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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 102740

Prepared for acme brick

22145 US- 67
Malvern AR 72104

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AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *Q2-E15T5803GPE 1*

1.0

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AC Inspection as Found

acme brick
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FolderID: 102740
FormID: 19984372

AC Inspection - Rev. 2

Location: MOTOR SHOP LR
Serial Number: Q2-E15T5803GPE 1
Description: 150HP SIEMENS 1190RPM

Hi-Speed Job Number:	102740
Manufacturer:	Siemens
Spec/ID #:	PART: 1LE22214CC312A
Serial Number:	Q2-E15T5803GPE
HP/kW:	150 (HP)
RPM:	1190 (RPM)
Frame:	447T
Voltage:	460
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TEFC
Repair Stage:	Final
Rewind:	No
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: ● 3 - High ● 7 - Good

Overall Condition

- | | |
|----------------------|------------|
| 1. Report Date | 05/24/2024 |
| 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	
	<i>Partially disassembled</i>	
5.	Distance from the end of the shaft to the Coupling/Sheave	inches
	<i>Na</i>	
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	(NA) Not Applicable
	<i>Na</i>	
7.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
8.	Does Shaft Have Visible Damage?	(No) No
9.	Assembled Shaft Runout	Inches
	<i>Unable to check due to partial disassembly by customer.</i>	
10.	Assembled Shaft End Play	inches
	<i>Na</i>	
11.	Air Gap Variation <10%	
	<i>Na</i>	

<div><div></div><div>12. Lead Condition</div></div> <div><div></div><div>One lead cut very short. Also several leads have insulation cut and showing bare wire.</div></div> <div><div></div><div></div></div>	(F) Fail	
13. Lead Length	11 Inches	
14. Does it have Lugs?, If so what is the Stud Size?	(No) No	
15. Lead Numbers	1,2,3	
<div><div></div><div>6 leads</div></div>		
16. Stator Temperature Detector Rating and Function		
Quantity	Rating	Quantity Passed
<div><div></div><div>Na</div></div>		
17. Bearing Temperature Detector Rating and Function		
Quantity	Rating	Quantity Passed
<div><div></div><div>Na</div></div>		
18. Frame Condition	pass	
19. Fan Condition	(F) Fail	
<div><div></div><div>Cracked</div></div> <div><div></div><div></div></div>		
20. Broken or Missing Components		
<div><div></div><div>All end bell housing mount bolts missing.</div></div>		
Initial Electrical Inspection		

21. Insulation Resistance/Megger

Megohms

Test ID	Test Date	Test Time	Test Type	Test Result	Test Status
102740	3/28/2024	3:28:09 PM	Insulation Resistance	PASS	Tested
102741	3/28/2024	3:28:09 PM	Insulation Resistance	PASS	Tested
102742	3/28/2024	3:28:09 PM	Insulation Resistance	PASS	Tested
102743	3/28/2024	3:28:09 PM	Insulation Resistance	PASS	Tested
102744	3/28/2024	3:28:09 PM	Insulation Resistance	PASS	Tested

22. Winding Resistance

1-2

1-3

2-3

0.253

0.255

0.252

Test ID	Test Date	Test Time	Test Type	Test Result	Test Status
102740	3/28/2024	3:28:09 PM	Winding Resistance	PASS	Tested
102741	3/28/2024	3:28:09 PM	Winding Resistance	PASS	Tested
102742	3/28/2024	3:28:09 PM	Winding Resistance	PASS	Tested
102743	3/28/2024	3:28:09 PM	Winding Resistance	PASS	Tested
102744	3/28/2024	3:28:09 PM	Winding Resistance	PASS	Tested

23. Perform Surge Test

(P) Pass

Test ID	Test Date	Test Time	Test Type	Test Result	Test Status
102740	3/28/2024	3:28:09 PM	Surge Test	PASS	Tested
102741	3/28/2024	3:28:09 PM	Surge Test	PASS	Tested
102742	3/28/2024	3:28:09 PM	Surge Test	PASS	Tested
102743	3/28/2024	3:28:09 PM	Surge Test	PASS	Tested
102744	3/28/2024	3:28:09 PM	Surge Test	PASS	Tested

Test ID	Test Date	Test Time	Test Type	Test Result	Test Status
102740	3/28/2024	3:28:09 PM	Surge Test	PASS	Tested
102741	3/28/2024	3:28:09 PM	Surge Test	PASS	Tested
102742	3/28/2024	3:28:09 PM	Surge Test	PASS	Tested
102743	3/28/2024	3:28:09 PM	Surge Test	PASS	Tested
102744	3/28/2024	3:28:09 PM	Surge Test	PASS	Tested

24. Number of Stator Slots

72



25. Stator Condition

pass


26. Stator Thermistors/Ohms







Na

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27. Stator Overloads/Ohms	Na
Mechanical Inspection	
28. Drive End Bearing Brand	FAG
29. Drive End Bearing Number-	NU 320-E-M1-C3
	
30. Drive End Bearing Qty.	1
31. Drive End Bearing Type	(Roller) Roller Bearing
	
32. Drive End Lubrication Type	(Grease) Grease Lubricated
33. Drive End Bearing Insulation or Grounding Device?	none
34. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
35. Drive End Bearing Condition	replace
36. Opposite Drive End Bearing Brand	Nachi
37. Opposite Drive End Bearing Number-	6316



38. Opposite Drive End Bearing Qty.	1
39. Opposite Drive End Bearing Type	(Ball) Ball Bearing
40. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
41. Opposite Drive End Bearing Insulation or Grounding Device?	none
42. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
43. Opposite Drive End Bearing Condition	replace
44. Drive End Seal	na
45. Opposite Drive End Seal	na
Rotor Inspection	
46. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
47. Growler Test	(Pass) Pass
48. Number of Rotor Bars	54
49. Rotor Condition	pass
50. List the Parts needed for the Repair Below <i>Sleeve ODE housing fit. Replace all attachment bolts for both housings and bearing caps.</i>	
51. Signature of Technician that Disassembled Motor	Terrence Holland
	
Mechanical Fits- Rotor	
52. Shaft Runout	0.002 inches
53. Rotor Runout	
Drive End Bearing Fit	Rotor Body
Opposite Drive End Bearing	
Na	
54. Coupling Fit Closest to Bearing Housing	
0 Degrees	90 Degrees
120 Degrees	
Na	
55. Coupling Fit Closest to the end of the Shaft	
0 Degrees	60 Degrees
120 Degrees	
Na	

56.	Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	3.9379	3.9379	3.9381	
	57.	Drive End Bearing Shaft Fit Condition	(P) Pass	
	58.	Opposite Drive End Bearing Shaft Fit		
		0 Degrees	60 Degrees	120 Degrees
		3.1502	3.15	3.15
	59.	Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	
	60.	Shaft Air Seal Fits		
		Drive End Air Seal	Opposite Drive End Air Seal	
	Na			
Mechanical Fits- Bearing Housings				
	61.	Drive End - Endbell Bearing Fit		
		0 Degrees	60 Degrees	120 Degrees
		8.464700000000001	8.464700000000001	8.4649
	62.	Drive End - Endbell Bearing Fit Condition	(P) Pass	
	63.	Opposite Drive End - Endbell Bearing Fit		
		0 Degrees	60 Degrees	120 Degrees
		7.4817	7.4818	7.4818
	Excessive pitting.			
	64.	Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail	



65. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass



66. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

67. List Machine Work Needed Below

Sleeve ode housing fit.

68. Technician

Terrence Holland

Root Cause of Failure

69. Failure locations

Motor requires re-lead de to insulation worn and cut on various leads. ODE housing worn and has excessive pitting. Bearing grease was dirty and contaminated.



70. Root cause of failure

Lead insulation was cut on various leads and one lead was cut very short. Also ODE housing fit is out of tolerance and pitted.

Dynamic Balance Report

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71. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



72. Initial Balance Readings

Drive End

Opposite Drive End

2.25

1.88

73. Final Balance Readings

Drive End

Opposite Drive End

.70

.53

74. Technician

David Maclin

Assembly

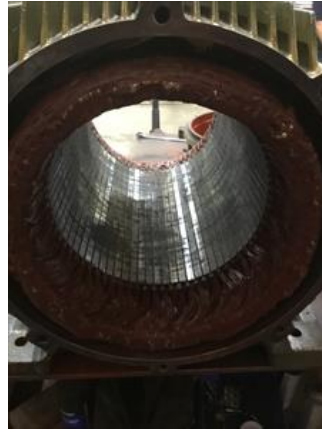
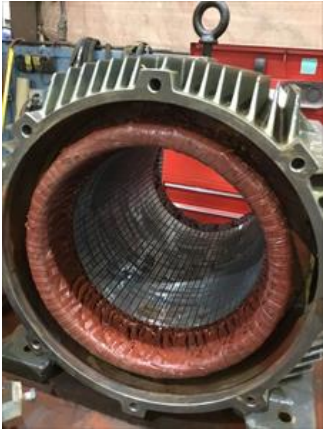
75. QC Check All Parts for Cleanliness Prior to Assembly

David Maclin

76. Photograph All Major Components prior to assembly

(Complete) Complete





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1.10



77. Final Insulation Resistance Test	2000 Megohms	
78. Assembled Shaft Endplay	0 inches	
79. Assembled Shaft Runout	0 inches	
80. Test Run Voltage		
Volts	Volts	Volts
459	459	460
<div> <div></div> <div>Witnessed by Chris Wiley</div> </div>		



81. Test Run Amperage		
Amps	Amps	Amps

73.3	73	72.3
82. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.02	0.01	0.01
83. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.02	0.01	0.02
84. Ambient Temperature - Fahrenheit		70
85. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
70		
86. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
70		
87. Document Final Condition with Pictures after paint		good
88. Final Pics and QC Review		





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1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
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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, 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.
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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.