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LR Motor Shop Repairs

Job Number 102265

Prepared for Almatris Inc/RCP Bauxite (10014)

4701 Alcoa Road
Bauxite AR 72011

Table of Contents

AC Inspection as Found - *LR Motor Shop*

AC Inspection - Rev. 2: 41870

1.0

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Table of Contents



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AC Inspection as Found

Almatis Inc/RCP Bauxite (10014)
4701 Alcoa Road
Bauxite, AR 72011

FolderID: 102265
FormID: 18854853

AC Inspection - Rev. 2

Location: LR Motor Shop

Serial Number: 41870

Description: 50HP RELIANCE 1200RPM 365T

Hi-Speed Job Number: 102265

Manufacturer: Reliance

Serial Number: 41870

HP/kW: 50 (HP)

RPM: 1200 (RPM)

Frame: 365T

Voltage: 460

Current: 65

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

J-box Included: Complete

Coupling/Sheave: None

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Heaters: No

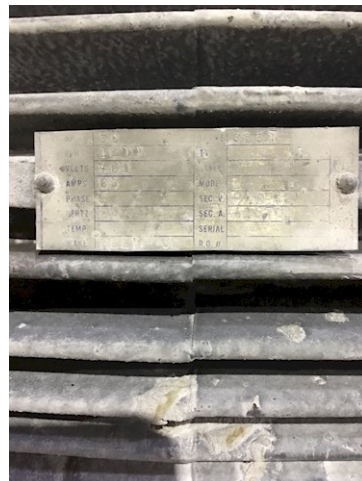
Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 2 - High ● 7 - Good

Overall Condition

1. Report Date
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?	(No) No
● 7.	Assembled Shaft Runout	0.0015 Inches
8.	Assembled Shaft End Play	inches
■	Na	
9.	Air Gap Variation <10%	
■	Na	
● 10.	Lead Condition	(P) Pass
11.	Lead Length	18 Inches



12.	Lead Numbers	■ Na
13.	Frame Condition	Pass

14. Fan Condition

(P) Pass



15. Broken or Missing Components

fan cover bolt holes in end bell broke

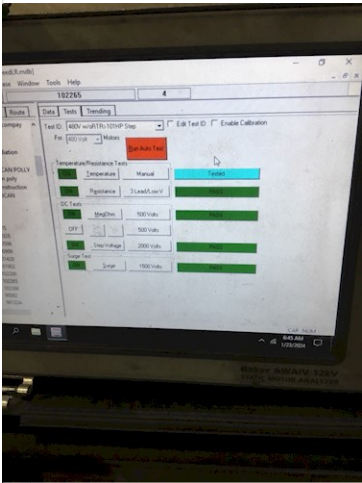


Initial Electrical Inspection

16. Insulation Resistance/Megger	6780 Megohms	
17. Winding Resistance		
1-2	1-3	2-3
.250	.250	.251

18. Perform Surge Test

(P) Pass



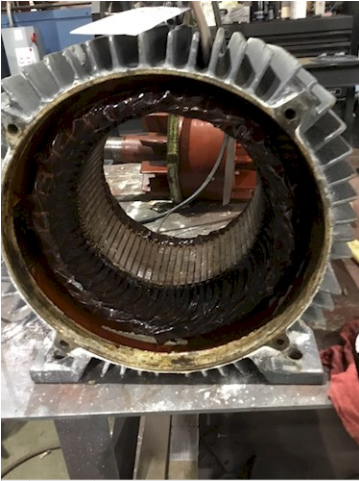
19. Number of Stator Slots

54

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20. Stator Condition

windings are dark from being hot



21. Stator Thermistors/Ohms

Na

22. Stator Overloads/Ohms

Na

Mechanical Inspection

23. Drive End Bearing Brand

SKF

24. Drive End Bearing Number-

6313

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

 *The start of fluting*



Start of fluting

31. Opposite Drive End Bearing Brand	SKF
32. Opposite Drive End Bearing Number-	6210
33. Opposite Drive End Bearing Qty.	1
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?	
 <i>Na</i>	
37. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	Wavy washer
38. Opposite Drive End Bearing Condition	
 <i>Normal wear</i>	



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	60
44. Rotor Condition	clean



45. List the Parts needed for the Repair Below

6313 6210 Bearing

46. Signature of Technician that Disassembled Motor

RW

RW

Mechanical Fits- Rotor

47. Shaft Runout

0.0015 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

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

2.5592



2.5592

2.5592



52. Drive End Bearing Shaft Fit Condition

(P) Pass

53. Opposite Drive End Bearing Shaft Fit			
0 Degrees		60 Degrees	120 Degrees
1.9686		1.9686	1.9686
			
54. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
55. Shaft Air Seal Fits			
Drive End Air Seal		Opposite Drive End Air Seal	
<div>Na</div>			
Mechanical Fits- Bearing Housings			
56. Drive End - Endbell Bearing Fit			
0 Degrees		60 Degrees	120 Degrees
5.5164		5.5134	5.5128
			
57. Drive End - Endbell Bearing Fit Condition			(F) Fail
58. Opposite Drive End - Endbell Bearing Fit			
0 Degrees		60 Degrees	120 Degrees
3.5434		3.5434	3.5434



60. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Na

61. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

62. List Machine Work Needed Below

DE end bell bearing fit .fan cover bolt hole broke out of end bell

63. Technician

RW

Root Cause of Failure

64. Failure locations

DE end bell bearing shows the start of fluting also de bearing fit bad

65. Root cause of failure

Na

Dynamic Balance Report

66. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

Na

67. Initial Balance Readings

Drive End

Opposite Drive End

0.17

0.33

68. Final Balance Readings

Drive End

Opposite Drive End



69. Technician

RW

Rewind

70. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

Na

71. Core Hot Spot Test

Pre-Burnout

Post-Burnout

Na

72. Post Rewind Electrical Test- Insulation Resistance

Megohms

Na

73. Post Rewind Polarization Index

Polarization Index

Na

74. Post Rewind Winding Resistance

1-2

1-3

2-3

Na

75. Post Rewind Surge Test

(Pass) Pass

76. Post Rewind Hi-Pot

micro-amps

Na

77. Technician

Na

Mechanical Fits- Rotor - Post Repair

78. Shaft Runout Post Repair

inches

Na

79. Rotor Runout Post Repair			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
Na			
80. Coupling Fit Closest to Bearing Housing Post Repair			
0 Degrees	90 Degrees	120 Degrees	
Na			
81. Coupling Fit Closest to the end of the Shaft Post Repair			
0 Degrees	60 Degrees	120 Degrees	
Na			
82. Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
Na			
83. Opposite Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
Na			
84. Shaft Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
Na			
85. Shaft Repair Sign-off			
Na			
Mechanical Fits- Bearing Housings - Post Repair			
86. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
5.5125	5.5126	5.5125	



87. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
N/A			

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88. Bearing Cap Condition Post Repair		
Drive End Bearing Cap		Opposite Drive End Bearing Cap
<div><div></div><div>N/A</div></div>		
89. End Bell Air Seal Fits Post Repair		
Drive End Air Seal		Opposite Drive End Air Seal
<div><div></div><div>N/A</div></div>		
90. End Bell Repair Sign-off		Gary
<div><div></div><div></div></div>		
Assembly		
91. QC Check All Parts for Cleanliness Prior to Assembly		RW
<div><div></div><div></div></div>		
92. Photograph All Major Components prior to assembly		(Complete) Complete





93. Final Insulation Resistance Test

18,670 Megohms

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94. Assembled Shaft Endplay	inches	
Na		
95. Assembled Shaft Runout		
96. Test Run Voltage		
Volts	Volts	Volts
457	456	455
458-457-457		



With out fan



With fan

97. Test Run Amperage

Amps	Amps	Amps
19.7	19.8	20
<div> <div></div> 19.9-20.0-20.2 </div>		



With out fan



With fan

98. Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
0.02	0.02	0.008999999999999999

99. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
0.03	0.03	0.02

100. Ambient Temperature - Fahrenheit

Na

101. Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes
<div> <div></div> Na </div>		

102. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes
<div> <div></div> Na </div>		

103. Document Final Condition with Pictures after paint



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104. Final Pics and QC Review

RW

Handwritten signature "RW" in black ink.



Co witness CRW



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