

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

> FolderID: 102673 FormID: 19818622

AC Inspection as Found

Shop

US Vanadium 6105 Cynamide Benton, AR 72015

AC Inspection - Rev. 2

Serial Number:

Location:

Description: 1 HP LIFTECH

Hi-Speed Job Number:	102673
Manufacturer:	Other
Product Number:	331982-03
Spec/ID #:	35Z65358861W
Serial Number:	F1301170141
HP/kW:	1 (HP)
RPM:	1725 (RPM)
Frame:	56C
Voltage:	460
Current:	1.5
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
Enclosure:	TENV
# of Leads:	6
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	03/20/2024
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	Yes
Shaft Machined Fit Repairs Required:	No
Bearing Housing Machined Fit Repairs Required:	No
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **a** 2 - High

11 - Good

Overall Condition

Report Date 04/08/2024



3. Photos of all six sides of the machine.





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P45









 Describe the Overall Condition of the Equipment as Received Dirty

		7	
In	itial l	Mechanical/Electrical	Ō
	5.	Does Shaft Turn Freely?	(Y) Yes
	6.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
	7.	Does Shaft Have Visible Damage?	(No) No
	8.	Assembled Shaft Runout	Inches
	•	Na	
	9.	Assembled Shaft End Play	inches
	-	Na	

10.	Air Gap Variation <10%		
-	Na		
11.	Lead Condition	(NA) Not Applicable	
12.	Lead Length	8 Inches	
13.	Does it have Lugs?, If so what is the Stud Size?	(No) No	
14.	Lead Numbers	1-3 & 11-13	
15.	Frame Condition	pass	
16.	Fan Condition	(P) Pass	P112
17	Broken or Missing Components	na	
17.	Broken or Missing Components Electrical Inspection	na	
18.	Insulation Resistance/Megger	Megohms	

	broken or wissing components		IIa	
Initial E	Electrical Inspection			
18.	Insulation Resistance/Megger		Megohms	
-	Na			
19.	Winding Resistance			
	1-2	1-3	2-3	
-	Na			
2 0.	Perform Surge Test		(NA) Not Applicable	
-	Rewind			
21.	Number of Stator Slots		36	
2 2.	Stator Condition		stator pass but windings are shorted coil to coil	
23.	Stator Thermistors/Ohms			
-	Na			
24.	Stator Overloads/Ohms		overload 0.03 ohms	
Mecha	nical Inspection			O
25.	Drive End Bearing Brand		NTN	



74 - E - C - 102 - 1	Market Control of the		
27.	Drive End Bearing Qty.	1	
28.	Drive End Bearing Type	(Ball) Ball Bearing	
29.	Drive End Lubrication Type	(Grease) Grease Lubricated	
30.	Drive End Bearing Insulation or Grounding Device?	na	
31.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	na	
32.	Drive End Bearing Condition		P81

Signs of normal wear



33. Opposite Drive End Bearing Brand

NSK

P91



34.	Opposite Drive End Bearing Number-	6203
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35. Opposite Drive End Bearing Qty.

1

36.	Opposite Drive End Bearing Type	(Ball) Ball Bearing	
37.	Opposite Drive End Lubrication Type	(Grease) Grease Lubricated	
38.	Opposite Drive End Bearing Insulation or Grounding Device?		
-	Na		
39.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer	
40.	Opposite Drive End Bearing Condition		P115
	Signs of normal wear		



41. Drive End Seal

■ Na

42. Opposite Drive End Seal

Na

Rotor	Inspection
IVOLOI	mapechon

43.	Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
44.	Growler Test	(Pass) Pass
45.	Number of Rotor Bars	48
46.	Rotor Condition	pass
47.	List the Parts needed for the Repair Below 6205 6203	
48.	Signature of Technician that Disassembled Motor	Cw

Mechanical Fits- Rotor

49. Shaft Runout inches

Na

50. Rotor Runout

Drive End Bearing Fit Rotor Body Opposite Drive End Bearing

Na

51. Coupling Fit Closest to Bearing Housing 0 Degrees 90 Degrees 120 Degrees Na	51.	Counting Fit Closest to Rearing Ho	auaina		
52. Coupling Fit Closest to the end of the Shaft 0 Degrees 60 Degrees 120 Degrees Ma 53. Drive End Bearing Shaft Fit 0 Degrees 60 Degrees 120 Degrees 0.9845 0.9846 0.9846 54. Drive End Bearing Shaft Fit 0 Degrees 60 Degrees 120 Degrees 0.6693 0.6693 0.6694 0.6693 56. Opposite Drive End Bearing Shaft Fit Condition (P) Pass 57. Shaft Air Seal Fits Drive End Air Seal Opposite Drive End Air Seal Ma Mechanical Fits- Bearing Housings 58. Drive End - Endbell Bearing Fit 0 Degrees 2.048 2.0479 2.0479 59. Drive End - Endbell Bearing Fit 0 Degrees 120 Degrees 1.5747 1.5748 1.5747 61. Opposite Drive End - Endbell Bearing Fit Condition (P) Pass 62. Bearing Cap Condition (P) Pass 63. End Bell Air Seal Fits Drive End Air Seal Fits Drive End Bearing Cap Opposite Drive End Bearing Cap Pass 63. End Bell Air Seal Fits Drive End Air Seal Opposite Drive End Air Seal		Coupling in Closest to Bearing in	busing		
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		Drive End Air Seal	Opposite Drive End Air Seal		
	_	Mo			
04. LIST IVIACHINE WORK INEEGEG BEIOW	,				
No	64.				
Na Cr. Tashnisian	05				Corr
65. Technician Cw	65.	Technician			CW
		/ /			
	/				
	(MM			
Min	1				

Root Cause of Failure

66. Failure locations

Bearings and windings

67. Root cause of failure

Bearings have signs of normal wear mixed with contamination and windings has a coil to coil short in hispeed

Dynamic Balance Report

68. Rotor Weight and Balance Grade

Rotor Weight Balance Grade

69. Initial Balance Readings

Drive End Opposite Drive End

70. Final Balance Readings

Drive End Opposite Drive End

71. Technician

Rewind

72. Core Test Results - Watts loss per Pound

Pre-Burnout Post Burnout

73. Core Hot Spot Test

Pre-Burnout Post-Burnout

74. Post Rewind Electrical Test-Insulation Resistance

Megohms

0

P40



Hi speed

75. Post Rewind Polarization Index

Polarization Index



Hi speed

77. Post Rewind Surge Test (Pass) Pass P68



Hi speed

- 78. Post Rewind Hi-Pot
- 79. Technician

Assembly

o

80. QC Check All Parts for Cleanliness Prior to Assembly

Terrence Holland









82.	Final Insulation Resistance Test	1 Gigohms
83.	Assembled Shaft Endplay	0 inches
84.	Assembled Shaft Runout	0.001 inches

85. Test Run Voltage P56

 Volts
 Volts
 Volts

 459
 458
 460

Witness: Low speed DM Witness: High speed CW





1,2,3



86.	Test Run Amperage			
	Amps	Amps	Amps	
	0.8	0.9	1	
87.	Drive End Vibration Readings - In	ches Per Second		
	Horizontal	Vertical	Axial	
88.	Opposite Drive End Vibration Rea	idings - Inches Per Second		
	Horizontal	Vertical	Axial	
89.	Ambient Temperature - Fahrenhe	it		
90.	Drive End Bearing Temps - Fahre	nheit		
	5 Minutes	10 Minutes	15 Minutes	
91.	Opposite Drive End Bearing Temp	os - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes	
92.	Document Final Condition with Pi	ctures after paint	Good	

Witness: CW







