



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

LR Motor Shop Repairs

**Job Number 101000**

Prepared for Reynolds Metals company

1333 highway 270  
Malvern AR 72104

# Table of Contents



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

## AC Recondition As Found

Reynolds Metals company

1333 highway 270

Malvern, AR 72104

FolderID: 101000

FormID: 16060866

### AC Recondition - Rev. 2

**Location:** Shop  
**Serial Number:** CE1020287-702 89-05001  
**Description:** 100HP US MOTORS 1800RPM 405TS

<b>Hi-Speed Job Number:</b>	101000
<b>Manufacturer:</b>	US Motors/Nidec
<b>Serial Number:</b>	CE1020287-702 89-05001
<b>HP/kW:</b>	100 (HP)
<b>RPM:</b>	1780 (RPM)
<b>Frame:</b>	405TS
<b>Voltage:</b>	460
<b>Current:</b>	118
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b>Service Factor:</b>	1.15
<b>Enclosure:</b>	TEFC
<b>J-box Included:</b>	Complete
<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: ● 3 - 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	
5.	Distance from the end of the shaft to the Coupling/Sheave	
<b>Initial Mechanical/Electrical</b>		
● 6.	Does Shaft Turn Freely?	<b>(Yes) Yes</b>
7.	Does Shaft Have Visible Damage?	<b>(No) No</b>
● 8.	Assembled Shaft Runout	<b>0.0015 Inches</b>
9.	Assembled Shaft End Play	
10.	Air Gap Variation <10%	
● 11.	Lead Condition	<b>(P) Pass</b>



12.	Lead Length	<b>10 Inches</b>
13.	Frame Condition	<b>pass</b>

14. Fan Condition	(F) Fail
Replace	



15. Broken or Missing Components		
Initial Electrical Inspection		
16. Insulation Resistance/Megger		18174 Megohms
17. Winding Resistance		
1-2	1-3	2-3
0.0505	0.0505	0.0504
	18. Perform Surge Test (P) Pass	



19. Number of Stator Slots	72 Megohms
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20. Stator Condition

wash and bake



### Mechanical Inspection

21. Drive End Bearing Brand

Nachi



22. Drive End Bearing Number-	6214
23. Drive End Bearing Qty.	1
24. Drive End Bearing Type	(Ball) Ball Bearing
25. Drive End Lubrication Type	(Grease) Grease Lubricated
26. Drive End Bearing Insulation or Grounding Device?	na
27. Drive End Wavy Washer/Snap-Ring Other Retention Device?	na

28. Drive End Bearing Condition

**Fluted**



29. Opposite Drive End Bearing Brand

**Nachi**

30. Opposite Drive End Bearing Number-

**6214**



31. Opposite Drive End Bearing Qty.

**1**

32. Opposite Drive End Bearing Type

**(Ball) Ball Bearing**

33. Opposite Drive End Lubrication Type

**(Grease) Grease Lubricated**

34. Opposite Drive End Bearing Insulation or Grounding Device?

**na**

35. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?

**na**

36. Opposite Drive End Bearing Condition

**Frosted**



37. Drive End Seal

**na**

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38. Opposite Drive End Seal	na
<b>Rotor Inspection</b>	
39. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast



40. Growler Test	(Pass) Pass
41. Number of Rotor Bars	
42. Rotor Condition	wash
43. List the Parts needed for the Repair Below 2 6214 Bearing	
44. Signature of Technician that Disassembled Motor	RW

*[Handwritten signature: RW]*

#### Mechanical Fits- Rotor

45. Shaft Runout		
46. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
47. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
48. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
49. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.7559	2.7559	2.7559

50. Drive End Bearing Shaft Fit Condition

(P) Pass



51. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.7563

2.7563

2.7563

52. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass



53. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

### Mechanical Fits- Bearing Housings

54. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

4.9217

4.9217

4.9217

55. Drive End - Endbell Bearing Fit Condition

(P) Pass



56. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

57. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail

Resleeve paint and Grooved



58. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass

pass

59. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

60. List Machine Work Needed Below

Ode end bell housing fit bad.fan cover bolts broke in end bell

61. Technician

RW

24

## Dynamic Balance Report

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62. Rotor Weight and Balance Grade			
Rotor Weight	Balance Grade		
63. Initial Balance Readings			
Drive End	Opposite Drive End		
64. Final Balance Readings			
Drive End	Opposite Drive End		
65. Technician			
<b>Rewind</b>			
66. Core Test Results - Watts loss per Pound			
Pre-Burnout	Post Burnout		
67. Core Hot Spot Test			
Pre-Burnout	Post-Burnout		
68. Post Rewind Electrical Test- Insulation Resistance			
69. Post Rewind Polarization Index			
70. Post Rewind Winding Resistance			
1-2	1-3	2-3	
71. Post Rewind Surge Test			
72. Post Rewind Hi-Pot			
73. Technician			
<b>Root Cause of Failure</b>			
74. Failure locations			
75. Root cause of failure			
<b>Mechanical Fits- Rotor - Post Repair</b>			
76. Shaft Runout Post Repair			
77. Rotor Runout Post Repair			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
78. Coupling Fit Closest to Bearing Housing Post Repair			
0 Degrees	90 Degrees	120 Degrees	
79. Coupling Fit Closest to the end of the Shaft Post Repair			
0 Degrees	60 Degrees	120 Degrees	
80. Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
81. Opposite Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
82. Shaft Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
83. Shaft Repair Sign-off			

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

84. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

85. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

86. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

87. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

88. End Bell Repair Sign-off

**Assembly**

89. Photograph All Major Components prior to assembly

90. Final Insulation Resistance Test

91. Assembled Shaft Endplay

92. Assembled Shaft Runout

93. Test Run Voltage

Volts

Volts

Volts

94. Test Run Amperage

Amps

Amps

Amps

95. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

96. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

97. Ambient Temperature - Fahrenheit

98. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

99. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

100. QC Check All Parts for Cleanliness Prior to Assembly

101. Document Final Condition with Pictures after paint

102. Final Pics and QC Review



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