



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

LR Motor Shop Repairs

Job Number 102874

Prepared for Arauco-Malvern MDF (10298)

1275 Willamette Rd
Malvern AR 72104

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AC Inspection as Found - *LR MOTORSHOP*

AC Inspection - Rev. 2: 02-C191G7611664-21 1

1.0

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Printed on 6/25/2024

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Hi-Speed Industrial Service
7030 Ryburn Dr
Millington, Tn 38053
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AC Inspection as Found

Arauco-Malvern MDF (10298)

1275 Willamette Rd
Malvern, AR 72104

FolderID: 102874
FormID: 20262111

AC Inspection - Rev. 2

Location: LR MOTORSHOP
Serial Number: 02-C191G7611664-21 1
Description: 5HP SIEMENS MOTOR FOR EVAL

Hi-Speed Job Number:	102874
Manufacturer:	Siemens
Product Number:	1LE22212AC214AA3-Z
Serial Number:	02-C191G7611664-21 1
HP/kW:	5 (HP)
RPM:	1165 (RPM)
Frame:	215TZ
Voltage:	230 / 460
Current:	13.5 / 6.7 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TEFC
# of Leads:	9
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	05/01/2024
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	No
Shaft Machined Fit Repairs Required:	Yes
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 1 - High ● 9 - Good

Overall Condition

1. Report Date	05/08/2024
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2. Nameplate Picture



3. Photos of all six sides of the machine.



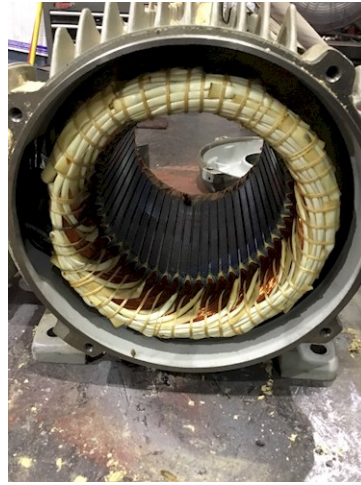


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1.2



4. Describe the Overall Condition of the Equipment as Received
Serviceable

Initial Mechanical/Electrical

5. Does Shaft Turn Freely?	(Y) Yes
6. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
7. Does Shaft Have Visible Damage?	(No) No
8. Assembled Shaft Runout	Inches
9. Assembled Shaft End Play	0 inches
10. Air Gap Variation <10%	
11. Lead Condition	(P) Pass
12. Lead Length	7.5 Inches
13. Does it have Lugs?, If so what is the Stud Size?	(No) No
14. Lead Numbers	1-9
15. Frame Condition	pass

16. Fan Condition

(P) Pass



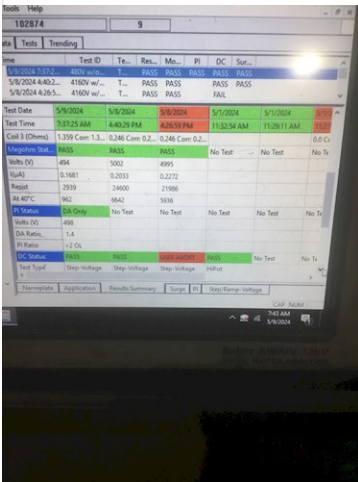
17. Broken or Missing Components

none

Initial Electrical Inspection

18. Insulation Resistance/Megger

2939 Megohms



19. Winding Resistance

1-2

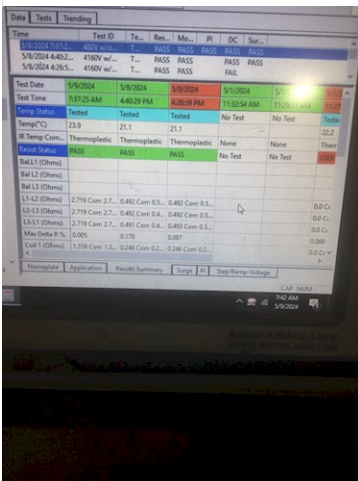
1-3

2-3

2.719

2.719

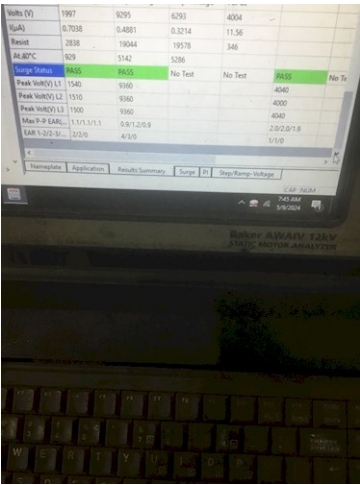
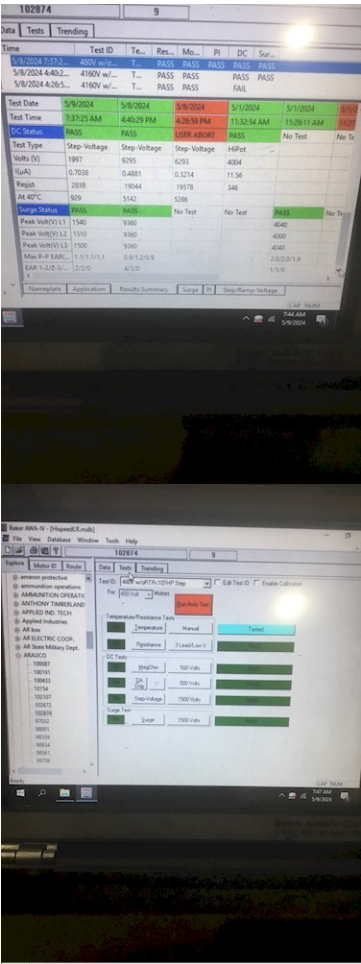
2.719



20. Perform Surge Test

(P) Pass

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21. Number of Stator Slots	48
22. Stator Condition	pass
23. Stator Thermistors/Ohms	
24. Stator Overloads/Ohms	
Mechanical Inspection	

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25. Drive End Bearing Brand



26. Drive End Bearing Number-	6208
27. Drive End Bearing Qty.	1
28. Drive End Bearing Type	(Ball) Ball Bearing
29. Drive End Lubrication Type	(Grease) Grease Lubricated
30. Drive End Bearing Insulation or Grounding Device?	none
31. Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
32. Drive End Bearing Condition	replace.
33. Opposite Drive End Bearing Brand	ORS



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34. Opposite Drive End Bearing Number-	6208
35. Opposite Drive End Bearing Qty.	1
36. Opposite Drive End Bearing Type	(Ball) Ball Bearing
37. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
38. Opposite Drive End Bearing Insulation or Grounding Device?	none
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
40. Opposite Drive End Bearing Condition	replace
41. Drive End Seal	VA 040



42. Opposite Drive End Seal	none
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Rotor Inspection

43. Rotor Type/Material

(Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast

44. Growler Test (Pass) Pass

45. Number of Rotor Bars 44

46. Rotor Condition passed growler and failed
runout

Bent .013ths

47. List the Parts needed for the Repair Below

D.E shaft bent .013

48. Signature of Technician that Disassembled Motor Terrence Holland

Mechanical Fits- Rotor

49. Shaft Runout 0.013 inches

50. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

51. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

52. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

53. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.5756

1.5754

1.5754

54. Drive End Bearing Shaft Fit Condition (P) Pass

55. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees



120 Degrees

1.5752

1.575

1.5754

56. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

57. Shaft Air Seal Fits			
Drive End Air Seal		Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings			
58. Drive End - Endbell Bearing Fit			
0 Degrees		60 Degrees	120 Degrees
<div><div></div>Bad, due to excessive wear/ pitting</div>			
			
59. Drive End - Endbell Bearing Fit Condition			(F) Fail
			
60. Opposite Drive End - Endbell Bearing Fit			
0 Degrees		60 Degrees	120 Degrees
3.1501		3.1502	3.1501
61. Opposite Drive End - Endbell Bearing Fit Condition			(P) Pass
62. Bearing Cap Condition			
Drive End Bearing Cap		Opposite Drive End Bearing Cap	
na		na	
63. End Bell Air Seal Fits			
Drive End Air Seal		Opposite Drive End Air Seal	
64. List Machine Work Needed Below			
Shaft bent .013 sleeve D.E housing fit.			

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65. Technician

Terrence Holland



Root Cause of Failure

66. Failure locations

DE housing fit & DE shaft bent 0.13 ths

67. Root cause of failure

Shaft bent out of tolerance due to unknown causes.

Dynamic Balance Report

68. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

69. Initial Balance Readings

Drive End

Opposite Drive End



Two plane balance
Item balanced: ROTOR BALANCE
Balancing specification: Nema & Dyn
Item operating speed: 1165.00 RPM
NEMA Spec: 2.00 mil
Balancing RPM: 448.33

Balance Conditions

Start

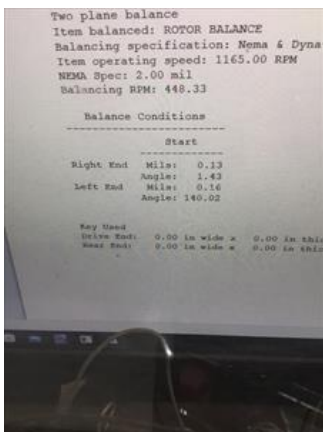
Right End Miles: 0.13
Angle: 1.43
Left End Miles: 0.16
Angle: 140.02

Key Used
Drive End: 0.00 in wide x 0.00 in thk
Rear End: 0.00 in wide x 0.00 in thk

70. Final Balance Readings

Drive End

Opposite Drive End



Two plane balance
Item balanced: ROTOR BALANCE
Balancing specification: Nema & Dyn
Item operating speed: 1165.00 RPM
NEMA Spec: 2.00 mil
Balancing RPM: 448.33

Balance Conditions

Start

Right End Miles: 0.13
Angle: 1.43
Left End Miles: 0.16
Angle: 140.02

Key Used
Drive End: 0.00 in wide x 0.00 in thk
Rear End: 0.00 in wide x 0.00 in thk

71. Technician

Cw


Mechanical Fits- Rotor - Post Repair

72. Shaft Runout Post Repair

0.003 inches



73. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

74. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

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

0 Degrees

60 Degrees

120 Degrees

76. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

77. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

78. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

79. Shaft Repair Sign-off

RW


Mechanical Fits- Bearing Housings - Post Repair

80. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
3.1499	3.1499	3.1499

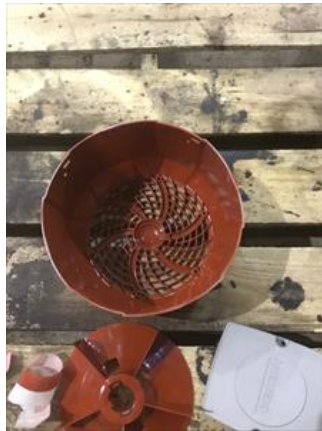


81. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
82. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
83. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
84. End Bell Repair Sign-off		RW
		

Assembly

85. QC Check All Parts for Cleanliness Prior to Assembly
86. Photograph All Major Components prior to assembly





87. Final Insulation Resistance Test			Megohms
Pass			
88. Assembled Shaft Endplay			inches
89. Assembled Shaft Runout			inches
90. Test Run Voltage			
Volts	Volts	Volts	

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91. Test Run Amperage

Amps

Amps

Amps

Witnessed by T HOLLAND



92. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

93. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

94. Ambient Temperature - Fahrenheit

95. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

96. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

97. Document Final Condition with Pictures after paint



98. Final Pics and QC Review

Cw



Co sign: TRH



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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.
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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

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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.
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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.