



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

LR Motor Shop Repairs

**Job Number 100036**

Prepared for Twin Rivers

1701 Jefferson Parkway  
White Hall AR 71602

# Table of Contents

AC Recondition As Found - *MOTOR SHOP LR*

AC Recondition - Rev. 2: 7K015641210836

1.0

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

## AC Recondition As Found

### Twin Rivers

1701 Jefferson Parkway  
White Hall, AR 71602

FolderID: 100036  
FormID: 14048168

#### AC Recondition - Rev. 2

Location: MOTOR SHOP LR  
Serial Number: 7K015641210836  
Description: 100HP SIEMENS 1200RPM 444T

|  |                 |
|--|-----------------|
| Hi-Speed Job Number:                           | 100036          |
| Manufacturer:                                  | Siemens         |
| Product Number:                                | 1LA04446S041    |
| Serial Number:                                 | 7K015641210836  |
| HP/kW:   | 100 (HP)        |
| RPM:   | 1185 (RPM)      |
| Frame:   | 444T            |
| Voltage:                                       | 460             |
| Current:                                       | 114             |
| Phase:   | Three           |
| Hz:  | 60 (Hz)         |
| Service Factor:                                | 1.15            |
| Enclosure:                                     | TEFC            |
| J-box Included:                                | None            |
| Coupling/Sheave:                               | None            |
| Date Received:                                 | 07/11/2022      |
| 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: ● 2 - High ● 5 - Good

#### Overall Condition

|                      |           |
|----------------------|-----------|
| 1. Report Date       | 7/15/2022 |
| 2. Nameplate Picture |           |

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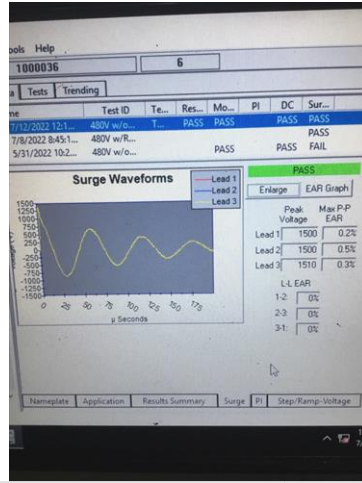
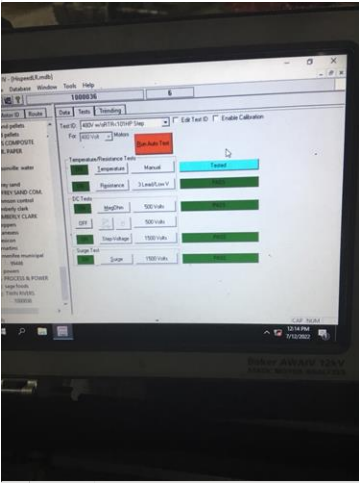
|  |                                 |                |
|--|---------------------------------|----------------|
| 3. Describe the Overall Condition of the Equipment as Received |                                 |                |
| 4. Photos of all six sides of the machine.                     |                                 |                |
| 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                  |                |
| 11.  | Lead Length                     |                |
| 12.  | Frame Condition                 | Pass           |
| 13.  | Fan Condition                   | (P) Pass       |
| 14.  | Broken or Missing Components    |                |
| Initial Electrical Inspection                                  |                                 |                |
| 15.  | Insulation Resistance/Megger    | 20,897 Megohms |
| 16.  | Winding Resistance              |                |
| 1-2  | 1-3                             | 2-3            |
| 0.0945   | 0.0945                          | 0.0945         |

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17. Perform Surge Test

(P) Pass



18. Stator Condition

wash and bake



- 19. Number of Stator Slots
- 20. Stator Thermistors/Ohms
- 21. Stator Overloads/Ohms

Mechanical Inspection

22. Drive End Bearing Number-

6318

Found frosting and cut marks in race



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?

no

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

snap ring



28. Drive End Bearing Condition

29. Opposite Drive End Bearing Number-

6316

Frosted also cut marks in races needs aegis ring installed

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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?       | no                         |
| 34. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? | wavy washer                |



|  |    |
|--|----|
| 35. Opposite Drive End Bearing Condition |    |
| 36. Drive End Seal                       | no |
| 37. Opposite Drive End Seal              | no |
| 38. Drive End Bearing Brand              |    |
| 39. Opposite Drive End Bearing Brand     |    |

Rotor Inspection



## 40. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast

41. Growler Test (Pass) Pass

42. Number of Rotor Bars 54

43. Rotor Condition wash and bake

44. List the Parts needed for the Repair Below

6318, 6316, aegis ring

45. Signature of Technician that Disassembled Motor

**Mechanical Fits- Rotor**

46. Shaft Runout

47. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

48. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

49. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

50. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.5434

3.5434


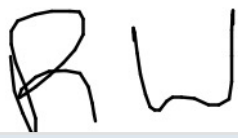
3.5434

51. Drive End Bearing Shaft Fit Condition

(P) Pass



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|   |                                |             |          |
|---|--------------------------------|-------------|----------|
| 52. Opposite Drive End Bearing Shaft Fit  |                                |             |          |
| 0 Degrees   | 60 Degrees                     | 120 Degrees |          |
| 3.1498  | 3.1498                         | 3.1499      |          |
| 53. Opposite Drive End Bearing Shaft Fit Condition                                  |                                |             | (F) Fail |
|     |                                |             |          |
| 54. Shaft Air Seal Fits   |                                |             |          |
| Drive End Air Seal  | Opposite Drive End Air Seal    |             |          |
| <b>Mechanical Fits- Bearing Housings</b>  |                                |             |          |
| 55. Drive End - Endbell Bearing Fit   |                                |             |          |
| 0 Degrees   | 60 Degrees                     | 120 Degrees |          |
| 7.4813  | 7.4813                         | 7.4813      |          |
| 56. Drive End - Endbell Bearing Fit Condition                                       |                                |             | (P) Pass |
| 57. Opposite Drive End - Endbell Bearing Fit  |                                |             |          |
| 0 Degrees   | 60 Degrees                     | 120 Degrees |          |
| 6.6942  | 6.6942                         | 6.6942      |          |
| 58. Opposite Drive End - Endbell Bearing Fit Condition                              |                                |             | (F) Fail |
| 59. Bearing Cap Condition   |                                |             |          |
| Drive End Bearing Cap   | Opposite Drive End Bearing Cap |             |          |
| pass  | pass                           |             |          |
| 60. End Bell Air Seal Fits  |                                |             |          |
| Drive End Air Seal  | Opposite Drive End Air Seal    |             |          |
| 61. List Machine Work Needed Below  |                                |             |          |
| <i>Ode shaft bearing fit and Ode end bell housing fit bad</i>                       |                                |             |          |
| 62. Technician  |                                |             | RW       |
|  |                                |             |          |

### Dynamic Balance Report

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## 63. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



## 64. Initial Balance Readings

Drive End

Opposite Drive End

0.65

0.71

## 65. Final Balance Readings

Drive End

Opposite Drive End

0.12

0.07

## 66. Technician

RW

## Rewind

## 67. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

## 68. Core Hot Spot Test

Pre-Burnout

Post-Burnout

## 69. Post Rewind Electrical Test- Insulation Resistance

## 70. Post Rewind Polarization Index

## 71. Post Rewind Winding Resistance

1-2

1-3

2-3

## 72. Post Rewind Surge Test

## 73. Post Rewind Hi-Pot

## 74. Technician

## Root Cause of Failure

## 75. Failure locations

*Bearings should signs of frosting they also had cuts in the races*

## 76. Root cause of failure

## Mechanical Fits- Rotor - Post Repair

## 77. Shaft Runout Post Repair

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|  |                             |                            |
|--|-----------------------------|----------------------------|
| 78. Rotor Runout Post Repair   |                             |                            |
| Drive End Bearing Fit  | Rotor Body                  | Opposite Drive End Bearing |
| 79. Coupling Fit Closest to Bearing Housing Post Repair  |                             |                            |
| 0 Degrees  | 90 Degrees                  | 120 Degrees                |
| 80. Coupling Fit Closest to the end of the Shaft Post Repair   |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 81. Drive End Bearing Shaft Fit Post Repair  |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 82. Opposite Drive End Bearing Shaft Fit Post Repair   |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 83. Shaft Air Seal Fits Post Repair  |                             |                            |
| Drive End Air Seal   | Opposite Drive End Air Seal |                            |
| 84. Shaft Repair Sign-off  |                             |                            |
| <b>Mechanical Fits- Bearing Housings - Post Repair</b>   |                             |                            |
| 85. Drive End - Endbell Bearing Fit Post Repair  |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 86. Opposite Drive End - Endbell Bearing Fit Post Repair   |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| <b>6.6931</b>  | <b>6.6931</b>               | <b>6.6932</b>              |
|  <i>Installed Agis ring on inner bearing cap.</i> |                             |                            |



|  |                                |  |
|--|--------------------------------|--|
| 87. Bearing Cap Condition Post Repair  |                                |  |
| Drive End Bearing Cap                  | Opposite Drive End Bearing Cap |  |
| 88. End Bell Air Seal Fits Post Repair |                                |  |
| Drive End Air Seal                     | Opposite Drive End Air Seal    |  |

**Assembly**

90. QC Check All Parts for Cleanliness Prior to Assembly

91. Photograph All Major Components prior to assembly







|                                      |       |  |       |
|--------------------------------------|-------|--|-------|
| 92. Final Insulation Resistance Test |       |  |       |
| 93. Assembled Shaft Endplay          |       |  |       |
| 94. Assembled Shaft Runout           |       |  |       |
| 95. Test Run Voltage                 |       |  |       |
| Volts                                | Volts |  | Volts |
| 458                                  | 458   |  | 458   |




|                       |      |  |      |
|-----------------------|------|--|------|
| 96. Test Run Amperage |      |  |      |
| Amps                  | Amps |  | Amps |
| 29.5                  | 29.6 |  | 30.3 |



|   |            |            |
|---|------------|------------|
| 97. Drive End Vibration Readings - Inches Per Second          |            |            |
| Horizontal  | Vertical   | Axial      |
| 98. Opposite Drive End Vibration Readings - Inches Per Second |            |            |
| Horizontal  | Vertical   | Axial      |
| 99. Ambient Temperature - Fahrenheit                          |            |            |
| 100. Drive End Bearing Temps - Fahrenheit                     |            |            |
| 5 Minutes   | 10 Minutes | 15 Minutes |
| 101. Opposite Drive End Bearing Temps - Fahrenheit            |            |            |
| 5 Minutes   | 10 Minutes | 15 Minutes |
| 102. Document Final Condition with Pictures after paint       |            |            |



|   |    |
|---|----|
| 103. Final Pics and QC Review   | RW |
|  |    |



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