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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 102002

Prepared for HMS MFG (12553)

6901 Lindsey Road
Little Rock AR 72206

Table of Contents

AC Inspection as Found - *LR MOTOR SHOP*

AC Inspection - Rev. 2: 92000775

1.0

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

AC Inspection as Found

HMS MFG (12553)
6901 Lindsey Road
Little Rock, AR 72206

FolderID: 102002
FormID: 18187683

AC Inspection - Rev. 2

Location: LR MOTOR SHOP
Serial Number: 92000775
Description: 134KW BAUMULLER 1200RPM

Hi-Speed Job Number:	102002
Manufacturer:	Other
Product Number:	DS2-160BO54W-25-5-AOB
Serial Number:	92000775
HP/kW:	134 (kW)
RPM:	2500 (RPM)
Current:	230
Phase:	Three
Hz:	125 (Hz)
Enclosure:	DP
J-box Included:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 3 - High ● 5 - Good

Overall Condition

- | | |
|----------------------|------------|
| 1. Report Date | 10/30/2023 |
| 2. Nameplate Picture | |



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3. Photos of all six sides of the machine.



4. Describe the Overall Condition of the Equipment as Received	
<i>Clean</i>	
5. Distance from the end of the shaft to the Coupling/Sheave	0 inches
Initial Mechanical/Electrical	
6. Does Shaft Turn Freely?	(No) No
7. Does Shaft Have Visible Damage?	(No) No
8. Assembled Shaft Runout	0 Inches
9. Assembled Shaft End Play	0 inches
10. Air Gap Variation <10%	none
11. Lead Condition	(P) Pass
12. Lead Length	12 Inches
13. Lead Numbers	UVW
14. Frame Condition	good
15. Fan Condition	(N) NA
16. Broken or Missing Components	none
Initial Electrical Inspection	
17. Insulation Resistance/Megger	2000 Megohms



18. Winding Resistance			
1-2	1-3	2-3	
.029	.028	.029	
19. Perform Surge Test			(P) Pass
20. Number of Stator Slots			36

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21. Stator Condition	good
22. Stator Thermistors/Ohms	none
23. Stator Overloads/Ohms	none



Mechanical Inspection

24. Drive End Bearing Brand	
25. Drive End Bearing Number-	6313
26. Drive End Bearing Qty.	1
27. Drive End Bearing Type	(Ball) Ball Bearing
28. Drive End Lubrication Type	(Grease) Grease Lubricated
29. Drive End Bearing Insulation or Grounding Device?	none
30. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
31. Drive End Bearing Condition	fatigue
32. Opposite Drive End Bearing Brand	NSK
33. Opposite Drive End Bearing Number-	6311
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	frosting
40. Drive End Seal	none
41. Opposite Drive End Seal	none

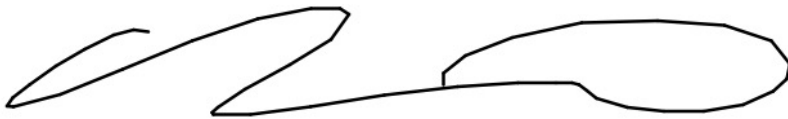
Rotor Inspection

42. Rotor Type/Material	
 Perm magnet	
43. Growler Test	(Pass) Pass
44. Number of Rotor Bars	0
45. Rotor Condition	good
46. List the Parts needed for the Repair Below	
6311, 6313, 3.5035 aegis ring	

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47. Signature of Technician that Disassembled Motor

David Maclin



Mechanical Fits- Rotor

48. Shaft Runout 0 inches

49. Rotor Runout

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0	0	0

50. Coupling Fit Closest to Bearing Housing

0 Degrees	90 Degrees	120 Degrees
0	0	0

51. Coupling Fit Closest to the end of the Shaft

0 Degrees	60 Degrees	120 Degrees
0	0	0

52. Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
2.5593	2.5593	2.5592

● 53. Drive End Bearing Shaft Fit Condition (P) Pass

54. Opposite Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
2.1657	2.1658	2.1658

● 55. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

56. Shaft Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal
ok	ok

Mechanical Fits- Bearing Housings

57. Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
5.5136	5.5137	5.5136

● 58. Drive End - Endbell Bearing Fit Condition (F) Fail

59. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
4.7253	4.7253	4.7253

■ O ring fit

● 60. Opposite Drive End - Endbell Bearing Fit Condition (P) Pass

61. Bearing Cap Condition

Drive End Bearing Cap	Opposite Drive End Bearing Cap
ok	n/a

62. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal
ok	ok

63. List Machine Work Needed Below

Sleeve DE end bell

64. Technician

David Maclin


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			
Mechanical Fits- Bearing Housings - Post Repair			
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			
Assembly			
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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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.
6. **DELIVERY SITE AND TIME FOR PERFORMANCE.** Hi-Speed and Buyer agree that time is of the essence for the purchase order and that Buyer shall fully cooperate with Hi-Speed in order to allow Hi-Speed full access to prosecute its work diligently and in an orderly manner. Buyer shall assist Hi-Speed in every way possible to avoid delaying, disrupting or interfering with the progress of Hi-Speed's work at the project site. In the event Hi-Speed's work is delayed, hindered, suspended, disrupted, re-sequenced or interfered with or rendered less efficient or more costly or adversely affected in any way as a result of acts or omissions of Buyer or other contractors or employees of Buyer or by any other reason beyond Hi-Speed's control and without the fault of Hi-Speed, then, in such event, Buyer shall be liable to Hi-Speed for any damages, additional costs, expenses, labor, materials, man hours, acceleration costs, overtime, additional jobsite overhead, extended home office overhead, and any and all other direct and indirect expenses of whatsoever nature or kind, caused in whole or in part, as a result of any of the above-referenced occurrences. Hi-Speed's project records will be the basis for computing the additional costs and damages of Hi-Speed's labor, materials, expenses and overhead related to such changes. BUYER WARRANTS THAT THE SITE FOR DELIVERY OR INSTALLATION OF ANY GOODS AND/OR FOR THE PERFORMANCE OF ANY SERVICES SHALL BE READY AND ADEQUATE FOR HI-SPEED'S DELIVERY OF GOODS AND/OR PERFORMANCE OF SERVICES AND THAT HI-SPEED SHALL HAVE FULL ACCESS THERETO, FREE OF ALL OBSTRUCTIONS. BUYER SHALL ASSUME ALL EXTRA COSTS ASSOCIATED WITH HI-SPEED'S INABILITY TO INSTALL ANY GOODS OR PERFORM ANY SERVICES AS A RESULT OF BUYER'S FAILURE TO COMPLY WITH THIS PROVISION. HI-SPEED MAY NOT INSPECT THE SITE PRIOR TO DELIVERY AND/OR INSTALLATION OF GOODS AND/OR PERFORMANCE OF SERVICES AND MAKES NO WARRANTY AS TO THE SUFFICIENCY OF THE SITE FOR THE DELIVERY AND/OR INSTALLATION OF GOODS AND/OR THE PERFORMANCE OF SERVICES AT SUCH SITE.
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8. **WARRANTIES.** Hi-Speed warrants that all goods shall conform in all material aspects to the goods identified in the quotation to Buyer and/or purchase order, and Hi-Speed makes to Buyer the manufacturer's express warranty for any goods sold to Buyer, which is offered by the manufacturer at the time of acceptance of any quotation by Buyer. This warranty is conditioned upon the installation, operation, and maintenance of the goods in accordance with the manufacturer's recommendations and/or standard industry practice and the goods at all times being operated or used under normal operating conditions for which they were designed. Hi-Speed, at its sole option, will repair or

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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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