

LR Motor Shop Repairs

Job Number 101412

Prepared for Welspun Tubular (11685)

9301 Frazier Pike Little Rock AR 72206

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AC Inspection - Rev. 2: 175-1

1.0





AC Inspection as Found

Welspun Tubular (11685)

9301 Frazier Pike Little Rock, AR 72206 FolderID: 101412 FormID: 16853000

AC Inspection - Rev. 2

Location: LR MOTORSHOP

Serial Number: 175-1

Description:50HP CENTRIFUGAL BLOWER

1800RPM D255S

| Manufacturer: Baldor Product Number: M12E875X828G1 Spec/ID #: M12E875X828G1 Serial Number: C061207022 HP/kW: 50 (HP) RPM: 1780 (RPM) Frame: D255S Voltage: 460 Current: 56 Phase: Three Hz: 60 (Hz) Service Factor: 1.15 Enclosure: TEFC J-box Included: Complete Coupling/Sheave: Sheave Bearing RTDs: No Stator RTDs: No Repair Stage: Final Heaters: No Winding Type: Random Wound | Hi-Speed Job Number: | 101412 |
|--|----------------------|-----------------|
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| J-box Included: Complete Coupling/Sheave: Sheave Bearing RTDs: No Stator RTDs: No Repair Stage: Final Heaters: No Winding Type: Random Wound | Service Factor: | 1.15 |
| Coupling/Sheave: Sheave Bearing RTDs: No Stator RTDs: No Repair Stage: Final Heaters: No Winding Type: Random Wound | Enclosure: | TEFC |
| Bearing RTDs: No Stator RTDs: No Repair Stage: Final Heaters: No Winding Type: Random Wound | J-box Included: | Complete |
| Stator RTDs: No Repair Stage: Final Heaters: No Winding Type: Random Wound | Coupling/Sheave: | Sheave |
| Repair Stage: Final Heaters: No Winding Type: Random Wound | Bearing RTDs: | No |
| Heaters: No Winding Type: Random Wound | Stator RTDs: | No |
| Winding Type : Random Wound | Repair Stage: | Final |
| 3 7/2 | Heaters: | No |
| | Winding Type : | Random Wound |
| Bearing Type: Rolling Element | Bearing Type: | Rolling Element |

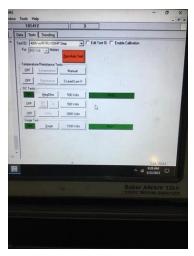
Priorities Found: 4 - High



2 - Good

Overall Condition

- 1. Report Date
- 2. Nameplate Picture
- 3. Photos of all six sides of the machine.

















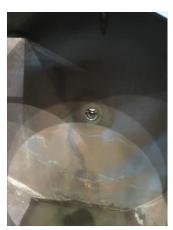
























 Describe the Overall Condition of the Equipment as Received Dirty and missing bolts for the front blower cover

5. Distance from the end of the shaft to the Coupling/Sheave

Initial Mechanical/Electrical

6. Does Shaft Turn Freely?

(Yes) Yes

7. Does Shaft Have Visible Damage?

(Yes) Yes





- 8. Assembled Shaft Runout
- 9. Assembled Shaft End Play
- 10. Air Gap Variation <10%
- 11. Lead Condition
- 12. Lead Length
- 13. Frame Condition
- 14. Fan Condition
- 15. Broken or Missing Components
- Front blower cover bolts

Initial Electrical Inspection

- 16. Insulation Resistance/Megger
- 17. Winding Resistance

1-2 1-3 2-3



| 19. | Number of Stator Slots | | | |
|-------|---------------------------|---------------|--|--|
| 20. | Stator Condition | | | |
| 21. | Stator Thermistors/Ohms | | | |
| 22. | Stator Overloads/Ohms | | | |
| Mecha | Mechanical Inspection | | | |
| 23. | Drive End Bearing Brand | Masta | | |
| 24. | Drive End Bearing Number- | S615 | | |
| 25. | Drive End Bearing Qty. | 1 | | |
| 26. | Drive End Bearing Type | (Other) Other | | |



| 27. Drive End Lubrication Type | (Grease) Grease Lubricated |
|---|----------------------------|
| 28. Drive End Bearing Insulation or Grounding Device? | |
| 29. Drive End Wavy Washer/Snap-Ring Other Retention Device? | |
| 30. Drive End Bearing Condition | |
| 31. Opposite Drive End Bearing Brand | masta |
| 32. Opposite Drive End Bearing Number- | S615 |
| 33. Opposite Drive End Bearing Qty. | 1 |

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| 35. | Opposite Drive End Lubrication Type | | (Grease) Grease Lubricated | |
|-------------|--|------------|----------------------------|--|
| 36. | Opposite Drive End Bearing Insulation or Grounding Device? | | | |
| 37. | Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? | | | |
| 38. | Opposite Drive End Bearing Condition | | | |
| 39. | Drive End Seal | | | |
| 40. | Opposite Drive End Seal | | | |
| Rotor | otor Inspection | | | |
| 41. | Rotor Type/Material | | | |
| 42. | Growler Test | | | |
| 43. | Number of Rotor Bars | | | |
| 44. | Rotor Condition | | | |
| 45. | List the Parts needed for the Repair Below | | | |
| 46. | Signature of Technician that Disassembled Motor | | | |
| Mech | lechanical Fits- Rotor | | | |
| 47. | Shaft Runout | | | |
| 48. | Rotor Runout | | | |
| | Drive End Bearing Fit | Rotor Body | Opposite Drive End Bearing | |
| | | | | |
| 4 9. | Coupling Fit Closest to Bearing Housing | ng | | |
| | 0 Degrees | 90 Degrees | 120 Degrees | |
| | | | | |
| - | Loose and has keyway wear | | | |





| | 51. | Drive End Bearing Shaft Fit | | | | |
|---|-----------------------------------|--|--------------------------------|-------------|----------|--|
| | | 0 Degrees | 60 Degrees | 120 Degrees | | |
| | | | | | | |
| | 52. | 3 | | | (F) Fail | |
| | - | New shaft recommend | | | | |
| | 53. | Opposite Drive End Bearing Shaft Fit | | | | |
| | | 0 Degrees | 60 Degrees | 120 Degrees | | |
| | - 1 | 0 " D: E ID : 0 "E" | 0 17.7 | | (E) E | |
| | 54. | Opposite Drive End Bearing Shaft Fit | Condition | | (F) Fail | |
| | | | | | | |
| | 55. | Shaft Air Seal Fits | Onnesite Drive Ford Air Cool | | | |
| | | Drive End Air Seal | Opposite Drive End Air Seal | | | |
| M | Mechanical Fits- Bearing Housings | | | | | |
| | | Drive End - Endbell Bearing Fit | | | | |
| | | 0 Degrees | 60 Degrees | 120 Degrees | | |
| | | 0 2 0g. 000 | 30 2 3g. 663 | .20 20g.000 | | |
| | 57. | Drive End - Endbell Bearing Fit Condit | tion | | | |
| | 58. | B. Opposite Drive End - Endbell Bearing Fit | | | | |
| | | 0 Degrees | 60 Degrees | 120 Degrees | | |
| | | | | | | |
| | | Opposite Drive End - Endbell Bearing Fit Condition | | | | |
| | 60. | Bearing Cap Condition | | | | |
| | | Drive End Bearing Cap | Opposite Drive End Bearing Cap | | | |
| | 0.4 | E 15 A: 0 E: | | | | |
| | 61. | End Bell Air Seal Fits | 0 " D: 5 4: 0 | | | |
| | | Drive End Air Seal | Opposite Drive End Air Seal | | | |
| | 62. | List Machine Work Needed Below | | | | |
| | 63. | Technician | | | | |
| D | Dynamic Balance Report | | | | | |
| | | | | | | |

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| 64. | Rotor Weight and Balance Grade | | |
|-------|---|--------------------|----------------------------|
| | Rotor Weight | Balance Grade | |
| | | | |
| 65. | 5. Initial Balance Readings | | |
| | Drive End | Opposite Drive End | |
| | | | |
| 66. | Final Balance Readings | | |
| | Drive End | Opposite Drive End | |
| | | | |
| • | Technician | | |
| Rewin | | | |
| 68. | Core Test Results - Watts loss per Po | | |
| | Pre-Burnout | Post Burnout | |
| 00 | One Hat Onet Test | | |
| 69. | Core Hot Spot Test | B 1B 1 | |
| | Pre-Burnout | Post-Burnout | |
| 70 | Post Rewind Electrical Test- Insulation | n Resistance | |
| 71. | | Tredictarios | |
| 72. | | | |
| 12. | 1-2 | 1-3 | 2-3 |
| | 1-2 | 1-3 | 2-3 |
| 73. | Post Rewind Surge Test | | |
| 74. | Post Rewind Hi-Pot | | |
| 75. | Technician | | |
| Root | Cause of Failure | | |
| 76. | Failure locations | | |
| | Bearings, shaft, and belt pulley | | |
| 77. | Root cause of failure | | |
| | Intensive wear | | |
| Mecha | anical Fits- Rotor - Post Repair | | |
| 78. | Shaft Runout Post Repair | | |
| | Rotor Runout Post Repair | | |
| | Drive End Bearing Fit | Rotor Body | Opposite Drive End Bearing |
| | Ü | , | 11 |
| 80. | Coupling Fit Closest to Bearing Housi | ng 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 |
| | D. E. ID. 1. 01 (15% D. 15 | | |
| 82. | Drive End Bearing Shaft Fit Post Repa | | 400 5 |
| | 0 Degrees | 60 Degrees | 120 Degrees |
| 92 | Opposite Drive End Bearing Shaft Fit | Poet Ranair | |
| 03. | * | • | 120 Dogrado |
| | 0 Degrees | 60 Degrees | 120 Degrees |
| | | | |

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| 84. | Shaft Air Seal Fits Post Repair | | |
|--|--|---------------------------------------|-------------|
| | Drive End Air Seal | Opposite Drive End Air Seal | |
| | | | |
| | Shaft Repair Sign-off | | |
| | chanical Fits- Bearing Housings - Post Repair | | |
| 86. | Drive End - Endbell Bearing Fit Post F | · | |
| | 0 Degrees | 60 Degrees | 120 Degrees |
| 07 | 87. Opposite Drive End - Endbell Bearing Fit Post Repair | | |
| 07. | • | · | 120 Degrees |
| | 0 Degrees | 60 Degrees | 120 Degrees |
| 88. | Bearing Cap Condition Post Repair | | |
| | Drive End Bearing Cap | Opposite Drive End Bearing Cap | |
| | ũ , | - 1 | |
| 89. | End Bell Air Seal Fits Post Repair | | |
| | Drive End Air Seal | Opposite Drive End Air Seal | |
| | | | |
| | End Bell Repair Sign-off | | |
| | embly | | |
| | QC Check All Parts for Cleanliness Pr | · · · · · · · · · · · · · · · · · · · | |
| 92. | | or to assembly | |
| | 93. Final Insulation Resistance Test 94. Assembled Shaft Endplay | | |
| | | | |
| | Assembled Shaft Runout | | |
| 96. | Test Run Voltage Volts | Volts | Volta |
| | VOILS | VOILS | Volts |
| 97. | Test Run Amperage | | |
| | Amps | Amps | Amps |
| | | | |
| 98. | Drive End Vibration Readings - Inches | s Per Second | |
| | Horizontal | Vertical | Axial |
| 00 | Opposite Drive End Vibration Reading | ne - Inches Per Second | |
| 99. | Horizontal | Vertical | Axial |
| | Tionzoniai | v Gilicai | MAIdI |
| 100. | 0. Ambient Temperature - Fahrenheit | | |
| | 101. Drive End Bearing Temps - Fahrenheit | | |
| | 5 Minutes | 10 Minutes | 15 Minutes |
| | | | |
| 102. Opposite Drive End Bearing Temps - Fahrenheit | | | |
| | 5 Minutes | 10 Minutes | 15 Minutes |
| 400 | B 10 10 10 10 10 10 10 10 10 10 10 10 10 | | |
| | Document Final Condition with Picture | es aπer paint | |
| 104. | Final Pics and QC Review | | |

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- 5. <u>DELIVERY OF GOODS AND/OR SERVICES.</u> 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.
- **DELIVERY SITE AND TIME FOR PERFORMANCE.** Hi-Speed and Buver 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.
- 7. INSPECTION/ACCEPTANCE. All goods and services ordered pursuant to any quotation shall be subject to inspection by Buyer after delivery or performance to determine conformity with the quotation and/or purchase order and Hi-Speed's advertised or published specifications. Buyer shall have a period of thirty (30) days from shipment of goods at the delivery destination specified in the quotation within which to inspect the goods for conformity with the quotation, order and/or Hi-Speed's advertised and published specifications and to provide Hi-Speed with written notice of any discrepancy or rejection. Buyer shall have a period of thirty (30) days following completion of any services within which to inspect the services for conformity with the quotation, purchase order and/or Hi-Speed's advertised and published specifications and to provide Hi-Speed with written notice of any discrepancy or rejection. If the goods delivered or services performed do not so conform, upon delivery of notice to Hi-Speed of any discrepancy, nonconformance or rejection, Hi-Speed shall have sixty (60) days to cure the alleged discrepancy and/or nonconformance. If Hi-Speed fails to cure in this time period, Buyer shall have the right to reject such goods or services. After the cure period, goods that have been delivered and rejected, in whole or in part, shall be returned to Hi-Speed. Buyer shall notify Hi-Speed and arrange for the return of the goods as required. Should such non-conforming services be rejected Hi-Speed shall, at its sole cost, re-perform the non-conforming services. Inspection or failure to inspect on any occasion shall not affect Buyer's rights under the warranty provisions herein.
- 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

replace any defective or non-conforming goods in accordance with the applicable manufacturer's warranty. Warranty for any defective or incorrect parts is limited to the repair or replacement of those parts. Hi-Speed warrants that all services will conform in all material respects to the description of services identified in the quotation and will be performed in a good and workmanlike manner in accordance with industry practices and standards. Should the services be reasonably rejected or not conform with the foregoing warranties, Hi-Speed shall, at its sole cost, re-perform the defective or nonconforming services. Notwithstanding the foregoing, these warranties do not extend to goods or services to the extent that such goods have been subject to misuse, neglect or abuse not caused by Hi-Speed or have been used in violation of the approved written instructions furnished to Buyer. THE FOREGOING REPRESENTS THE SOLE AND EXCLUSIVE WARRANTY GIVEN BY HI-SPEED WITH RESPECT TO ALL GOODS SOLD AND IS IN LIEU OF ALL OTHER WARRANTIES EITHER EXPRESS OR IMPLIED. HI-SPEED EXPRESSLY DISCLAIMS ALL OTHER WARRANTIES INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICLAR USE OR PURPOSE. BUYER WAIVES ANY CLAIM THAT THESE EXCLUSIONS OR LIMITATIONS DEPRIVE IT OF AN ADEQUATE REMEDY AT EQUITY OR LAW OR CAUSE THIS AGREEMENT TO FAIL IN ITS ESSENTIAL PURPOSE. BUYER SHALL BE ENTITLED TO NO OTHER REMEDY OTHER THAN AS SET FORTH HEREIN, REGARDLESS OF THE CLAIM OR CAUSE OF ACTION, WHETHER BASED IN CONTRACT, TORT, NEGLIGENCE, GOODS LIABILITY, STRICT LIABILITY OR OTHERWISE.

- 9. <u>LIMITATION OF DAMAGES.</u> HI-SPEED SHALL HAVE NO LIABILITY TO BUYER WITH RESPECT TO THE SALE OR DELIVERY OF ANY GOODS OR THE REPAIR THEREOF OR WITH RESPECT TO THE SALE OR PERFORMANCE OF ANY SERVICES, FOR LOST PROFITS, SPECIAL, CONSEQUENTIAL, EXEMPLARY, PUNITIVE OR INCIDENTAL DAMAGES OF ANY KIND OR NATURE WHETHER ARISING IN CONTRACT, TORT, GOODS LIABILITY OR OTHERWISE, EVEN IF HI-SPEED WAS ADVISED OF THE POSSIBILITY OF SUCH LOSS OR DAMAGES. HI-SPEED SHALL NOT BE LIABLE FOR ANY DAMAGES OR DELAYS CAUSED BY ANY FAILURE TO MAKE ANY DELIVERY OF GOODS BY ANY EXPECTED TIME OR DATE OR THE FAILURE TO PROVIDE OR COMPLETE ANY SERVICES BY ANY EXPECTED DATE OR TIME. IN NO EVENT SHALL HI-SPEED BE LIABLE TO BUYER FOR ANY DAMAGES WHATSOEVER IN EXCESS OF THE TOTAL PRICE PAID FOR ALL GOODS AND/OR SERVICES HEREUNDER OR REFERENCED IN ANY QUOTATION OR THE PURCHASE ORDER.
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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, earth quake, 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. <u>NONWAIVER.</u> 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.