



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

LR Motor Shop Repairs

**Job Number 101784**

Prepared for CONWAY COUNTY WATER

30 H2O DRIVE  
PLUMMERVILLE AR 72127

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AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *P04N2690131R-1*

**1.0**

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

**AC Inspection as Found**  
**CONWAY COUNTY WATER**  
30 H2O DRIVE  
PLUMMERVILLE, AR 72127

FolderID: 101784  
FormID: 17715818

**AC Inspection - Rev. 2**

**Location:** MOTOR SHOP LR  
**Serial Number:** P04N2690131R-1  
**Description:** 50HP US MOTORS VERTICAL  
1200RPM 365T

|                             |                 |
|-----------------------------|-----------------|
| <b>Hi-Speed Job Number:</b> | 101784          |
| <b>Manufacturer:</b>        | US Motors/Nidec |
| <b>Serial Number:</b>       | P04N2690161R-1  |
| <b>HP/kW:</b>               | 50 (HP)         |
| <b>RPM:</b>                 | 1170 (RPM)      |
| <b>Frame:</b>               | 365TP           |
| <b>Voltage:</b>             | 460             |
| <b>Current:</b>             | 63              |
| <b>Phase:</b>               | Three           |
| <b>Hz:</b>                  | 60 (Hz)         |
| <b>Service Factor:</b>      | 1.15            |
| <b>Enclosure:</b>           | WPI             |
| <b>J-box Included:</b>      | Complete        |
| <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: ● 1 - High ● 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

*Oil is very dark*

#### Initial Mechanical/Electrical

|                                  |                                    |           |
|----------------------------------|------------------------------------|-----------|
| <input checked="" type="radio"/> | 5. Does Shaft Turn Freely?         | (Yes) Yes |
|                                  | 6. Does Shaft Have Visible Damage? | (No) No   |
|                                  | 7. Assembled Shaft Runout          |           |
|                                  | 8. Assembled Shaft End Play        |           |
|                                  | 9. Air Gap Variation <10%          |           |

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|                                      |  |   |
|--------------------------------------|--|---|
| 10.                                  | Lead Condition   | (P) Pass  |
|                                      | <i>A little hard</i>   |   |
| 11.                                  | Lead Length  | 6 Inches  |
| 12.                                  | Lead Numbers   | 123   |
| 13.                                  | Frame Condition  |   |
| 14.                                  | Fan Condition  |   |
| 15.                                  | Broken or Missing Components                                     |   |
| <b>Initial Electrical Inspection</b> |  |   |
| 16.                                  | Insulation Resistance/Megger                                     | 4000 Megohms  |
| 17.                                  | Winding Resistance   |   |
|                                      | 1-2  | 1-3 2-3   |
| 18.                                  | Perform Surge Test   | (P) Pass  |
| 19.                                  | Number of Stator Slots   | 54  |
| 20.                                  | Stator Condition   |   |
| 21.                                  | Stator Thermistors/Ohms  |   |
| 22.                                  | Stator Overloads/Ohms  |   |
| <b>Mechanical Inspection</b>         |  |   |
| 23.                                  | Drive End Bearing Brand  | skf   |
| 24.                                  | Drive End Bearing Number-  | 7220b   |
| 25.                                  | Drive End Bearing Qty.   | 1   |
| 26.                                  | Drive End Bearing Type   | (Thrust) Thrust                                     |
| 27.                                  | Drive End Lubrication Type                                       | (Oil) Oil Lubricated                                |
| 28.                                  | Drive End Bearing Insulation or Grounding Device?                |   |
| 29.                                  | Drive End Wavy Washer/Snap-Ring Other Retention Device?          |   |
| 30.                                  | Drive End Bearing Condition                                      | worn  |
| 31.                                  | Opposite Drive End Bearing Brand                                 | fag   |
| 32.                                  | Opposite Drive End Bearing Number-                               | 6211  |
| 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?       |   |
| 37.                                  | Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? | bearing cap and snap ring                           |
| 38.                                  | Opposite Drive End Bearing Condition                             | worn  |
| 39.                                  | Drive End Seal   |   |
| 40.                                  | Opposite Drive End Seal  |   |
| <b>Rotor Inspection</b>              |  |   |
| 41.                                  | Rotor Type/Material  | (Squirrel Aluminum) Squirrel Cage Aluminum Die Cast |
| 42.                                  | Growler Test   | (Pass) Pass   |
| 43.                                  | Number of Rotor Bars   | 66  |
| 44.                                  | Rotor Condition  |   |
| 45.                                  | List the Parts needed for the Repair Below                       |   |
|                                      | 7220b  |   |
|                                      | 6211 c3  |   |

46. Signature of Technician that Disassembled Motor

Trevor Hall



### Mechanical Fits- Rotor

47. Shaft Runout

48. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

49. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

50. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

51. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.9376

3.9374

3.9375

52. Drive End Bearing Shaft Fit Condition

(P) Pass

53. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.1653

2.1654

2.1654

54. Opposite Drive End Bearing Shaft Fit Condition

(F) Fail

Undersized

55. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

### Mechanical Fits- Bearing Housings

56. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

7.0875

7.0875

7.0875

57. Drive End - Endbell Bearing Fit Condition

(P) Pass

58. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

3.9376

3.9376

3.9375

59. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass

60. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass

61. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

62. List Machine Work Needed Below

Machine opposite drive shaft fit



63. Technician

Trevor Hall


**Dynamic Balance Report**

64. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

65. Initial Balance Readings

Drive End

Opposite Drive End

66. Final Balance Readings

Drive End

Opposite Drive End

67. Technician

**Rewind**

68. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

69. Core Hot Spot Test

Pre-Burnout

Post-Burnout

70. Post Rewind Electrical Test- Insulation Resistance

71. Post Rewind Polarization Index

72. Post Rewind Winding Resistance

1-2

1-3

2-3

73. Post Rewind Surge Test

74. Post Rewind Hi-Pot

75. Technician

**Root Cause of Failure**

76. Failure locations

*Bearings and opposite drive end shaft fit*

77. Root cause of failure

*Normal wear***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

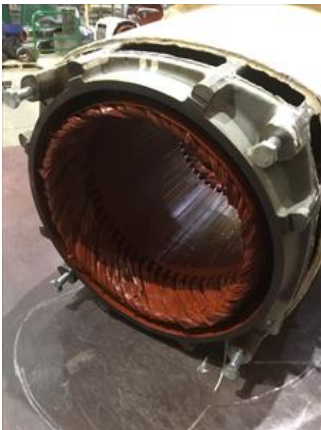
0 Degrees

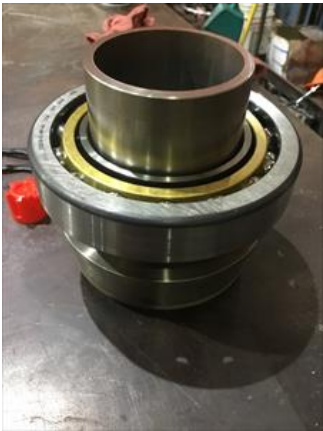
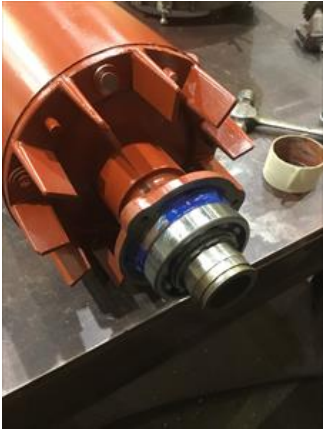
60 Degrees

120 Degrees

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|   |  |                                |             |
|---|--|--------------------------------|-------------|
| 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 |
|   |  |                                |             |
| 87.   | Opposite Drive End - Endbell Bearing Fit Post Repair |                                |             |
|   | 0 Degrees  | 60 Degrees                     | 120 Degrees |
|   |  |                                |             |
| 88.   | Bearing Cap Condition Post Repair                    |                                |             |
|   | Drive End Bearing Cap                                | Opposite Drive End 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                             |                                |             |
| Assembly  |  |                                |             |
| 91.   | QC Check All Parts for Cleanliness Prior to Assembly |                                |             |
| 92.   | Photograph All Major Components prior to assembly    |                                |             |





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|   |            |            |       |
|---|------------|------------|-------|
| 93. Final Insulation Resistance Test                          |            |            |       |
| 94. Assembled Shaft Endplay                                   |            |            |       |
| 95. Assembled Shaft Runout                                    |            |            |       |
| 96. Test Run Voltage  |            |            |       |
| Volts   | Volts      | Volts      | Volts |
| 97. Test Run Amperage   |            |            |       |
| Amps  | Amps       | Amps       | Amps  |
| 98. Drive End Vibration Readings - Inches Per Second          |            |            |       |
| Horizontal  | Vertical   | Axial      |       |
| 99. Opposite Drive End Vibration Readings - Inches Per Second |            |            |       |
| Horizontal  | Vertical   | Axial      |       |
| 100. Ambient Temperature - Fahrenheit                         |            |            |       |
| 101. Drive End Bearing Temps - Fahrenheit                     |            |            |       |
| 5 Minutes   | 10 Minutes | 15 Minutes |       |
| 102. Opposite Drive End Bearing Temps - Fahrenheit            |            |            |       |
| 5 Minutes   | 10 Minutes | 15 Minutes |       |
| 103. Document Final Condition with Pictures after paint       |            |            |       |
| 104. Final Pics and QC Review                                 |            |            |       |



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10. **SEVERABILITY.** The partial or complete invalidity of any provision of these Standard Terms and Conditions shall not affect the enforceability of the remainder of these Standard Terms and Conditions. If any provision is found to be invalid or unenforceable, that portion shall be modified to make it enforceable or shall be stricken and the remainder of these Standard Terms and Conditions shall enforced.
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.