



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

LR Motor Shop Repairs

**Job Number 100866**

Prepared for LAYNE (10766)

2015 S Main Street  
STUTT GART AR 72160

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AC Recondition As Found - *Motor Shop*

AC Recondition - Rev. 2: *R12-30721052-6T-01*

**1.0**

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

## AC Recondition As Found

LAYNE (10766)  
2015 S Main Street  
STUTTGART, AR 72160

FolderID: 100866  
FormID: 15896884


### AC Recondition - Rev. 2

Location: Motor Shop

Serial Number: R12-30721052-6T-01

Description: 250HP US MOTORS VERTICAL  
1800RPM H445TPA

Hi-Speed Job Number:	100866
Manufacturer:	US Motors/Nidec
Product Number:	HO250V2SLH-C
Serial Number:	R12-30721052-6T-01
HP/kW:	250 (HP)
RPM:	1780 (RPM)
Frame:	H445TPA
Voltage:	460
Current:	283
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	WPI
J-box Included:	Complete
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found:  7 - Good

### Overall Condition

1. Report Date
2. Nameplate Picture



3. Photos of all six sides of the machine.

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1.2



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	
8. Assembled Shaft End Play	
9. Air Gap Variation <10%	
10. Lead Condition	(P) Pass



11. Lead Length	15 Inches
12. Frame Condition	
13. Fan Condition	(N) NA
14. Broken or Missing Components	

#### Initial Electrical Inspection


15. Insulation Resistance/Megger	2000 Megohms	
16. Winding Resistance		
1-2	1-3	2-3
17. Perform Surge Test	(P) Pass	
18. Number of Stator Slots	72 Megohms	
19. Stator Condition		

#### Mechanical Inspection

20. Drive End Bearing Brand	FAG
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21. Drive End Bearing Number-	7322B
22. Drive End Bearing Qty.	1
23. Drive End Bearing Type	(Thrust) Thrust
24. Drive End Lubrication Type	(Oil) Oil Lubricated
25. Drive End Bearing Insulation or Grounding Device?	
26. Drive End Wavy Washer/Snap-Ring Other Retention Device?	
27. Drive End Bearing Condition	worn
<div>  <i>Balls have been dragging, outer race is worn and has a dent in it.</i> </div>	



28. Opposite Drive End Bearing Brand	Peer
29. Opposite Drive End Bearing Number-	6215



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30. Opposite Drive End Bearing Qty.	1
31. Opposite Drive End Bearing Type	(Ball) Ball Bearing
32. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
33. Opposite Drive End Bearing Insulation or Grounding Device?	
34. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring and spacer
35. Opposite Drive End Bearing Condition	worn
36. Drive End Seal	
37. Opposite Drive End Seal	
<b>Rotor Inspection</b>	
38. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
39. Growler Test	(Pass) Pass
40. Number of Rotor Bars	
41. Rotor Condition	
42. List the Parts needed for the Repair Below	
6215 7322B	
43. Signature of Technician that Disassembled Motor	Trevor Hall
	
<b>Mechanical Fits- Rotor</b>	
44. Shaft Runout	
45. Rotor Runout	
Drive End Bearing Fit	Rotor Body
Opposite Drive End Bearing	
46. Coupling Fit Closest to Bearing Housing	
0 Degrees	90 Degrees
120 Degrees	
47. Coupling Fit Closest to the end of the Shaft	
0 Degrees	60 Degrees
120 Degrees	



48. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
4.3318	4.3318	4.3317



49.	Drive End Bearing Shaft Fit Condition	(P) Pass	
50.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	2.9533	2.9531	2.9532
51.	Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	
52.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings			
53.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	9.4498	9.4498	9.4498
54.	Drive End - Endbell Bearing Fit Condition	(P) Pass	
55.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	5.1187	5.1187	5.1186
56.	Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass	

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## 57. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap



## 58. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

## 59. List Machine Work Needed Below

## 60. Technician

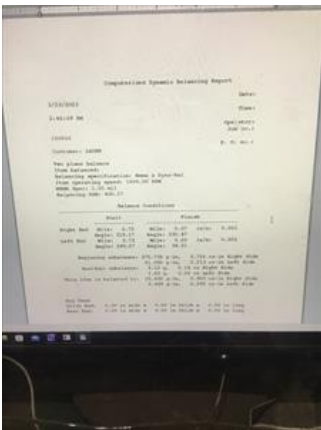
Trevor Hall

## Dynamic Balance Report

## 61. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



## 62. Initial Balance Readings

Drive End

Opposite Drive End

0.75

2.73

## 63. Final Balance Readings

Drive End

Opposite Drive End

.07

.25

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64. Technician

RW


**Rewind**

65. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

66. Core Hot Spot Test

Pre-Burnout

Post-Burnout

67. Post Rewind Electrical Test- Insulation Resistance

68. Post Rewind Polarization Index

69. Post Rewind Winding Resistance

1-2

1-3

2-3

70. Post Rewind Surge Test

71. Post Rewind Hi-Pot

72. Technician

**Root Cause of Failure**

73. Failure locations

74. Root cause of failure

**Mechanical Fits- Rotor - Post Repair**

75. Shaft Runout Post Repair

76. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

77. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

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

0 Degrees

60 Degrees

120 Degrees

79. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

80. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

81. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

82. Shaft Repair Sign-off

**Mechanical Fits- Bearing Housings - Post Repair**

83. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

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84. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
85. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
86. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
87. End Bell Repair Sign-off		
<b>Assembly</b>		
88. Photograph All Major Components prior to assembly		





89. Final Insulation Resistance Test		
90. Assembled Shaft Endplay		
91. Assembled Shaft Runout		
92. Test Run Voltage		
Volts	Volts	Volts
457	456	456

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### 93. Test Run Amperage

Amps	Amps	Amps
83.5	84.90000000000001	83.3



### 94. Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
0.02	0.02	

### 95. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
0.04	0.02	

### 96. Ambient Temperature - Fahrenheit

### 97. Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes

### 98. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes

### 99. QC Check All Parts for Cleanliness Prior to Assembly

### 100. Document Final Condition with Pictures after paint



101. Final Pics and QC Review

RW

RW



## STANDARD TERMS AND CONDITIONS FOR PURCHASE OF GOOD AND/OR SERVICES

1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
2. **PRICE.** All quoted prices shall remain firm and binding for a period of thirty (30) days from the date of quotation or for the period specifically stated in the quotation. The price for any and all goods and/or services ordered or approved by Buyer after thirty (30) days from the date of any quotation are subject to any increase in price that may occur after the expiration of thirty (30) days from the issuance of the quotation and the date the Buyer releases any shipment.
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.
4. **BILLING AND PAYMENT TERMS.** Hi-Speed shall invoice Buyer for all goods and/or services as same are rendered at the address listed on the quotation. Payments for all goods and/or services shall be due thirty (30) days from the date of the current invoice or as otherwise set forth in the quotation. Late payments are subject to a late fee of 5% of the total invoice amount. Recurring late payments may lead to a deposit requirement on future services or sale of goods. Buyer shall be liable to Hi-Speed for any and all fees and expenses incurred by Hi-Speed to collect any invoices or to enforce these Standard Terms and Conditions, including but not limited to, attorney's fees.
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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