



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

LR Motor Shop Repairs

**Job Number 101711**

Prepared for Twin Rivers

1701 Jefferson Parkway  
White Hall AR 71602

# Table of Contents



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

## AC Inspection as Found

### Twin Rivers

1701 Jefferson Parkway  
White Hall, AR 71602

FolderID: 101711  
FormID: 17555953

#### AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: 200 HP WORLD WIDE

Hi-Speed Job Number: 101711

Manufacturer: Other

HP/kW: 200 (HP)

RPM: 1790 (RPM)

Frame: 145/7

Voltage: 230 / 460

Current: 458/229

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.25

Enclosure: TEFC

# of Leads: 12

J-box Included: None

Coupling/Sheave: None

Date Received: 08/08/2023

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Heaters: No

Priorities Found: ● 5 - 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

*Dirty*

#### Initial Mechanical/Electrical

|   |                                    |              |
|---|------------------------------------|--------------|
| ● | 5. Does Shaft Turn Freely?         | (Yes) Yes    |
|   | 6. Does Shaft Have Visible Damage? | (No) No      |
| ● | 7. Assembled Shaft Runout          | 0.002 Inches |
|   | 8. Assembled Shaft End Play        |              |
|   | 9. Air Gap Variation <10%          |              |
| ● | 10. Lead Condition                 | (P) Pass     |



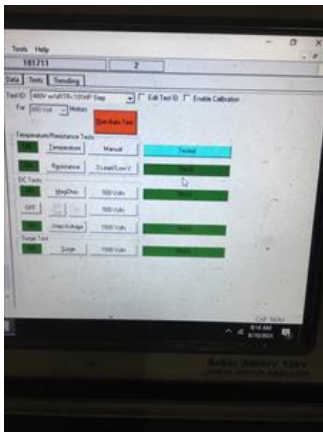
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|                     |           |
|---------------------|-----------|
| 11. Lead Length     | 18 Inches |
| 12. Lead Numbers    | T1-T12    |
| 13. Frame Condition | pass      |
| ● 14. Fan Condition | (P) Pass  |



|                                      |          |
|--------------------------------------|----------|
| 15. Broken or Missing Components     | j-box    |
| <b>Initial Electrical Inspection</b> |          |
| 16. Insulation Resistance/Megger     |          |
| 17. Winding Resistance               |          |
| 1-2                                  | 1-3 2-3  |
| ● 18. Perform Surge Test             | (P) Pass |



|                              |         |
|------------------------------|---------|
| 19. Number of Stator Slots   | Megohms |
| 48                           |         |
| 20. Stator Condition         | pass    |
| 21. Stator Thermistors/Ohms  | na      |
| 22. Stator Overloads/Ohms    | na      |
| <b>Mechanical Inspection</b> |         |


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|  |   |
|--|---|
| 24. Drive End Bearing Number-  | <b>NU319</b>                                |
| 25. Drive End Bearing Qty.   | <b>1</b>                                    |
| 26. Drive End Bearing Type   | <b>(Roller) Roller Bearing</b>              |
| 27. Drive End Lubrication Type                                       | <b>(Grease) Grease Lubricated</b>           |
| 28. Drive End Bearing Insulation or Grounding Device?                | <b>na</b>                                   |
| 29. Drive End Wavy Washer/Snap-Ring Other Retention Device?          | <b>na</b>                                   |
| 30. Drive End Bearing Condition                                      | <b>signs of chemical burns and skidding</b> |
| 31. Opposite Drive End Bearing Brand                                 | <b>FAG</b>                                  |
| 32. Opposite Drive End Bearing Number-                               | <b>6313</b>                                 |
| 33. Opposite Drive End Bearing Qty.                                  | <b>1</b>                                    |
| 34. Opposite Drive End Bearing Type                                  | <b>(Ball) Ball Bearing</b>                  |
| 35. Opposite Drive End Lubrication Type                              | <b>(Grease) Grease Lubricated</b>           |
| 36. Opposite Drive End Bearing Insulation or Grounding Device?       | <b>na</b>                                   |
| 37. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? | <b>snap ring</b>                            |
| 38. Opposite Drive End Bearing Condition                             | <b>wear</b>                                 |



|                                       |             |             |                |
|---------------------------------------|-------------|-------------|----------------|
| 39. Drive End Seal                    |             |             | <b>slinger</b> |
| 40. Opposite Drive End Seal           |             |             | <b>slinger</b> |
| 41. DE Sleeve Bearing Inside Diameter |             |             |                |
| 0 degrees                             | 120 degrees | 240 degrees |                |

|   |   |                            |             |
|---|---|----------------------------|-------------|
| 42. DE Sleeve Bearing Outside Diameter              | 0 degrees   | 120 degrees                | 240 degrees |
| 43. DE Sleeve Bearing Housing Inside Diameter       | 0 degrees   | 120 degrees                | 240 degrees |
| 44. DE Sleeve Bearing to Housing Clearance          | 0 degrees   | 120 degrees                | 240 degrees |
| 45. ODE Sleeve Bearing Inside Diameter              | 0 degrees   | 120 degrees                | 240 degrees |
| 46. ODE Sleeve Bearing Outside Diameter             | 0 degrees   | 120 degrees                | 240 degrees |
| 47. ODE Sleeve Bearing Housing Inside Diameter      | 0 degrees   | 120 degrees                | 240 degrees |
| 48. ODE Sleeve Bearing to Housing Clearance         | 0 degrees   | 120 degrees                | 240 degrees |
| <b>Rotor Inspection</b>                             |   |                            |             |
| 49. Rotor Type/Material                             | (Squirrel Aluminum) Squirrel<br>Cage Aluminum Die Cast                              |                            |             |
| 50. Growler Test                                    | (Pass) Pass   |                            |             |
| 51. Number of Rotor Bars                            | 40  |                            |             |
| 52. Rotor Condition                                 | pass  |                            |             |
| 53. List the Parts needed for the Repair Below      | <p><i>J-box</i><br/><i>NU319</i><br/><i>6313</i></p>                                |                            |             |
| 54. Signature of Technician that Disassembled Motor |  |                            |             |
| <b>Mechanical Fits- Rotor</b>                       |   |                            |             |
| 55. Shaft Runout                                    | 0.002 inches  |                            |             |
| 56. Rotor Runout                                    |   |                            |             |
| Drive End Bearing Fit                               | Rotor Body  | Opposite Drive End Bearing |             |
| 57. Coupling Fit Closest to Bearing Housing         | 0 Degrees   | 90 Degrees                 | 120 Degrees |
| 58. Coupling Fit Closest to the end of the Shaft    | 0 Degrees   | 60 Degrees                 | 120 Degrees |

|   |   |                                |             |
|---|---|--------------------------------|-------------|
| 59.   | Drive End Bearing Shaft Fit   |                                |             |
|   | 0 Degrees   | 60 Degrees                     | 120 Degrees |
|   | 3.7418  | 3.7419                         | 3.7419      |
| 60.   | Drive End Bearing Shaft Fit Condition                               |                                | (P) Pass    |
| 61.   | Opposite Drive End Bearing Shaft Fit                                |                                |             |
|   | 0 Degrees   | 60 Degrees                     | 120 Degrees |
|   | 2.5595  | 2.5596                         | 2.5597      |
| 62.   | Opposite Drive End Bearing Shaft Fit Condition                      |                                | (P) Pass    |
| 63.   | Shaft Air Seal Fits   |                                |             |
|   | Drive End Air Seal  | Opposite Drive End Air Seal    |             |
| <b>Mechanical Fits- Bearing Housings</b>  |   |                                |             |
| 64.   | Drive End - Endbell Bearing Fit                                     |                                |             |
|   | 0 Degrees   | 60 Degrees                     | 120 Degrees |
|   | 7.8751  | 7.8756                         | 7.8756      |
| 65.   | Drive End - Endbell Bearing Fit Condition                           |                                | (F) Fail    |
| 66.   | Opposite Drive End - Endbell Bearing Fit                            |                                |             |
|   | 0 Degrees   | 60 Degrees                     | 120 Degrees |
|   | 5.5125  | 5.5132                         | 5.5133      |
| 67.   | Opposite Drive End - Endbell Bearing Fit Condition                  |                                | (F) Fail    |
| 68.   | Bearing Cap Condition   |                                |             |
|   | Drive End Bearing Cap   | Opposite Drive End Bearing Cap |             |
|   | Pass  |                                |             |
| 69.   | End Bell Air Seal Fits  |                                |             |
|   | Drive End Air Seal  | Opposite Drive End Air Seal    |             |
| 70.   | List Machine Work Needed Below<br><i>Both end bell bearing fits</i> |                                |             |
| 71.   | Technician  |                                | Cw          |
|  |   |                                |             |
| <b>Dynamic Balance Report</b>   |   |                                |             |
| 72.   | Rotor Weight and Balance Grade                                      |                                |             |
|   | Rotor Weight  | Balance Grade                  |             |
| 73.   | Initial Balance Readings  |                                |             |
|   | Drive End   | Opposite Drive End             |             |
| 74.   | Final Balance Readings  |                                |             |
|   | Drive End   | Opposite Drive End             |             |
| 75.   | Technician  |                                |             |
| <b>Rewind</b>   |   |                                |             |



|  |                             |                            |
|--|-----------------------------|----------------------------|
| 76. Core Test Results - Watts loss per Pound                 |                             |                            |
| Pre-Burnout  | Post Burnout                |                            |
| 77. Core Hot Spot Test                                       |                             |                            |
| Pre-Burnout  | Post-Burnout                |                            |
| 78. Post Rewind Electrical Test- Insulation Resistance       |                             |                            |
| 79. Post Rewind Polarization Index                           |                             |                            |
| 80. Post Rewind Winding Resistance                           |                             |                            |
| 1-2  | 1-3                         | 2-3                        |
| 81. Post Rewind Surge Test                                   |                             |                            |
| 82. Post Rewind Hi-Pot                                       |                             |                            |
| 83. Technician   |                             |                            |
| <b>Root Cause of Failure</b>                                 |                             |                            |
| 84. Failure locations  |                             |                            |
| <i>Bearings and both end bell bearing fits are oversized</i> |                             |                            |
| 85. Root cause of failure                                    |                             |                            |
| <i>Wear</i>  |                             |                            |
| <b>Mechanical Fits- Rotor - Post Repair</b>                  |                             |                            |
| 86. Shaft Runout Post Repair                                 |                             |                            |
| 87. Rotor Runout Post Repair                                 |                             |                            |
| Drive End Bearing Fit  | Rotor Body                  | Opposite Drive End Bearing |
| 88. Coupling Fit Closest to Bearing Housing Post Repair      |                             |                            |
| 0 Degrees  | 90 Degrees                  | 120 Degrees                |
| 89. Coupling Fit Closest to the end of the Shaft Post Repair |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 90. Drive End Bearing Shaft Fit Post Repair                  |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 91. Opposite Drive End Bearing Shaft Fit Post Repair         |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 92. Shaft Air Seal Fits Post Repair                          |                             |                            |
| Drive End Air Seal   | Opposite Drive End Air Seal |                            |
| 93. Shaft Repair Sign-off                                    |                             |                            |
| <b>Mechanical Fits- Bearing Housings - Post Repair</b>       |                             |                            |
| 94. Drive End - Endbell Bearing Fit Post Repair              |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 95. Opposite Drive End - Endbell Bearing Fit Post Repair     |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |

|  |                                |           |
|--|--------------------------------|-----------|
| 96. Bearing Cap Condition Post Repair                          |                                |           |
| Drive End Bearing Cap  | Opposite Drive End Bearing Cap |           |
| 97. End Bell Air Seal Fits Post Repair                         |                                |           |
| Drive End Air Seal   | Opposite Drive End Air Seal    |           |
| 98. DE Sleeve Bearing Inside ID Post Repair                    |                                |           |
| Measure 1  | Measure 2                      | Measure 3 |
| 99. DE Sleeve Bearing Outside ID Post Repair                   |                                |           |
| Measure 1  | Measure 2                      | Measure 3 |
| 100. DE Sleeve Bearing Inside OD Post Repair                   |                                |           |
| Measure 1  | Measure 2                      | Measure 3 |
| 101. DE Sleeve Bearing Outside OD Post Repair                  |                                |           |
| Measure 1  | Measure 2                      | Measure 3 |
| 102. End Bell Repair Sign-off                                  |                                |           |
| 103. ODE Sleeve Bearing Inside ID Post Repair                  |                                |           |
| Measure 1  | Measure 2                      | Measure 3 |
| 104. ODE Sleeve Bearing Outside ID Post Repair                 |                                |           |
| Measure 1  | Measure 2                      | Measure 3 |
| 105. ODE Sleeve Bearing Inside OD Post Repair                  |                                |           |
| Measure 1  | Measure 2                      | Measure 3 |
| 106. ODE Sleeve Bearing Outside OD Post Repair                 |                                |           |
| Measure 1  | Measure 2                      | Measure 3 |
| <b>Assembly</b>  |                                |           |
| 107. QC Check All Parts for Cleanliness Prior to Assembly      |                                |           |
| 108. Photograph All Major Components prior to assembly         |                                |           |
| 109. Final Insulation Resistance Test                          |                                |           |
| 110. Assembled Shaft Endplay                                   |                                |           |
| 111. Assembled Shaft Runout                                    |                                |           |
| 112. Test Run Voltage  |                                |           |
| Volts  | Volts                          | Volts     |
| 113. Test Run Amperage   |                                |           |
| Amps   | Amps                           | Amps      |
| 114. Drive End Vibration Readings - Inches Per Second          |                                |           |
| Horizontal   | Vertical                       | Axial     |
| 115. Opposite Drive End Vibration Readings - Inches Per Second |                                |           |
| Horizontal   | Vertical                       | Axial     |

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|  |            |            |
|--|------------|------------|
| 116. Ambient Temperature - Fahrenheit                            |            |            |
| 117. Drive End Bearing Temps - Fahrenheit                        |            |            |
| 5 Minutes  | 10 Minutes | 15 Minutes |
| 118. Drive End Bearing Temps - Fahrenheit 20-30 Minutes          |            |            |
| 20 Minutes   | 25 Minutes | 30 Minutes |
| 119. Drive End Bearing Temps - Fahrenheit 35-45 Minutes          |            |            |
| 35 Minutes   | 40 Minutes | 45 Minutes |
| 120. Drive End Bearing Temps - Fahrenheit 50-60 Minutes          |            |            |
| 50 Minutes   | 55 Minutes | 60 Minutes |
| 121. Opposite Drive End Bearing Temps - Fahrenheit               |            |            |
| 5 Minutes  | 10 Minutes | 15 Minutes |
| 122. Opposite Drive End Bearing Temps - Fahrenheit 20-30 Minutes |            |            |
| 20 Minutes   | 25 Minutes | 30 Minutes |
| 123. Opposite Drive End Bearing Temps - Fahrenheit 35-45 Minutes |            |            |
| 35 Minutes   | 40 Minutes | 45 Minutes |
| 124. Opposite Drive End Bearing Temps - Fahrenheit 50-60 Minutes |            |            |
| 50 Minutes   | 55 Minutes | 60 Minutes |
| 125. Stator Temperatures- Fahrenheit                             |            |            |
| 5 Minutes  | 10 Minutes | 15 Minutes |
| 126. Stator Temperatures- Fahrenheit 20-30 Minutes               |            |            |
| 20 Minutes   | 25 Minutes | 30 Minutes |
| 127. Stator Temperatures- Fahrenheit 35-45 Minutes               |            |            |
| 35 Minutes   | 40 Minutes | 45 Minutes |
| 128. Stator Temperatures- Fahrenheit 50-60 Minutes               |            |            |
| 50 Minutes   | 55 Minutes | 60 Minutes |
| 129. Document Final Condition with Pictures after paint          |            |            |
| 130. Final Pics and QC Review                                    |            |            |



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11. **GOVERNING LAW AND JURISDICTION.** Any controversy arising out of any quotation, the purchase order, the goods sold or delivered, repair or replacement thereof, or any services provided pursuant to any quotation or any purchase order, or these Standard Terms and Conditions shall be governed by the laws of the state of Tennessee without regard to any choice of law provisions and any cause of action related in any manner thereto shall be brought only in the state or federal courts of Shelby County, Tennessee.
12. **ABANDONED EQUIPMENT.** Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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.
14. **NONWAIVER.** No course of dealing or failure of either party to strictly enforce any term, right, or condition of these Standard Terms and Conditions will be construed as a waiver of such term, right or condition. Any waiver by Hi-Speed will only be in writing and will waive no succeeding breach of a term, right or condition.
15. **ASSIGNMENT.** The rights and obligations of the parties shall neither be assigned nor delegated without the prior written consent of the other party. However, any party may assign or delegate its respective rights and obligations, in whole or in part, (i) to any subsidiary, (ii) pursuant to other financing, merger or reorganization or (iii) pursuant to any sale or transfer of substantially all of the assets of the assigning party. These Standard Terms and Conditions shall bind the heirs, successors and assigns of the parties hereto.
16. **NO INDIVIDUAL LIABILITY.** Notwithstanding any other agreement to the contrary, the Buyer agrees that in no event will the Buyer hold and Hi-Speed owner, director, officer or employee personally liable for unintentional tortious conduct or conduct that constitutes the breach of any contract between Hi-Speed and the Buyer, even if the Hi-Speed owner, director, officer or employee is or could be construed to be a party to such contract.