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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 103038

Prepared for Almatris Inc/RCP Bauxite (10014)

4701 Alcoa Road
Bauxite AR 72011

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AC Inspection as Found - *LR Motor Shop*

AC Inspection - Rev. 2: 604T0109F0 1

1.0

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Printed on 6/10/2024

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AC Inspection as Found
Almatis Inc/RCP Bauxite (10014)
4701 Alcoa Road
Bauxite, AR 72011

FolderID: 103038
FormID: 20515517

AC Inspection - Rev. 2

Location: LR Motor Shop
Serial Number: 604T0109F0 1
Description: 60HP SIEMENS EVAL

| | |
|---|-----------------|
| Hi-Speed Job Number: | 103038 |
| Manufacturer: | Siemens |
| Serial Number: | 604T0109F0 1 |
| HP/kW: | 60 (HP) |
| RPM: | 1185 (RPM) |
| Frame: | 404T |
| Voltage: | 230 / 460 |
| Current: | 123 |
| Phase: | Three |
| Hz: | 60 (Hz) |
| Service Factor: | 1.15 |
| Enclosure: | TEFC |
| # of Leads: | 12 |
| J-box Included: | Complete |
| Coupling/Sheave: | None |
| Date Received: | 05/29/2024 |
| Bearing RTDs: | No |
| Stator RTDs: | No |
| Repair Stage: | Final |
| Rewind: | No |
| Shaft Machined Fit Repairs Required: | No |
| Bearing Housing Machined Fit Repairs Required: | Yes |
| Heaters: | No |
| Winding Type : | Random Wound |
| Bearing Type: | Rolling Element |

Priorities Found: **2 - High** **8 - Good**

Overall Condition

- | | |
|----------------------|-------------------|
| 1. Report Date | 06/10/2024 |
| 2. Nameplate Picture | |

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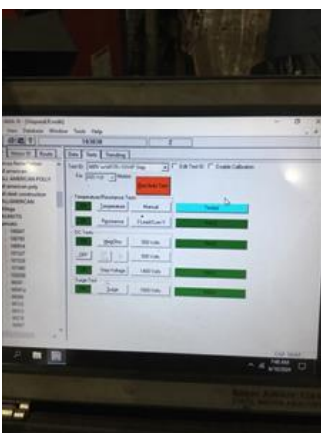
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| | |
|--|-----------------|
| 3. Photos of all six sides of the machine. | under nameplate |
| 4. Describe the Overall Condition of the Equipment as Received <i>Clean</i> | |
| Initial Mechanical/Electrical | |
| 5. Does Shaft Turn Freely? | (Y) Yes |
| 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 | 0 Inches |
| 9. Assembled Shaft End Play | 0 inches |
| 10. Air Gap Variation <10% | none |
| 11. Lead Condition | (P) Pass |
| 12. Lead Length | 12 Inches |
| 13. Does it have Lugs?, If so what is the Stud Size? | (Yes) Yes |
| 5/16 hole | |
| 14. Lead Numbers | 1-12 |
| 15. Frame Condition | good |
| 16. Fan Condition | (P) Pass |
| 17. Broken or Missing Components | none |
| Initial Electrical Inspection | |
| 18. Insulation Resistance/Megger | Megohms |



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| | | |
|------------------------------|--------------|-----------------|
| 19. Winding Resistance | | |
| 1-2 | 1-3 | 2-3 |
| .0945 | .0945 | .0945 |
| 20. Perform Surge Test | | (P) Pass |
| 21. Number of Stator Slots | | 72 |
| 22. Stator Condition | | good |
| 23. Stator Thermistors/Ohms | | none |
| 24. Stator Overloads/Ohms | | none |
| Mechanical Inspection | | |
| 25. Drive End Bearing Brand | | unknown |



| | |
|--|-----------------------------------|
| 26. Drive End Bearing Number- | 6316 |
| 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 Device? | none |
| 32. Drive End Bearing Condition | normal wear |
| 33. Opposite Drive End Bearing Brand | unknown |
| 34. Opposite Drive End Bearing Number- | 6316 |
| 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? | none |
| 39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? | wavy |
| 40. Opposite Drive End Bearing Condition | normal wear |
| 41. Drive End Seal | none |
| 42. Opposite Drive End Seal | none |

Rotor Inspection

| | |
|--|--|
| 43. Rotor Type/Material | (Squirrel Aluminum) Squirrel Cage Aluminum Die Cast |
| 44. Growler Test | (Pass) Pass |
| 45. Number of Rotor Bars | 56 |
| 46. Rotor Condition | good |
| 47. List the Parts needed for the Repair Below | 6316, 6316 |

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48. Signature of Technician that Disassembled Motor

David Maclin



Mechanical Fits- Rotor

49. Shaft Runout 0.0005 inches

50. Rotor Runout

| | | |
|-----------------------|------------|----------------------------|
| Drive End Bearing Fit | Rotor Body | Opposite Drive End Bearing |
| 0 | 0 | 0 |

51. Coupling Fit Closest to Bearing Housing

| | | |
|---------------|---------------|---------------|
| 0 Degrees | 90 Degrees | 120 Degrees |
| 2.8745 | 2.8745 | 2.8745 |

52. Coupling Fit Closest to the end of the Shaft

| | | |
|---------------|---------------|---------------|
| 0 Degrees | 60 Degrees | 120 Degrees |
| 2.8745 | 2.8745 | 2.8745 |

53. Drive End Bearing Shaft Fit

| | | |
|---------------|---------------|-------------|
| 0 Degrees | 60 Degrees | 120 Degrees |
| 3.1502 | 3.1501 | 3.15 |

● 54. Drive End Bearing Shaft Fit Condition (P) Pass

55. Opposite Drive End Bearing Shaft Fit

| | | |
|---------------|---------------|---------------|
| 0 Degrees | 60 Degrees | 120 Degrees |
| 3.1501 | 3.1499 | 3.1499 |

● 56. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

57. Shaft Air Seal Fits

| | |
|--------------------|-----------------------------|
| Drive End Air Seal | Opposite Drive End Air Seal |
| ok | ok |

Mechanical Fits- Bearing Housings

58. Drive End - Endbell Bearing Fit

| | | |
|---------------|---------------|---------------|
| 0 Degrees | 60 Degrees | 120 Degrees |
| 6.6935 | 6.6934 | 6.6935 |

● 59. Drive End - Endbell Bearing Fit Condition (P) Pass

60. Opposite Drive End - Endbell Bearing Fit

| | | |
|---------------|---------------|---------------|
| 0 Degrees | 60 Degrees | 120 Degrees |
| 6.6939 | 6.6944 | 6.6951 |

● 61. Opposite Drive End - Endbell Bearing Fit Condition (F) Fail

62. Bearing Cap Condition

| | |
|-----------------------|--------------------------------|
| Drive End Bearing Cap | Opposite Drive End Bearing Cap |
| ok | ok |

63. End Bell Air Seal Fits

| | |
|--------------------|-----------------------------|
| Drive End Air Seal | Opposite Drive End Air Seal |
| ok | ok |

64. List Machine Work Needed Below

Sleeve ODE end bell



Co sign: CRW

Root Cause of Failure

66. Failure locations

Ode bearing and fit

67. Root cause of failure

*Contamination from moisture***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

Mechanical Fits- Bearing Housings - Post Repair

72. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

73. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

74. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

75. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

76. End Bell Repair Sign-off

Assembly

77. QC Check All Parts for Cleanliness Prior to Assembly

78. Photograph All Major Components prior to assembly

79. Final Insulation Resistance Test

80. Assembled Shaft Endplay

81. Assembled Shaft Runout

82. Test Run Voltage

Volts

Volts

Volts

83. Test Run Amperage

Amps

Amps

Amps

| | | |
|---|------------|------------|
| 84. Drive End Vibration Readings - Inches Per Second | | |
| Horizontal | Vertical | Axial |
| 85. Opposite Drive End Vibration Readings - Inches Per Second | | |
| Horizontal | Vertical | Axial |
| 86. Ambient Temperature - Fahrenheit | | |
| 87. Drive End Bearing Temps - Fahrenheit | | |
| 5 Minutes | 10 Minutes | 15 Minutes |
| 88. Opposite Drive End Bearing Temps - Fahrenheit | | |
| 5 Minutes | 10 Minutes | 15 Minutes |
| 89. Document Final Condition with Pictures after paint | | |
| 90. Final Pics and QC Review | | |



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