



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

LR Motor Shop Repairs

**Job Number 102807**

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: *E17577-01*

**1.0**

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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: 102807  
FormID: 20122158

**AC Inspection - Rev. 2**

**Location:** LR Motor Shop

**Serial Number:** E17577-01

**Description:** 800 HP SIEMENS 3567 RPM

**Hi-Speed Job Number:** 102807

**Manufacturer:** Siemens

**Serial Number:** E17577-01

**HP/kW:** 800 (HP)

**RPM:** 3567 (RPM)

**Frame:** 5010Y

**Voltage:** 4160

**Phase:** Three

**Hz:** 60 (Hz)

**Service Factor:** 1.15

**Enclosure:** TEFC

**Repair Stage:** Final

**Rewind:** Yes

**Shaft Machined Fit Repairs  
Required:** No

**Bearing Housing Machined  
Fit Repairs Required:** Yes

**Heaters:** No

**Winding Type :** Form Coil

**Bearing Type:** Rolling Element

Priorities Found: ● 3 - High ● 7 - Good

**Overall Condition**

- |                      |            |
|----------------------|------------|
| 1. Report Date       | 04/22/2024 |
| 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	
	<i>Both internal fans had a catastrophic failure. Both endbells are worn. Opposite side bearing came apart.</i>	
5.	Distance from the end of the shaft to the Coupling/Sheave	0 inches
	<i>Coupling flush with shaft</i>	
<b>Initial Mechanical/Electrical</b>		
6.	Does Shaft Turn Freely?	(Y) Yes
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	0.001 Inches

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10. Assembled Shaft End Play	inches	
Na		
11. Air Gap Variation <10%		
Na		
12. Lead Condition	(P) Pass	
13. Lead Length	30 Inches	
14. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes	
Wrong size lugs. Needs 4 AWG		
15. Lead Numbers	123	
16. Stator Temperature Detector Rating and Function		
Quantity	Rating	Quantity Passed
8	110	8



17. Bearing Temperature Detector Rating and Function		
Quantity	Rating	Quantity Passed
2	110	2
18. Frame Condition	good	
19. Fan Condition	(F) Fail	

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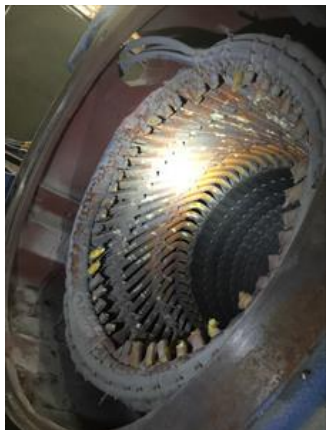
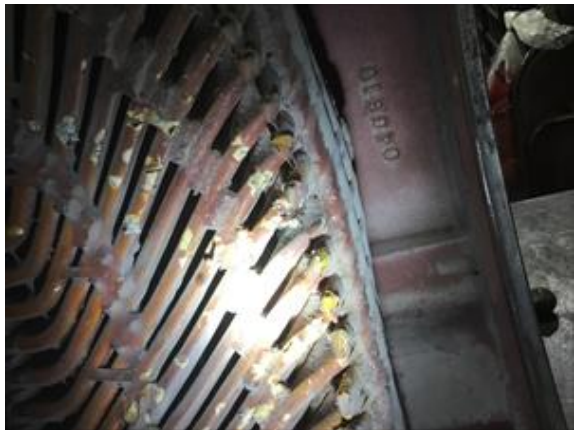
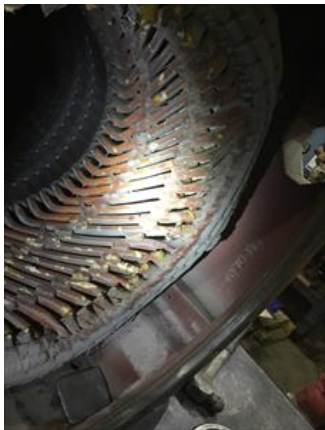


20. Broken or Missing Components	fan is broken		
Initial Electrical Inspection			
21. Insulation Resistance/Megger	Megohms		
 Na			
22. Winding Resistance			
1-2	1-3	2-3	
 Na			
23. Perform Surge Test			
 Na			
24. Number of Stator Slots	48		



25. Stator Condition

rewind



26. Stator Thermistors/Ohms

Na

27. Stator Overloads/Ohms

Na

**Mechanical Inspection**

28. Drive End Bearing Brand

**FAG**

29. Drive End Bearing Number-

**6315 2Z c3**

30. Drive End Bearing Qty.

**1**

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31. Drive End Bearing Type	(Ball) Ball Bearing
32. Drive End Lubrication Type	(Grease) Grease Lubricated



33. Drive End Bearing Insulation or Grounding Device?	no
34. Drive End Wavy Washer/Snap-Ring Other Retention Device?	no
35. Drive End Bearing Condition	fail
36. Opposite Drive End Bearing Brand	FAG



37. Opposite Drive End Bearing Number-	6315 2Z c3
38. Opposite Drive End Bearing Qty.	1
39. Opposite Drive End Bearing Type	(Ball) Ball Bearing
40. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated

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41. Opposite Drive End Bearing Insulation or Grounding Device?	no
42. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	no
43. Opposite Drive End Bearing Condition	fail
Cage came apart	



44. Drive End Seal	Na
45. Opposite Drive End Seal	Na

#### Rotor Inspection

46. Rotor Type/Material	(Copper Barred) Copper Barred Rotor
47. Growler Test	(Pass) Pass
48. Number of Rotor Bars	40
49. Rotor Condition	good
50. List the Parts needed for the Repair Below	6315, 6315, 2 internal shaft fans, rewind
51. Signature of Technician that Disassembled Motor	Trevor Hall

#### Mechanical Fits- Rotor

52.	Shaft Runout	0 inches	
53.	Rotor Runout		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
	0	0	0
54.	Coupling Fit Closest to Bearing Housing		
	0 Degrees	90 Degrees	120 Degrees
	2.7569	2.7568	2.7567
55.	Coupling Fit Closest to the end of the Shaft		
	0 Degrees	60 Degrees	120 Degrees
	2.7563	2.756	2.7565
56.	Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	2.9533	2.9533	2.9533
57.	Drive End Bearing Shaft Fit Condition	(P) Pass	
58.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	2.953	2.9533	2.9533

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59.	Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
60.	Shaft Air Seal Fits			
	Drive End Air Seal		Opposite Drive End Air Seal	
	ok		ok	
Mechanical Fits- Bearing Housings				
61.	Drive End - Endbell Bearing Fit			
	0 Degrees		60 Degrees	120 Degrees
	6.302		6.3025	6.302



62.	Drive End - Endbell Bearing Fit Condition	(P) Pass	
63.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	6.3002	6.3003	6.3003



64.	Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass	
65.	Bearing Cap Condition		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	ok	ok	
66.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
	ok	ok	
67.	List Machine Work Needed Below		
	<i>Sleeve DE endbell</i>		

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68. Technician

David Maclin


**Root Cause of Failure**

69. Failure locations

*Ode bearing*

70. Root cause of failure

*Fatigue***Dynamic Balance Report**

71. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

72. Initial Balance Readings

Drive End

Opposite Drive End

73. Final Balance Readings

Drive End

Opposite Drive End

74. Technician

**Rewind**

75. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

76. Core Hot Spot Test

Pre-Burnout

Post-Burnout

77. Post Rewind Electrical Test- Insulation Resistance

78. Post Rewind Polarization Index

79. Post Rewind Winding Resistance

1-2

1-3

2-3

80. Post Rewind Surge Test

81. Post Rewind Hi-Pot

82. Technician

**Mechanical Fits- Bearing Housings - Post Repair**

83. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

84. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

85. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

86. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
87. End Bell Repair Sign-off		
<b>Assembly</b>		
88. QC Check All Parts for Cleanliness Prior to Assembly		
89. Photograph All Major Components prior to assembly		
90. Final Insulation Resistance Test		
91. Assembled Shaft Endplay		
92. Assembled Shaft Runout		
93. Test Run Voltage		
Volts	Volts	Volts
94. Test Run Amperage		
Amps	Amps	Amps
95. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
96. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
97. Ambient Temperature - Fahrenheit		
98. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
99. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
100. Stator Temperatures- Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
101. Document Final Condition with Pictures after paint		
102. Final Pics and QC Review		



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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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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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