



KEEPING YOUR FACILITY UP TO SPEED
— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 103367

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

1.0

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Printed on 8/19/2024

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Hi-Speed Industrial Service
7030 Ryburn Dr
Millington, Tn 38053
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AC Inspection as Found
Almatis Inc/RCP Bauxite (10014)
4701 Alcoa Road
Bauxite, AR 72011

FolderID: 103367
FormID: 21294089

AC Inspection - Rev. 2

Location: LR Motor Shop

Serial Number:

Description: 250HP US ELECTRIC MOTOR
EVAL

Hi-Speed Job Number: 103367

Manufacturer: US Motors/Nidec

HP/kW: 250 (HP)

RPM: 1770 (RPM)

Frame: 445TPA

Voltage: 460

Current: 283A

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: WPI

of Leads: 6

J-box Included: None

Coupling/Sheave: None

Date Received: 08/13/2024

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: **5 - High**

2 - Low

3 - Good

Overall Condition

1. Report Date

08/19/2024

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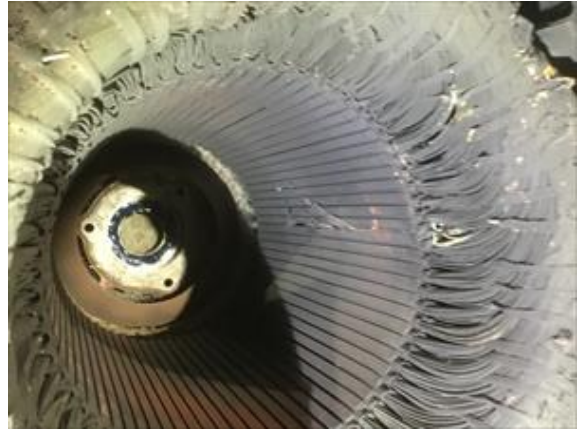
2. Nameplate Picture

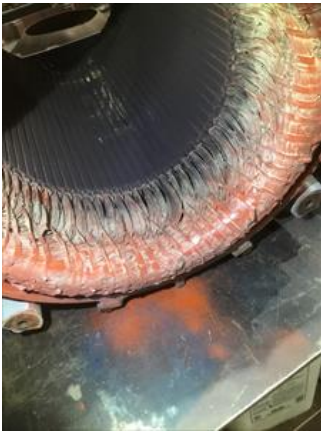


3. Photos of all six sides of the machine.









4. Describe the Overall Condition of the Equipment as Received		
<i>Dirty and signs of fire</i>		
5. Report Date [COPY]		
Initial Mechanical/Electrical		
<input checked="" type="radio"/>	6. Does Shaft Turn Freely?	(N) No
<input checked="" type="radio"/>	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
	10. Assembled Shaft End Play	inches
	11. Air Gap Variation <10%	
<input checked="" type="radio"/>	12. Lead Condition	(NA) Not Applicable
<input checked="" type="radio"/>	<i>Rewind</i>	
	13. Lead Length	16 Inches
<input checked="" type="radio"/>	14. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
<input checked="" type="radio"/>	<i>Yes</i>	
	15. Lead Numbers	1-1/2-2/3-3
	16. Frame Condition	pass
	17. Fan Condition	(N) NA
	18. Broken or Missing Components	j-box
Initial Electrical Inspection		
	19. Insulation Resistance/Megger	Megohms


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20.	Winding Resistance		
	1-2	1-3	2-3
21.	Perform Surge Test	(NA) Not Applicable	
	Windings blown		
22.	Number of Stator Slots		
23.	Stator Condition	core damage	
24.	Stator Thermistors/Ohms		
25.	Stator Overloads/Ohms		
Mechanical Inspection			
26.	Drive End Bearing Brand		
27.	Drive End Bearing Number-		
28.	Drive End Bearing Qty.		
29.	Drive End Bearing Type		
30.	Drive End Lubrication Type	(Oil) Oil Lubricated	
31.	Drive End Bearing Insulation or Grounding Device?		
32.	Drive End Wavy Washer/Snap-Ring Other Retention Device?		
33.	Drive End Bearing Condition		
34.	Opposite Drive End Bearing Brand	koyo	
35.	Opposite Drive End Bearing Number-	6215	
36.	Opposite Drive End Bearing Qty.	1	
37.	Opposite Drive End Bearing Type	(Ball) Ball Bearing	
38.	Opposite Drive End Lubrication Type	(Grease) Grease Lubricated	
39.	Opposite Drive End Bearing Insulation or Grounding Device?		
40.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?		
41.	Opposite Drive End Bearing Condition		
	Normal wear		



42. Drive End Seal	
43. Opposite Drive End Seal	
Rotor Inspection	
44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
45. Growler Test	
46. Number of Rotor Bars	
47. Rotor Condition	

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48. List the Parts needed for the Repair Below		
6215		
49. Signature of Technician that Disassembled Motor		CRW
		
Mechanical Fits- Rotor		
50. Shaft Runout	inches	
51. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
52. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
53. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
54. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
55. Drive End Bearing Shaft Fit Condition		
56. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.9531	2.9531	2.9531
57. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	
58. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings		
59. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
60. Drive End - Endbell Bearing Fit Condition		
61. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.1183	5.1184	5.1185
62. Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass	
63. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
Pass		
64. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
65. List Machine Work Needed Below		

66. Technician

Cw


 Co sign: RRW
Root Cause of Failure

67. Failure locations

Windings

68. Root cause of failure

*Contamination from bottom of stator caused windings to short to ground***Dynamic Balance Report**

69. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

70. Initial Balance Readings

Drive End

Opposite Drive End

71. Final Balance Readings

Drive End

Opposite Drive End

72. Technician

Rewind

73. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

74. Core Hot Spot Test

Pre-Burnout

Post-Burnout

75. Post Rewind Electrical Test- Insulation Resistance

76. Post Rewind Polarization Index

77. Post Rewind Winding Resistance

1-2

1-3

2-3

78. Post Rewind Surge Test

79. Post Rewind Hi-Pot

80. Technician

Assembly

81. QC Check All Parts for Cleanliness Prior to Assembly

82. Photograph All Major Components prior to assembly

83. Final Insulation Resistance Test

84. Assembled Shaft Endplay

85. Assembled Shaft Runout

86. Test Run Voltage

Volts

Volts

Volts

87. Test Run Amperage			
Amps	Amps	Amps	
88. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
89. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
90. Ambient Temperature - Fahrenheit			
91. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
92. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
93. Document Final Condition with Pictures after paint			
94. 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.
2. **PRICE.** All quoted prices shall remain firm and binding for a period of thirty (30) days from the date of quotation or for the period specifically stated in the quotation. The price for any and all goods and/or services ordered or approved by Buyer after thirty (30) days from the date of any quotation are subject to any increase in price that may occur after the expiration of thirty (30) days from the issuance of the quotation and the date the Buyer releases any shipment.
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5. **DELIVERY OF GOODS AND/OR SERVICES.** 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.
6. **DELIVERY SITE AND TIME FOR PERFORMANCE.** Hi-Speed and Buyer 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

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10. **SEVERABILITY.** The partial or complete invalidity of any provision of these Standard Terms and Conditions shall not affect the enforceability of the remainder of these Standard Terms and Conditions. If any provision is found to be invalid or unenforceable, that portion shall be modified to make it enforceable or shall be stricken and the remainder of these Standard Terms and Conditions shall enforced.
11. **GOVERNING LAW AND JURISDICTION.** Any controversy arising out of any quotation, the purchase order, the goods sold or delivered, repair or replacement thereof, or any services provided pursuant to any quotation or any purchase order, or these Standard Terms and Conditions shall be governed by the laws of the state of Tennessee without regard to any choice of law provisions and any cause of action related in any manner thereto shall be brought only in the state or federal courts of Shelby County, Tennessee.
12. **ABANDONED EQUIPMENT.** Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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.
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