

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

> FolderID: 102906 FormID: 20326568

AC Inspection as Found

20820 interstate 30 N Benton, AR 72019

AC Inspection - Rev. 2

Location: Motor Shop Serial Number: 32-12-200A 2A

Description:6HP ILG IND

Hi-Speed Job Number:	102906
Manufacturer:	Other
Serial Number:	32-12-200A 2A
HP/kW:	6 (HP)
RPM:	855 (RPM)
Frame:	32
Voltage:	Other
Current:	18 (Amps)
Phase:	Three
Hz:	60 (Hz)
Enclosure:	TENV
# of Leads:	3
J-box Included:	None
Coupling/Sheave:	None
Date Received:	05/08/2024
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	Yes
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**





4 - Good

Overall Condition

Report Date

05/20/2024



3. Photos of all six sides of the machine.



P45















 Describe the Overall Condition of the Equipment as Received Serviceable

Initial I	Mechanical/Electrical	Ō
5 .	Does Shaft Turn Freely?	(N) No
6.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(Yes) Yes
-	ODE bearing journal.	
7.	Does Shaft Have Visible Damage?	(No) No
8.	Assembled Shaft Runout	Inches
-	Couldn't perform. Motor locked up.	
9.	Assembled Shaft End Play	inches
-	Na	
10.	Air Gap Variation <10%	
-	Na	
11.	Lead Condition	(P) Pass

12. Lead Length 3 Inches P87



• '	13.	Does it have Lugs?, If so what is the Stud Size?	(No) No
,	14.	Lead Numbers	1-3
,	15.	Frame Condition	pass
,	16.	Fan Condition	(N) NA
-		Na	
,	17.	Broken or Missing Components	none

Initial Electrical Inspection 18. Insulation Resistance/Megger Na 19. Winding Resistance 1-2 1-3 2-3

20. Perform Surge Test
(NA) Not Applicable
P57



Mechanical Inspection

Windings charred

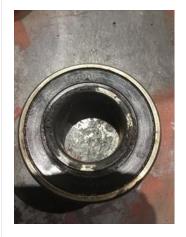
Na

21.	Number of Stator Slots	54	
22.	Stator Condition	rewind	
23.	Stator Thermistors/Ohms		
-	Na		
24.	Stator Overloads/Ohms		
-	Na		





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	? none
31. Drive End Wavy Washer/Snap-Ring Other Retention	on Device? none
32. Drive End Bearing Condition	locked up
33. Opposite Drive End Bearing Brand	JAF
34. Opposite Drive End Bearing Number-	P9







35. Opposite Drive End Bearing Qty.

6206

-	Sealed double wide		
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?	none	
39.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?		P114



40. Opposite Drive End Bearing Condition	worn
41. Drive End Seal	none
42. Opposite Drive End Seal	none

Rotor Inspection

43. Rotor Type/Material (Squirrel Aluminum) Squirrel P3
Cage Aluminum Die Cast



44.	Growler Test	(Pass) Pass	
45.	Number of Rotor Bars	67	
46.	Rotor Condition	pass	
47.	List the Parts needed for the Repair Below		
	Bearings,		

48. Signature of Technician that Disassembled Motor Terrence Holland

Mechanical Fits- Rotor

	49.	Shaft Runout ODE shaft bearing journal out of tole	erance. Unable to perform measureme	inches	
	50.	Rotor Runout	·		
		Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
		G	,		
	-	Na			
	51.	Coupling Fit Closest to Bearing Ho	pusing		
		0 Degrees	90 Degrees	120 Degrees	
	-	Na			
	52.	Coupling Fit Closest to the end of			
		0 Degrees	60 Degrees	120 Degrees	
		Na			
	53.	Drive End Bearing Shaft Fit			
	00.	0 Degrees	60 Degrees	120 Degrees	
		1.575	1.575	1.5749	
	54.	Drive End Bearing Shaft Fit Condit		(P) Pass	
Ť	55.	Opposite Drive End Bearing Shaft		()	
		0 Degrees	60 Degrees	120 Degrees	
		· ·	C	J	
	•	Excessive wear. Bearing came off in	n housing.		
	56.	Opposite Drive End Bearing Shaft	Fit Condition	(F) Fail	
	57.	Shaft Air Seal Fits			
		Drive End Air Seal	Opposite Drive End Air Seal		
	-	Na			
M	lechai	nical Fits- Bearing Housings			
M	~	nical Fits- Bearing Housings Drive End - Endbell Bearing Fit	00 D	400 D	
M	lechai	nical Fits- Bearing Housings	60 Degrees	120 Degrees	
M	fechai 58.	Drive End - Endbell Bearing Fit O Degrees	60 Degrees	120 Degrees	
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M	58. 59.	nical Fits- Bearing Housings Drive End - Endbell Bearing Fit 0 Degrees Lip worn in. Drive End - Endbell Bearing Fit Co	ndition	120 Degrees (F) Fail	
M	58.	Drive End - Endbell Bearing Fit O Degrees Lip worn in. Drive End - Endbell Bearing Fit Co	andition ring Fit	(F) Fail	
M	58. 59.	nical Fits- Bearing Housings Drive End - Endbell Bearing Fit 0 Degrees Lip worn in. Drive End - Endbell Bearing Fit Co	ndition	·	
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65. Technician		Terrence Holland
1	Hollan	

Witness: RRW

Root Cause of Failure

66. Failure locations

Both housing fits, ode shaft bearing fit, and rewind stator.

67. Root cause of failure

Excessive amounts of moisture entered into the stator housings and bearings causing them to lock up. Also contributed to windings shorted to ground.

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
- 75. Post Rewind Polarization Index
- 76. Post Rewind Winding Resistance

1-2 1-3 2-3

- 77. Post Rewind Surge Test
- 78. Post Rewind Hi-Pot
- 79. Technician

Mechanical Fits- Rotor - Post Repair

- 80. Shaft Runout Post Repair
- 81. Rotor Runout Post Repair

Drive End Bearing Fit Rotor Body Opposite Drive End Bearing

82. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees 90 Degrees 120 Degrees

84. Drive End Bearing Shaft Fit Post Repair 0 Degrees 60 Degrees 120 Degrees 85. Opposite Drive End Bearing Shaft Fit Post Repair 0 Degrees 60 Degrees 120 Degrees 86. Shaft Air Seal Fits Post Repair Drive End Air Seal Opposite Drive End Air Seal 87. Shaft Repair Sign-off Mechanical Fits- Bearing Housings - Post Repair 0 Degrees 60 Degrees 120 Degrees 88. Drive End Air Seal Opposite Drive End Air Seal 87. Shaft Repair Sign-off Mechanical Fits- Bearing Housings - Post Repair 0 Degrees 60 Degrees 120 Degrees 88. Opposite Drive End - Endbell Bearing Fit Post Repair 0 Degrees 60 Degrees 120 Degrees 90. Bearing Cap Condition Post Repair Drive End Bearing Cap Opposite Drive End Bearing Cap 91. End Bell Air Seal Fits Post Repair Drive End Air Seal Opposite Drive End Air Seal 92. End Bell Repair Sign-off Assembly 93. QC Check All Parts for Cleanliness Prior to Assembly 94. Photograph All Major Components prior to assembly 95. Final Insulation Resistance Test 96. Assembled Shaft Endplay 97. Assembled Shaft Endplay 97. Assembled Shaft Runout 98. Test Run Amperage Amps Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial	83.	Coupling Fit Closest to the end of	the Shaft Post Repair		
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92. End Bell Repair Sign-off Assembly 93. QC Check All Parts for Cleanliness Prior to Assembly 94. Photograph All Major Components prior to assembly 95. Final Insulation Resistance Test 96. Assembled Shaft Endplay 97. Assembled Shaft Runout 98. Test Run Voltage Volts Volts Volts Volts Volts 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial		Drive End Bearing Cap	Opposite Drive End Bearing Cap		
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92. End Bell Repair Sign-off Assembly 93. QC Check All Parts for Cleanliness Prior to Assembly 94. Photograph All Major Components prior to assembly 95. Final Insulation Resistance Test 96. Assembled Shaft Endplay 97. Assembled Shaft Runout 98. Test Run Voltage Volts Volts Volts Volts 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial	91.	End Bell Air Seal Fits Post Repair			
Assembly 93. QC Check All Parts for Cleanliness Prior to Assembly 94. Photograph All Major Components prior to assembly 95. Final Insulation Resistance Test 96. Assembled Shaft Endplay 97. Assembled Shaft Runout 98. Test Run Voltage Volts Volts Volts Volts 99. Test Run Amperage Amps Amps Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial		Drive End Air Seal	Opposite Drive End Air Seal		
Assembly 93. QC Check All Parts for Cleanliness Prior to Assembly 94. Photograph All Major Components prior to assembly 95. Final Insulation Resistance Test 96. Assembled Shaft Endplay 97. Assembled Shaft Runout 98. Test Run Voltage Volts Volts Volts Volts 99. Test Run Amperage Amps Amps Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial					
93. QC Check All Parts for Cleanliness Prior to Assembly 94. Photograph All Major Components prior to assembly 95. Final Insulation Resistance Test 96. Assembled Shaft Endplay 97. Assembled Shaft Runout 98. Test Run Voltage Volts Volts Volts Volts 99. Test Run Amperage Amps Amps Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial	92.	End Bell Repair Sign-off			
94. Photograph All Major Components prior to assembly 95. Final Insulation Resistance Test 96. Assembled Shaft Endplay 97. Assembled Shaft Runout 98. Test Run Voltage Volts Volts Volts 99. Test Run Amperage Amps Amps Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial	Assem	bly			
95. Final Insulation Resistance Test 96. Assembled Shaft Endplay 97. Assembled Shaft Runout 98. Test Run Voltage Volts Volts Volts Volts 99. Test Run Amperage Amps Amps Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial	93.	QC Check All Parts for Cleanlines	s Prior to Assembly		
96. Assembled Shaft Endplay 97. Assembled Shaft Runout 98. Test Run Voltage Volts Volts Volts Volts 99. Test Run Amperage Amps Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial 101. Opposite Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial	94.	Photograph All Major Components	prior to assembly		
97. Assembled Shaft Runout 98. Test Run Voltage Volts Volts Volts Volts 99. Test Run Amperage Amps Amps Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial 101. Opposite Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial	95.	Final Insulation Resistance Test			
98. Test Run Voltage Volts Volts Volts Volts 99. Test Run Amperage Amps Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial 101. Opposite Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial	96.	Assembled Shaft Endplay			
Volts	97.	Assembled Shaft Runout			
99. Test Run Amperage Amps Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial 101. Opposite Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial	98.	Test Run Voltage			
Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial 101. Opposite Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial		Volts	Volts	Volts	
Amps Amps Amps 100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial 101. Opposite Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial					
100. Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial 101. Opposite Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial	99.	Test Run Amperage			
Horizontal Vertical Axial 101. Opposite Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial		Amps	Amps	Amps	
Horizontal Vertical Axial 101. Opposite Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial					
101. Opposite Drive End Vibration Readings - Inches Per Second Horizontal Vertical Axial	100.	Drive End Vibration Readings - Inc	ches Per Second		
Horizontal Vertical Axial		Horizontal	Vertical	Axial	
Horizontal Vertical Axial					
	101.	Opposite Drive End Vibration Rea	dings - Inches Per Second		
102. Ambient Temperature - Fahrenheit		Horizontal	Vertical	Axial	
102. Ambient Temperature - Fahrenheit					
	102.	Ambient Temperature - Fahrenhei	t		

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103.	Drive End Bearing Temps - Fahre	enheit	
	5 Minutes	10 Minutes	15 Minutes
104.	Opposite Drive End Bearing Temp	ps - Fahrenheit	
	5 Minutes	10 Minutes	15 Minutes
105.	Document Final Condition with Pi	ctures after paint	
106.	Final Pics and QC Review		