



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

LR Motor Shop Repairs

**Job Number 102134**

Prepared for Reynolds Metals company

1333 highway 270  
Malvern AR 72104

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AC Inspection as Found - *Shop*

AC Inspection - Rev. 2

**1.0**

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

## AC Inspection as Found

Reynolds Metals company

1333 highway 270

Malvern, AR 72104

FolderID: 102134

FormID: 18546997

### AC Inspection - Rev. 2

Location: Shop

Serial Number:

Description: 100 hp

Hi-Speed Job Number: 102134

Manufacturer: Siemens

Product Number: 7-5106-13633-1-2

HP/kW: 100 (HP)

RPM: 1770 (RPM)

Frame: 405TS

Voltage: 460

Current: 112

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

# of Leads: 3

J-box Included: None

Coupling/Sheave: None

Date Received: 11/27/2023

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Shaft Machined Fit Repairs  
Required: Yes

Bearing Housing Machined  
Fit Repairs Required: Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 5 - High

● 2 - Good

### Overall Condition

1. Report Date

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1.0

## 2. Nameplate Picture



## 3. Photos of all six sides of the machine.











4. Describe the Overall Condition of the Equipment as Received

*Serviceable*

#### Initial Mechanical/Electrical

●	5. Does Shaft Turn Freely?	(No) No
	6. Does Shaft Have Visible Damage?	(No) No
	7. Assembled Shaft Runout	Inches
■	<i>Shaft will not rotate.</i>	
	8. Assembled Shaft End Play	inches
	9. Air Gap Variation <10%	
●	10. Lead Condition	(F) Fail
■	<i>Insulation cracked and worn</i>	



11. Lead Length

7 Inches

 *Lugged*



12. Lead Numbers

1-3

13. Frame Condition

pass

14. Fan Condition

(P) Pass



15. Broken or Missing Components

no connection box

### Initial Electrical Inspection

16. Insulation Resistance/Megger

Megohms

17. Winding Resistance

1-2

1-3

2-3



18. Perform Surge Test

(F) Fail



19. Number of Stator Slots	60
20. Stator Condition	rewind
21. Stator Thermistors/Ohms	
22. Stator Overloads/Ohms	
<b>Mechanical Inspection</b>	
23. Drive End Bearing Brand	unreadable
24. Drive End Bearing Number-	6313
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?	none
29. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none

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31. Opposite Drive End Bearing Brand

unreadable

32. Opposite Drive End Bearing Number-

6313

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?	<b>none</b>
37. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>none</b>
38. Opposite Drive End Bearing Condition	<b>replace.</b>
39. Drive End Seal	
40. Opposite Drive End Seal	

#### Rotor Inspection

41. Rotor Type/Material

**(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast**



42. Growler Test	<b>(Pass) Pass</b>
43. Number of Rotor Bars	<b>46</b>
44. Rotor Condition	<b>pass</b>
45. List the Parts needed for the Repair Below	
46. Signature of Technician that Disassembled Motor	<b>Terrence Holland</b>

#### Mechanical Fits- Rotor

47. Shaft Runout	0.002 inches		
48. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	

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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	
2.5596	2.5596	2.5597	
52. Drive End Bearing Shaft Fit Condition			(P) Pass
53. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.5593	2.5594	2.5594	
54. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
55. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
needs polishing			
<b>Mechanical Fits- Bearing Housings</b>			
56. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
Bad from excessive wear.			
57. Drive End - Endbell Bearing Fit Condition			(F) Fail



58. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
Failed due to excessive wear.			

59. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail



60. Bearing Cap Condition

Drive End Bearing Cap  
pass

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

*Sleeve both end bell housing fits. Repair O.D.E shaft bearing journal. Polish rough shaft seal area on DE.*

63. Technician

Terrence Holland

#### Root Cause of Failure

64. Failure locations

*D.E bearing cage failed, due to excessive grease contamination on both bearings.*

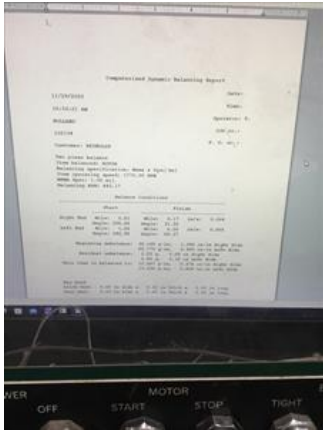
65. Root cause of failure

*Contaminated grease caused D.E bearing cage to fail.*

#### Dynamic Balance Report

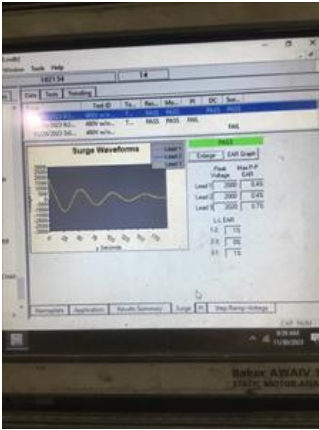


66. Rotor Weight and Balance Grade	
Rotor Weight	Balance Grade
67. Initial Balance Readings	
Drive End	Opposite Drive End



68.	Final Balance Readings		
	Drive End	Opposite Drive End	
69.	Technician		
Rewind			
70.	Core Test Results - Watts loss per Pound		
	Pre-Burnout	Post Burnout	
	Na		
71.	Core Hot Spot Test		
	Pre-Burnout	Post-Burnout	
	pass	pass	
72.	Post Rewind Electrical Test- Insulation Resistance		118959 Megohms
73.	Post Rewind Polarization Index		Polarization Index
	Na		
74.	Post Rewind Winding Resistance		
	1-2	1-3	2-3
	.0620	0.0631	0.0631

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76. Post Rewind Hi-Pot

0.0167 micro-amps

77. Technician

RW

RHR



### 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

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			
<b>Mechanical Fits- Bearing Housings - Post Repair</b>			
86. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
5.5122	55.5122	5.5122	



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			<b>Gary</b>
			
<b>Assembly</b>			
91. QC Check All Parts for Cleanliness Prior to Assembly			<b>Cw</b>
			
92. Photograph All Major Components prior to assembly			<b>(Complete) Complete</b>

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93. Final Insulation Resistance Test	Megohms	
Na		
94. Assembled Shaft Endplay	inches	
Na		
95. Assembled Shaft Runout	inches	
0.002		
96. Test Run Voltage		
Volts	Volts	Volts
Lead test in pictures		



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## Load test



## Load test

97. Test Run Amperage

Amps

Amps

Amps

In pictures



## Load test

98. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.09

0.02

0.03

99. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.07000000000000001

0.05

0.02

100. Ambient Temperature - Fahrenheit

Na

101. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

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102. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

103. Document Final Condition with Pictures after paint

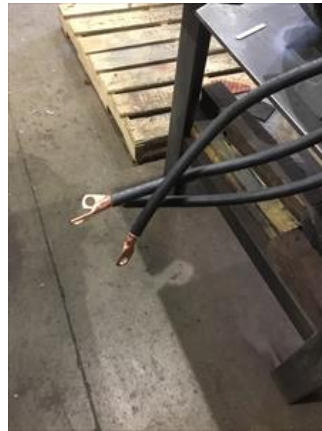


104. Final Pics and QC Review

Cw

A handwritten signature in black ink, appearing to be 'Cw', is written across the page.

Co Sign: DM





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