



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

Table of Contents

AC Inspection as Found - *LR Motor Shop*

AC Inspection - Rev. 2: *E17577-01*

1.0

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Printed on 5/10/2024

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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: 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: ● **4 - 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>	
Initial Mechanical/Electrical		
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

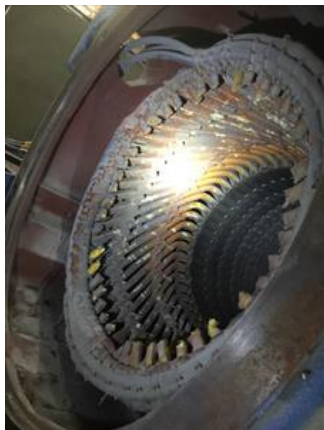
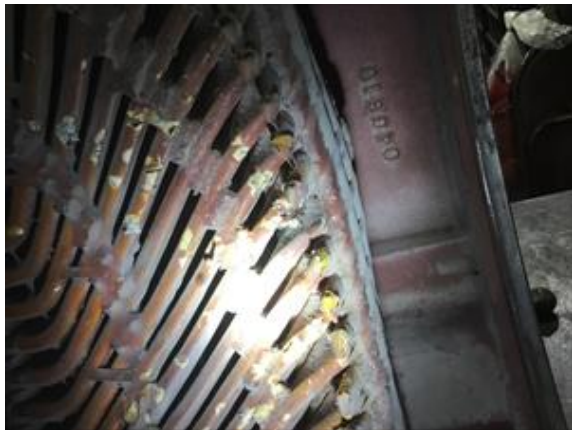
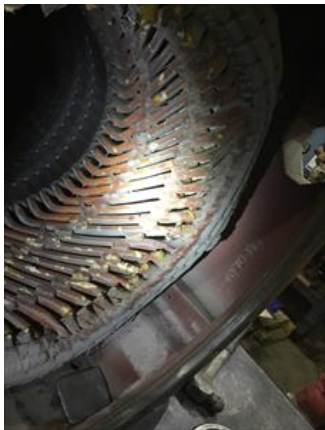


17. Bearing Temperature Detector Rating and Function		
Quantity	Rating	Quantity Passed
2	110	2
18. Frame Condition	good	
19. Fan Condition	(F) Fail	

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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



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	(Aluminum Bar) Aluminum 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
	6.304		6.304	6.304



62. Drive End - Endbell Bearing Fit Condition	(F) Fail		
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		
	Sleeve DE endbell		

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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

.074**1.11**

73. Final Balance Readings

Drive End

Opposite Drive End

0.04**.10**

74. Technician

RW


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

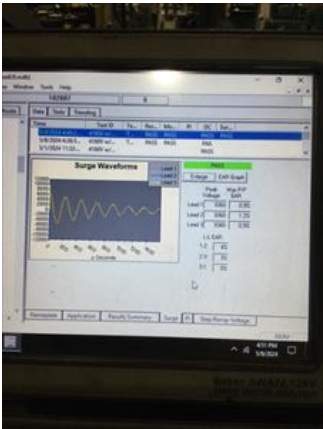
24500 Megohms

78. Post Rewind Polarization Index

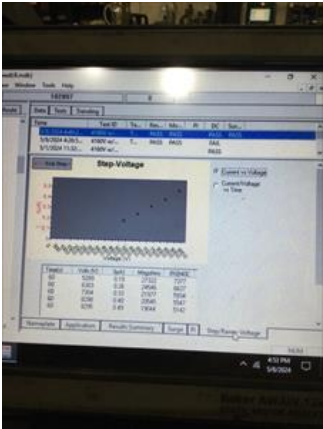
Polarization Index

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79. Post Rewind Winding Resistance		
1-2	1-3	2-3
0.492	0.492	0.49
80. Post Rewind Surge Test		(Pass) Pass



● 81. Post Rewind Hi-Pot	micro-amps
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82. Technician
Mechanical Fits- Bearing Housings - Post Repair

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83. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
6.2998	6.2998	6.2998



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		Gary
		

Assembly		
88. QC Check All Parts for Cleanliness Prior to Assembly		RW
		

89. Photograph All Major Components prior to assembly

(Complete) Complete



90. Final Insulation Resistance Test

13590 Megohms



91. Assembled Shaft Endplay

92. Assembled Shaft Runout

93. Test Run Voltage		
Volts	Volts	Volts
4117	4135	4162



Co witness Trevor Hall

94. Test Run Amperage		
Amps	Amps	Amps
23.5	22.2	22.7



95. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.008999999999999999	0.02	0.008999999999999999
96. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.02	0.01	0.02
97. Ambient Temperature - Fahrenheit		79
98. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
81	83	86
99. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
105	108	112

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100. Stator Temperatures- Fahrenheit			
	5 Minutes	10 Minutes	15 Minutes
101. Document Final Condition with Pictures after paint			



102. Final Pics and QC Review	RW
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AL



Co witness Trevor Hall



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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.
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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

replace any defective or non-conforming goods in accordance with the applicable manufacturer's warranty. Warranty for any defective or incorrect parts is limited to the repair or replacement of those parts. Hi-Speed warrants that all services will conform in all material respects to the description of services identified in the quotation and will be performed in a good and workmanlike manner in accordance with industry practices and standards. Should the services be reasonably rejected or not conform with the foregoing warranties, Hi-Speed shall, at its sole cost, re-perform the defective or nonconforming services. Notwithstanding the foregoing, these warranties do not extend to goods or services to the extent that such goods have been subject to misuse, neglect or abuse not caused by Hi-Speed or have been used in violation of the approved written instructions furnished to Buyer. THE FOREGOING REPRESENTS THE SOLE AND EXCLUSIVE WARRANTY GIVEN BY HI-SPEED WITH RESPECT TO ALL GOODS SOLD AND IS IN LIEU OF ALL OTHER WARRANTIES EITHER EXPRESS OR IMPLIED. HI-SPEED EXPRESSLY DISCLAIMS ALL OTHER WARRANTIES INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR USE OR PURPOSE. BUYER WAIVES ANY CLAIM THAT THESE EXCLUSIONS OR LIMITATIONS DEPRIVE IT OF AN ADEQUATE REMEDY AT EQUITY OR LAW OR CAUSE THIS AGREEMENT TO FAIL IN ITS ESSENTIAL PURPOSE. BUYER SHALL BE ENTITLED TO NO OTHER REMEDY OTHER THAN AS SET FORTH HEREIN, REGARDLESS OF THE CLAIM OR CAUSE OF ACTION, WHETHER BASED IN CONTRACT, TORT, NEGLIGENCE, GOODS LIABILITY, STRICT LIABILITY OR OTHERWISE.

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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.
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.