



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

LR Motor Shop Repairs

**Job Number 102387**

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: 01941900-10/17-04

**1.0**

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*Printed on 2/22/2024*

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


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

FolderID: 102387  
FormID: 19136471

**AC Inspection - Rev. 2**

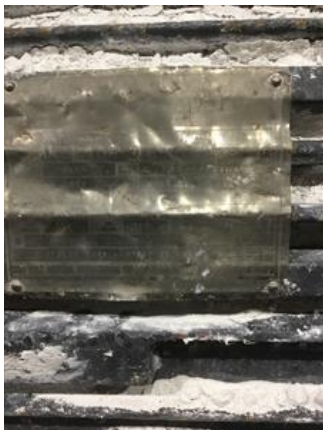
**Location:** LR Motor Shop  
**Serial Number:** 01941900-10/17-04  
**Description:** 75HP 1800RPM 365T TEFC

<b>Hi-Speed Job Number:</b>	102387
<b>Product Number:</b>	2VL 365TTFS6536BN
<b>Serial Number:</b>	01941900-10/17-04
<b>HP/kW:</b>	75 (HP)
<b>RPM:</b>	1775 (RPM)
<b>Frame:</b>	365T
<b>Voltage:</b>	460
<b>Current:</b>	86
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b>Service Factor:</b>	1.15
<b>Enclosure:</b>	TEFC
<b>Coupling/Sheave:</b>	None
<b>Bearing RTDs:</b>	No
<b>Stator RTDs:</b>	No
<b>Repair Stage:</b>	Final
<b>Heaters:</b>	No
<b>Winding Type :</b>	Random Wound
<b>Bearing Type:</b>	Rolling Element

Priorities Found:  **8 - Good**

**Overall Condition**

- |                      |            |
|----------------------|------------|
| 1. Report Date       | 01/26/2024 |
| 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

*Dirty*

#### Initial Mechanical/Electrical

5. Does Shaft Turn Freely? (Yes) Yes

6. Does Shaft Have Visible Damage? (Yes) Yes

Weld drive output and cut new keyway.



7. Assembled Shaft Runout

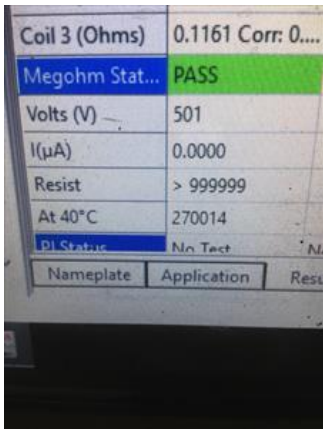
Inches

Na

8. Assembled Shaft End Play	inches
Na	
9. Air Gap Variation <10%	na
10. Lead Condition	(P) Pass
11. Lead Length	8 Inches
12. Lead Numbers	1-3
13. Frame Condition	pass
14. Fan Condition	(P) Pass



15. Broken or Missing Components	na
<b>Initial Electrical Inspection</b>	
16. Insulation Resistance/Megger	Megohms
In picture	



## 17. Winding Resistance

1-2

1-3

2-3

 In picture

Test Time	7:40:08 AM	7:28:3
Resist Status	PASS	No Te
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.0774 Corr: 0....	
L2-L3 (Ohms)	0.0774 Corr: 0....	
L3-L1 (Ohms)	0.0774 Corr: 0....	
Max Delta R %	0.063	
Coil 1 (Ohms)	0.1161 Corr: 0....	
Coil 2 (Ohms)	0.1159 Corr: 0....	
Coil 3 (Ohms)	0.1161 Corr: 0....	
Megohm Stat...	PASS	No Test
Mins (1/1)	4/11	
Nameplate	Application	Results Summ

## 18. Perform Surge Test

(P) Pass

82387	2
Tests	Trending
400V w/RTTR-101HP Step	<input type="checkbox"/> Edit Test ID <input type="checkbox"/> Enable Calibration
400V Volt	Motors
Start Auto Test	
Temperature/Resistance Tests	
Temperature	Manual
Resistance	3 Lead/low V
C Tests	
MegOhm	500 Volts
OFF	500 Volts
Drop Voltage	1500 Volts
Surge Test	Surge 1500 Volts

## 19. Number of Stator Slots

48

## 20. Stator Condition

dirty

## 21. Stator Thermistors/Ohms

na

## 22. Stator Overloads/Ohms

na

## Mechanical Inspection

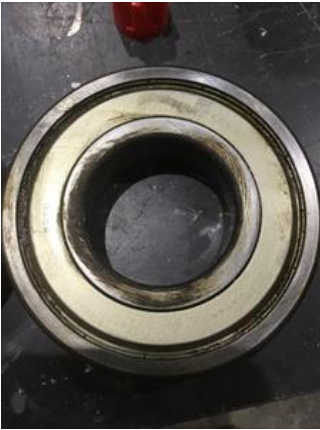
## 23. Drive End Bearing Brand

koyo



24. Drive End Bearing Number-

6314



25. Drive End Bearing Qty.	1
26. Drive End Bearing Type	(Ball) Ball Bearing
27. Drive End Lubrication Type	(Grease) Grease Lubricated
28. Drive End Bearing Insulation or Grounding Device?	na
29. Drive End Wavy Washer/Snap-Ring Other Retention Device?	na
30. Drive End Bearing Condition	signs of contamination



31. Opposite Drive End Bearing Brand	koyo
32. Opposite Drive End Bearing Number-	6312




33. Opposite Drive End Bearing Qty.	1
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34. Opposite Drive End Bearing Type	(Ball) Ball Bearing
35. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
36. Opposite Drive End Bearing Insulation or Grounding Device?	na
37. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
38. Opposite Drive End Bearing Condition	
Signs of contamination	



39.	Drive End Seal	na
40.	Opposite Drive End Seal	na
Rotor Inspection		
41.	Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
42.	Growler Test	(Pass) Pass
43.	Number of Rotor Bars	40
44.	Rotor Condition	pass needs cleaning
45.	List the Parts needed for the Repair Below 6314 6312	
46.	Signature of Technician that Disassembled Motor	Cw
		
Mechanical Fits- Rotor		
47.	Shaft Runout	0.002 inches
48.	Rotor Runout	
	Drive End Bearing Fit	Rotor Body
		Opposite Drive End Bearing
	Na	
49.	Coupling Fit Closest to Bearing Housing	
	0 Degrees	90 Degrees
		120 Degrees
	Na	

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50. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
Na		
51. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.756	2.756	2.756
52. Drive End Bearing Shaft Fit Condition		(P) Pass
53. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.3623	2.3623	2.3624
54. Opposite Drive End Bearing Shaft Fit Condition		(P) Pass
55. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
<b>Mechanical Fits- Bearing Housings</b>		
56. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.9054	5.9055	5.9055
57. Drive End - Endbell Bearing Fit Condition		(P) Pass
58. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.1179	5.118	5.118
59. Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
60. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
Pass		



61. End Bell Air Seal Fits	
Drive End Air Seal	Opposite Drive End Air Seal
Na	
62. List Machine Work Needed Below	
ODE shaft bearing fit	

63. Technician

Cw


**Root Cause of Failure**

64. Failure locations

*Bearings and ODE shaft bearing fit*

65. Root cause of failure

*Wear and contamination***Dynamic Balance Report**

66. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

67. Initial Balance Readings

Drive End

Opposite Drive End

68. Final Balance Readings

Drive End

Opposite Drive End

69. Technician

**Rewind**

70. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

71. Core Hot Spot Test

Pre-Burnout

Post-Burnout

72. Post Rewind Electrical Test- Insulation Resistance

73. Post Rewind Polarization Index

74. Post Rewind Winding Resistance

1-2

1-3

2-3

75. Post Rewind Surge Test

76. Post Rewind Hi-Pot

77. Technician

**Mechanical Fits- Rotor - Post Repair**

78. Shaft Runout Post Repair

79. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

80. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees


120 Degrees

81. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

82. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
83. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
84. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
85. Shaft Repair Sign-off		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
86. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
87. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
88. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
89. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
90. End Bell Repair Sign-off		
<b>Assembly</b>		
91. QC Check All Parts for Cleanliness Prior to Assembly		Cw
		
92. Photograph All Major Components prior to assembly		







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93. Final Insulation Resistance Test	Megohms	
Na		
94. Assembled Shaft Endplay	inches	
Na		
95. Assembled Shaft Runout	inches	
Na		
96. Test Run Voltage		
Volts	Volts	Volts



97. Test Run Amperage
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Amps

Amps

Amps



## 98. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

**0.02****0.03****0.03**

## 99. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

**0.02****0.04****0.03**

## 100. Ambient Temperature - Fahrenheit

Na

## 101. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

## 102. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

103. Document Final Condition with Pictures after paint



104. Final Pics and QC Review

Cw

A handwritten signature in black ink, appearing to be 'Chris', is written across the page.



Co Sign: RRW



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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.
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