm Stat...	PASS	No Test
Volts (V)	501	
I(μA)	0.1434	
Resist	3494	
At 40°C	943	
PI Status	No Test	No Test
Nameplate	Application	Results Summary

Coil 2 (Ohms)	0.097 Corr: 0.0...	
Coil 3 (Ohms)	0.097 Corr: 0.0...	
Megohm Stat...	PASS	No Test
Volts (V)	501	
I(μA)	0.1434	
Resist	3494	
At 40°C	943	
PI Status	No Test	No Test
Nameplate	Application	Results Summary

17. Winding Resistance			
1-2	1-3	2-3	
0.097	0.097	0.097	

Test Time	9:51:45 AM	9:40:50 AM
Resist Status	PASS	No Test
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.195 Corr: 0.1...	
L2-L3 (Ohms)	0.195 Corr: 0.1...	
L3-L1 (Ohms)	0.194 Corr: 0.1...	
Max Delta R %	0.214	
Coil 1 (Ohms)	0.097 Corr: 0.0...	
Coil 2 (Ohms)	0.097 Corr: 0.0...	
Coil 3 (Ohms)	0.097 Corr: 0.0...	
Megohm Stat...	PASS	No Test
Volts (V)	501	
I(μA)	0.1434	
Resist	3494	
At 40°C	943	
PI Status	No Test	No Test
Nameplate	Application	Results Summary

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18. Perform Surge Test

(P) Pass



19. Number of Stator Slots	44
20. Stator Condition	pass
21. Stator Thermistors/Ohms	Na
22. Stator Overloads/Ohms	Na
Mechanical Inspection	
23. Drive End Bearing Brand	



24. Drive End Bearing Number-	6311
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?	Na
29. Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer

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30. Drive End Bearing Condition

signs of wear



31. Opposite Drive End Bearing Brand




32. Opposite Drive End Bearing Number-	6309
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?	na
37. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	na
38. Opposite Drive End Bearing Condition	signs of wear



39. Drive End Seal

na

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40. Opposite Drive End Seal	na
41. DE Sleeve Bearing Inside Diameter	
0 degrees	120 degrees
240 degrees	
Na	
42. DE Sleeve Bearing Outside Diameter	
0 degrees	120 degrees
240 degrees	
Na	
43. DE Sleeve Bearing Housing Inside Diameter	
0 degrees	120 degrees
240 degrees	
Na	
44. DE Sleeve Bearing to Housing Clearance	
0 degrees	120 degrees
240 degrees	
Na	
45. ODE Sleeve Bearing Inside Diameter	
0 degrees	120 degrees
240 degrees	
Na	
46. ODE Sleeve Bearing Outside Diameter	
0 degrees	120 degrees
240 degrees	
Na	
47. ODE Sleeve Bearing Housing Inside Diameter	
0 degrees	120 degrees
240 degrees	
Na	
48. ODE Sleeve Bearing to Housing Clearance	
0 degrees	120 degrees
240 degrees	
Na	
Rotor Inspection	
49. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
50. Growler Test	(Pass) Pass
51. Number of Rotor Bars	42
52. Rotor Condition	pass
53. List the Parts needed for the Repair Below	
6311	
6309	
Bearing sleeves for both end bell bearing fits	
54. Signature of Technician that Disassembled Motor	Cw
	
Mechanical Fits- Rotor	

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55.	Shaft Runout	0.002 inches	
56.	Rotor Runout		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
	<div>Na</div>		
57.	Coupling Fit Closest to Bearing Housing		
	0 Degrees	90 Degrees	120 Degrees
	<div>Na</div>		
58.	Coupling Fit Closest to the end of the Shaft		
	0 Degrees	60 Degrees	120 Degrees
	<div>Na</div>		
59.	Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	2.1656	2.1658	2.1657
<div></div> 60.	Drive End Bearing Shaft Fit Condition	(P) Pass	
61.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	1.772	1.772	1.7721
<div></div> 62.	Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	
63.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
	<div>Na</div>		
Mechanical Fits- Bearing Housings			
64.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	4.7259	4.7256	4.7263
<div></div> 65.	Drive End - Endbell Bearing Fit Condition	(F) Fail	
66.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	3.9385	3.9383	3.9388
<div></div> 67.	Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail	
<div></div> 68.	Bearing Cap Condition		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	<div>Bearing caps are the bearing fits for the end bells both need machine work</div>		
69.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
	<div>Na</div>		
<div></div> 70.	List Machine Work Needed Below		
	Both end bell bearing fits		

71. Technician

Cw


Dynamic Balance Report

72. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

73. Initial Balance Readings

Drive End

Opposite Drive End

74. Final Balance Readings

Drive End

Opposite Drive End

75. Technician

Rewind

76. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

77. Core Hot Spot Test

Pre-Burnout

Post-Burnout

78. Post Rewind Electrical Test- Insulation Resistance

79. Post Rewind Polarization Index

80. Post Rewind Winding Resistance

1-2

1-3

2-3

81. Post Rewind Surge Test

82. Post Rewind Hi-Pot

83. Technician

Root Cause of Failure

84. Failure locations

Bearings and end bell bearing fits

85. Root cause of failure

*Wear***Mechanical Fits- Rotor - Post Repair**

86. Shaft Runout Post Repair

87. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

88. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

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

0 Degrees

60 Degrees

120 Degrees

90. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
91. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
92. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
93. Shaft Repair Sign-off		
Mechanical Fits- Bearing Housings - Post Repair		
94. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
95. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
96. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
97. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
98. DE Sleeve Bearing Inside ID Post Repair		
Measure 1	Measure 2	Measure 3
99. DE Sleeve Bearing Outside ID Post Repair		
Measure 1	Measure 2	Measure 3
100. DE Sleeve Bearing Inside OD Post Repair		
Measure 1	Measure 2	Measure 3
101. DE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
102. End Bell Repair Sign-off		
103. ODE Sleeve Bearing Inside ID Post Repair		
Measure 1	Measure 2	Measure 3
104. ODE Sleeve Bearing Outside ID Post Repair		
Measure 1	Measure 2	Measure 3
105. ODE Sleeve Bearing Inside OD Post Repair		
Measure 1	Measure 2	Measure 3
106. ODE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
Assembly		

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107. QC Check All Parts for Cleanliness Prior to Assembly		
108. Photograph All Major Components prior to assembly		
109. Final Insulation Resistance Test		
110. Assembled Shaft Endplay		
111. Assembled Shaft Runout		
112. Test Run Voltage		
Volts	Volts	Volts
113. Test Run Amperage		
Amps	Amps	Amps
114. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
115. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
116. Ambient Temperature - Fahrenheit		
117. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
118. Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
119. Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
120. Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
121. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
122. Opposite Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
123. Opposite Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
124. Opposite Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
125. Document Final Condition with Pictures after paint		
126. Final Pics and QC Review		



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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.
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.