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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 102266**

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: *C 05 7767454-0020 M 0001*

**1.0**

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Hi-Speed Industrial Service  
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901-873-5300

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

FolderID: 102266  
FormID: 18855490

### AC Inspection - Rev. 2

**Location:** LR Motor Shop  
**Serial Number:** C 05 7767454-0020 M 0001  
**Description:** 40HP US MOTORS 1800RPM 324T

<b>Hi-Speed Job Number:</b>	102266
<b>Manufacturer:</b>	US Motors/Nidec
<b>Product Number:</b>	HD40P2E
<b>Serial Number:</b>	C 05 7767454-0020 M 0001
<b>HP/kW:</b>	40 (HP)
<b>RPM:</b>	1780 (RPM)
<b>Frame:</b>	324T
<b>Voltage:</b>	230 / 460
<b>Current:</b>	92/46
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b>Service Factor:</b>	1.15
<b>Enclosure:</b>	TEFC
<b>J-box Included:</b>	Complete
<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: ● 2 - High ● 11 - Good

### Overall Condition

1. Report Date
2. Nameplate Picture



3. Photos of all six sides of the machine.

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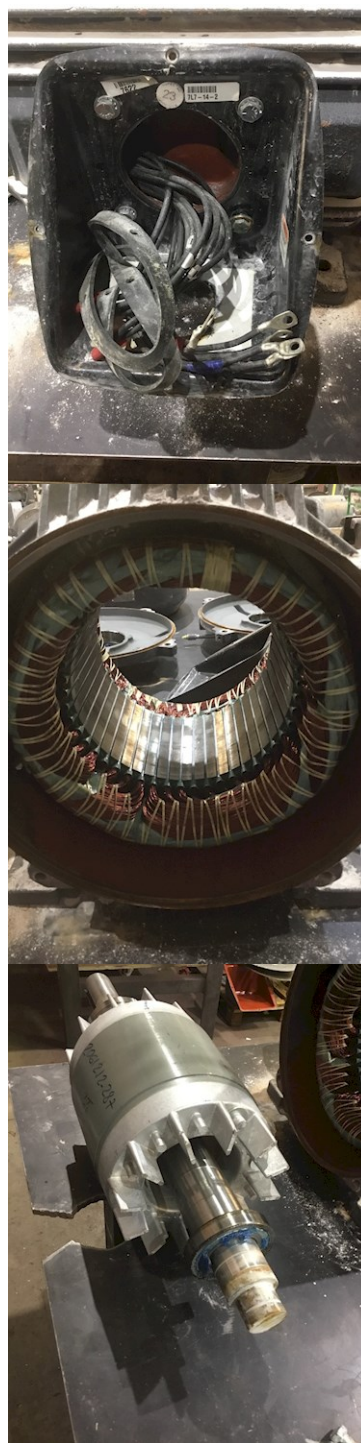


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1.2



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4.	Describe the Overall Condition of the Equipment as Received	
	Dirty	
5.	Distance from the end of the shaft to the Coupling/Sheave	inches
	Na	
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	(Yes) Yes
7.	Does Shaft Have Visible Damage?	(No) No
8.	Assembled Shaft Runout	0.002 Inches
9.	Assembled Shaft End Play	inches
	Na	
10.	Air Gap Variation <10%	
	Na	
11.	Lead Condition	(P) Pass
12.	Lead Length	12 Inches
13.	Lead Numbers	1-12
14.	Stator Temperature Detector Rating and Function	
	Quantity	Rating
	Quantity Passed	
	Na	
15.	Bearing Temperature Detector Rating and Function	
	Quantity	Rating
	Quantity Passed	
	Na	
16.	Frame Condition	pass

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17. Fan Condition

(P) Pass



18. Heater Quantity, Ratings

Quantity	Volts/Watts	Pass/Fail
Na		

19. Broken or Missing Components

na

Initial Electrical Inspection

20. Insulation Resistance/Megger

Megohms

In picture

Coil 2 (Ohms)	0.109	Corr: 0.1...
Coil 3 (Ohms)	0.109	Corr: 0.1...
Megohm Stat...	PASS	No Test
Volts (V)	504	
I(μA)	0.0041	
Resist	122470	
At 40°C	33068	
DI Status	No Test	No Test
Nameplate	Application	Results Summary

## 21. Winding Resistance

1-2

1-3

2-3

In picture

Test Time	7:07:02 AM	6:54:21 AM
IR Temp Com...	Thermoplastic	None
Resist Status	PASS	No Test
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.218 Corr: 0.2...	
L2-L3 (Ohms)	0.218 Corr: 0.2...	
L3-L1 (Ohms)	0.218 Corr: 0.2...	
Max Delta R %	0.191	
Coil 1 (Ohms)	0.109 Corr: 0.1...	
Coil 2 (Ohms)	0.109 Corr: 0.1...	
Coil 3 (Ohms)	0.109 Corr: 0.1...	
Min Ohm Stat	PASS	No Test
Nameplate	Application	Results Summary

## 22. Perform Surge Test

(P) Pass

102266	2
Tests	Trending
ID: 480V w/cRTR-101HP Step	Edit Test ID Enable Calibration
or 480 Volt Motors	
Run Auto Test	
Temperature/Resistance Tests	
Temperature Manual	Tested
Resistance 3 Lead/low V	PASS
DC Tests	
500V MegOhm 500 Volts	PASS
500V 500 Volts	
Step Voltage 1500 Volts	PASS
Surge Test	
Surge 1500 Volts	PASS

## 23. Number of Stator Slots

48

## 24. Stator Condition

pass

## 25. Stator Thermistors/Ohms

Na

## 26. Stator Overloads/Ohms

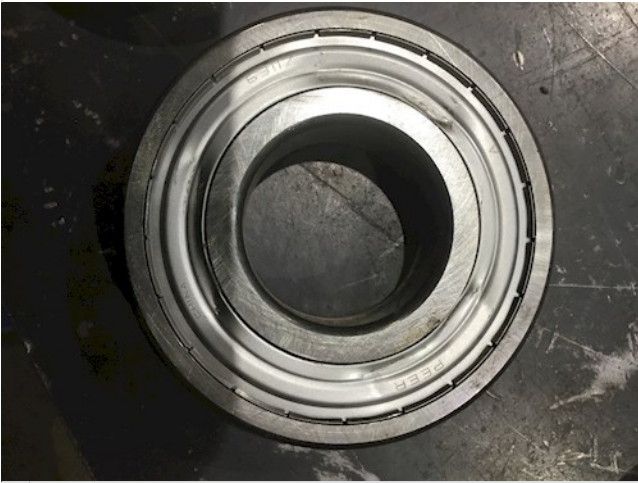
Na

## Mechanical Inspection



27. Drive End Bearing Brand

peer



28. Drive End Bearing Number-

6311

29. Drive End Bearing Qty.

1

30. Drive End Bearing Type

(Ball) Ball Bearing

31. Drive End Lubrication Type

(Grease) Grease Lubricated

32. Drive End Bearing Insulation or Grounding Device?

Na

33. Drive End Wavy Washer/Snap-Ring Other Retention Device?

na

34. Drive End Bearing Condition

Signs of frosting







35. Opposite Drive End Bearing Brand


skf




36. Opposite Drive End Bearing Number-	6211
37. Opposite Drive End Bearing Qty.	1
38. Opposite Drive End Bearing Type	(Ball) Ball Bearing
39. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
40. Opposite Drive End Bearing Insulation or Grounding Device?	na
41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
42. Opposite Drive End Bearing Condition	
<div> <div></div> <div>Signs of frosting</div> </div>	



43. Drive End Seal			
 <i>Slinger</i>			
44. Opposite Drive End Seal			
 <i>Na</i>			
45. DE Sleeve Bearing Inside Diameter			
0 degrees	120 degrees	240 degrees	
 <i>Na</i>			
46. DE Sleeve Bearing Outside Diameter			
0 degrees	120 degrees	240 degrees	
 <i>Na</i>			

47. DE Sleeve Bearing Housing Inside Diameter		
0 degrees	120 degrees	240 degrees
Na		
48. DE Sleeve Bearing to Housing Clearance		
0 degrees	120 degrees	240 degrees
Na		
49. ODE Sleeve Bearing Inside Diameter		
0 degrees	120 degrees	240 degrees
Na		
50. ODE Sleeve Bearing Outside Diameter		
0 degrees	120 degrees	240 degrees
Na		
51. ODE Sleeve Bearing Housing Inside Diameter		
0 degrees	120 degrees	240 degrees
Na		
52. ODE Sleeve Bearing to Housing Clearance		
0 degrees	120 degrees	240 degrees
Na		
<b>Rotor Inspection</b>		
53. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast	
54. Growler Test	(Pass) Pass	
55. Number of Rotor Bars	56	
56. Rotor Condition	pass	
57. List the Parts needed for the Repair Below		
6311 6211 Aegis ring-2.6070		
58. Signature of Technician that Disassembled Motor	Cw	
		
<b>Mechanical Fits- Rotor</b>		
59. Shaft Runout	inches	
0.002		
60. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
Na		










61. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
Na			
62. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
Na			
63. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.1655	2.1653	2.1654	
64. Drive End Bearing Shaft Fit Condition			(P) Pass
65. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.1655	2.1655	2.1654	
66. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
67. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Na			
<b>Mechanical Fits- Bearing Housings</b>			
68. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
4.7255	4.7254	4.7254	
69. Drive End - Endbell Bearing Fit Condition			(P) Pass
70. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
3.9379	3.9379	3.938	
71. Opposite Drive End - Endbell Bearing Fit Condition			(P) Pass
72. Bearing Cap Condition			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
Na			
73. End Bell Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Na			
74. List Machine Work Needed Below			
Na			
75. Technician			Cw
			
<b>Root Cause of Failure</b>			
76. Failure locations			
Bearings			

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77. Root cause of failure			
<i>Bearings have frosting other than that motor is in good shape</i>			
<b>Dynamic Balance Report</b>			
78. Rotor Weight and Balance Grade			
Rotor Weight		Balance Grade	
Na			
79. Initial Balance Readings			
Drive End		Opposite Drive End	
Na			
80. Final Balance Readings			
Drive End		Opposite Drive End	
Na			
81. Technician			
Na			
<b>Rewind</b>			
82. Core Test Results - Watts loss per Pound			
Pre-Burnout		Post Burnout	
Na			
83. Core Hot Spot Test			
Pre-Burnout		Post-Burnout	
Na			
84. Post Rewind Electrical Test- Insulation Resistance			Megohms
Na			
85. Post Rewind Polarization Index			Polarization Index
Na			
86. Post Rewind Winding Resistance			
1-2	1-3	2-3	
Na			
87. Post Rewind Surge Test			
Na			
88. Post Rewind Hi-Pot			micro-amps
Na			
89. Technician			
Na			
<b>Mechanical Fits- Rotor - Post Repair</b>			
90. Shaft Runout Post Repair			inches
Na			
91. Rotor Runout Post Repair			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
Na			

92. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
 Na		
93. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
 Na		
94. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
 Na		
95. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
 Na		
96. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
 Na		
97. Shaft Repair Sign-off		
 Na		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
98. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
 Na		
99. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
 Na		
100. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
 Na		
101. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
 Na		
102. DE Sleeve Bearing Inside ID Post Repair		
Measure 1	Measure 2	Measure 3
 Na		
103. DE Sleeve Bearing Outside ID Post Repair		
Measure 1	Measure 2	Measure 3
 Na		



104. DE Sleeve Bearing Inside OD Post Repair		
Measure 1	Measure 2	Measure 3
 Na		
105. DE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
 Na		
106. End Bell Repair Sign-off		
 Na		
107. ODE Sleeve Bearing Inside ID Post Repair		
Measure 1	Measure 2	Measure 3
 Na		
108. ODE Sleeve Bearing Outside ID Post Repair		
Measure 1	Measure 2	Measure 3
 Na		
109. ODE Sleeve Bearing Inside OD Post Repair		
Measure 1	Measure 2	Measure 3
 Na		
110. ODE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
 Na		
<b>Assembly</b>		






113. Final Insulation Resistance Test	Megohms		
Na			
114. Assembled Shaft Endplay	inches		
Na			
115. Assembled Shaft Runout	inches		
Na			
116. Test Run Voltage			
Volts	Volts	Volts	



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117. Test Run Amperage

Amps

Amps

Amps



118. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

Na

119. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

Na

120. Ambient Temperature - Fahrenheit

Na

121. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

122. Drive End Bearing Temps - Fahrenheit 20-30 Minutes

20 Minutes

25 Minutes

30 Minutes

Na

123. Drive End Bearing Temps - Fahrenheit 35-45 Minutes

35 Minutes

40 Minutes

45 Minutes

Na

124. Drive End Bearing Temps - Fahrenheit 50-60 Minutes

50 Minutes

55 Minutes

60 Minutes

Na

125. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

126. Opposite Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
<div> <div></div> <div>Na</div> </div>		
127. Opposite Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
<div> <div></div> <div>Na</div> </div>		
128. Opposite Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
<div> <div></div> <div>Na</div> </div>		
129. Stator Temperatures- Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
<div> <div></div> <div>Na</div> </div>		
130. Stator Temperatures- Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
<div> <div></div> <div>Na</div> </div>		
131. Stator Temperatures- Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
<div> <div></div> <div>Na</div> </div>		
132. Stator Temperatures- Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
<div> <div></div> <div>Na</div> </div>		
133. Document Final Condition with Pictures after paint		



134. Final Pics and QC Review	ZTW
<div> <div></div> <div></div> </div>	
<div> <div></div> <div>Co sign: CRW</div> </div>	

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9. **LIMITATION OF DAMAGES.** HI-SPEED SHALL HAVE NO LIABILITY TO BUYER WITH RESPECT TO THE SALE OR DELIVERY OF ANY GOODS OR THE REPAIR THEREOF OR WITH RESPECT TO THE SALE OR PERFORMANCE OF ANY SERVICES, FOR LOST PROFITS, SPECIAL, CONSEQUENTIAL, EXEMPLARY, PUNITIVE OR INCIDENTAL DAMAGES OF ANY KIND OR NATURE WHETHER ARISING IN CONTRACT, TORT, GOODS LIABILITY OR OTHERWISE, EVEN IF HI-SPEED WAS ADVISED OF THE POSSIBILITY OF SUCH LOSS OR DAMAGES. HI-SPEED SHALL NOT BE LIABLE FOR ANY DAMAGES OR DELAYS CAUSED BY ANY FAILURE TO MAKE ANY DELIVERY OF GOODS BY ANY EXPECTED TIME OR DATE OR THE FAILURE TO PROVIDE OR COMPLETE ANY SERVICES BY ANY EXPECTED DATE OR TIME. IN NO EVENT SHALL HI-SPEED BE LIABLE TO BUYER FOR ANY DAMAGES WHATSOEVER IN EXCESS OF THE TOTAL PRICE PAID FOR ALL GOODS AND/OR SERVICES HEREUNDER OR REFERENCED IN ANY QUOTATION OR THE PURCHASE ORDER.
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.
14. **NONWAIVER.** No course of dealing or failure of either party to strictly enforce any term, right, or condition of these Standard Terms and Conditions will be construed as a waiver of such term, right or condition. Any waiver by Hi-Speed will only be in writing and will waive no succeeding breach of a term, right or condition.
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.