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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 103325**

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: *4X321085A2-GU*

**1.0**

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*Printed on 8/27/2024*

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Hi-Speed Industrial Service  
7030 Ryburn Dr  
Millington, Tn 38053  
901-873-5300

## AC Inspection as Found

Arauco-Malvern MDF (10298)

1275 Willamette Rd  
Malvern, AR 72104

FolderID: 103325  
FormID: 21228262

### AC Inspection - Rev. 2

Location: LR MOTORSHOP  
Serial Number: 4X321085A2-GU  
Description: 100HP Reliance 1200RPM 444TS

Hi-Speed Job Number:	99706
Manufacturer:	Reliance
Serial Number:	4X321085A2-GU
HP/kW:	100 (HP)
RPM:	1180 (RPM)
Frame:	444TS
Voltage:	230 / 460
Current:	240/120
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	ODP
# of Leads:	3
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	04/22/2022
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	No
Shaft Machined Fit Repairs Required:	Yes
Bearing Housing Machined Fit Repairs Required:	Yes
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 3 - High ● 7 - Good

### Overall Condition

1. Report Date 08/07/2024

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## 2. Nameplate Picture



### 3. Describe the Overall Condition of the Equipment as Received

**Serviceable**

4. Photos of all six sides of the machine.



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5. Report Date [COPY]		
Initial Mechanical/Electrical		
<input checked="" type="radio"/> 6.	Does Shaft Turn Freely?	(Y) Yes
<input type="radio"/> 7.	Does Shaft Have Visible Damage?	(No) No
<input checked="" type="radio"/> 8.	Assembled Shaft Runout	0.0005 Inches
<input type="radio"/> 9.	Assembled Shaft End Play	inches
<input type="radio"/> Na		
<input type="radio"/> 10.	Air Gap Variation <10%	
<input type="radio"/> Na		

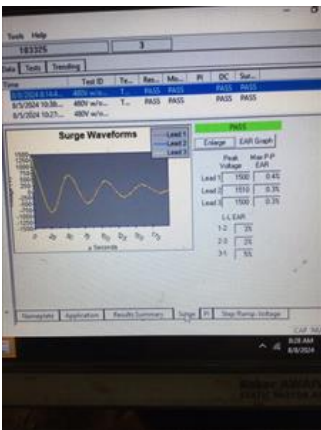
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11. Lead Condition

(P) Pass



12. Lead Length	14 Inches
13. Frame Condition	pass
14. Fan Condition	(N) NA
15. Broken or Missing Components	none
16. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
17. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
18. Lead Numbers	0
<b>Initial Electrical Inspection</b>	
19. Insulation Resistance/Megger	18985 Megohms
20. Winding Resistance	
1-2	1-3
0.130	0.129
2-3	0.129
21. Perform Surge Test	(P) Pass



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22. Stator Condition

wash and bake



23. Number of Stator Slots

72

24. Stator Thermistors/Ohms

Na

25. Stator Overloads/Ohms

Na

### Mechanical Inspection

26. Drive End Bearing Number-

6213 1Z C3



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?

Na

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

none

32. Drive End Bearing Condition

Frosted



33. Opposite Drive End Bearing Number-

6213 1Z C3



34. Opposite Drive End Bearing Qty.

1

35. Opposite Drive End Bearing Type

(Ball) Ball Bearing

36. Opposite Drive End Lubrication Type

(Grease) Grease Lubricated


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37. Opposite Drive End Bearing Insulation or Grounding Device?	<b>none</b>
38. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>None</b>
39. Opposite Drive End Bearing Condition	<b>normal wear</b>




40. Drive End Seal	<b>Na</b>
41. Opposite Drive End Seal	<b>Na</b>
42. Drive End Bearing Brand	<b>Fag</b>
43. Opposite Drive End Bearing Brand	<b>Fag</b>
<b>Rotor Inspection</b>	
44. Rotor Type/Material	<b>(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast</b>
45. Growler Test	<b>(Pass) Pass</b>
46. Number of Rotor Bars	<b>84</b>
47. Rotor Condition	<b>wash</b>
48. List the Parts needed for the Repair Below	<b>2 6213 C3</b>
49. Signature of Technician that Disassembled Motor	<b>RW</b>
	

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## Mechanical Fits- Rotor

50. Shaft Runout	0.0005 inches	
51. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
 A		
52. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
 Na		
53. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
 Na		
54. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.5287	2.5287	2.5287
 55. Drive End Bearing Shaft Fit Condition	(F) Fail	



56. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.5589	2.5589	2.5589
 57. Opposite Drive End Bearing Shaft Fit Condition	(F) Fail	



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58.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
	<div><div></div>Na</div>		
Mechanical Fits- Bearing Housings			
59.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	4.7267	4.7259	4.7262
<div><div></div>60.</div>	Drive End - Endbell Bearing Fit Condition		(F) Fail
	<div><div></div>Resleeve</div>		



61. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
4.7266	4.7249	4.7249
62. Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass	



63. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
Na		
64. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
pass	pass	

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65. List Machine Work Needed Below  
*Both shaft bearing fits are bad. De end bell bearing fit bad*

66. Technician RW



Co sign: CRW

### Root Cause of Failure

67. Failure locations  
*Bearing fits on shaft and drive end end bell*

68. Root cause of failure  
*Heavy usage*

### Dynamic Balance Report

69. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade
--------------	---------------

70. Initial Balance Readings

Drive End	Opposite Drive End
-----------	--------------------

```
Two plane balance
Item balanced: ROTOR BALANCE
Balancing specification: Nema 4
Item operating speed: 1180.00 RPM
NEMA Spec: 2.00 mil
Balancing RPM: 400.48

-----
Balance Condition
-----
Start
-----
Right End  Mils: 0.33  Mils:
           Angle: 271.42 Angle:
Left End   Mils: 1.27  Mils:
           Angle: 244.35 Angle:

Beginning unbalance: 28.056 g
                   111.195 g
Residual unbalance:  4.17 g
                   5.64 g
This item is balanced to: 27.091 g
                   36.683 g

Key Used
Drive End:  9.00 in wide x  0.00 in
Vest End:   9.00 in wide x  0.00 in
```

## 71. Final Balance Readings

Drive End

Opposite Drive End



## 72. Technician

Cw

## Mechanical Fits- Rotor - Post Repair

## 73. Shaft Runout Post Repair

0.001 inches

## 74. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0.002

0.002

0.003

## 75. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

## 76. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

## 77. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

2.5597

2.5597

2.5597



## 78. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

2.5596

2.5595

2.5596



## 79. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

## 80. Shaft Repair Sign-off

Gary

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

## 81. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

4.725

4.7252

4.7251



## 82. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees


120 Degrees

## 83. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap



84. End Bell Air Seal Fits Post Repair	
Drive End Air Seal	Opposite Drive End Air Seal
85. End Bell Repair Sign-off	Gary
	
<b>Assembly</b>	
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

Witnessed by RRW



91. Test Run Amperage

Amps

Amps

Amps



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. QC Check All Parts for Cleanliness Prior to Assembly

98. Document Final Condition with Pictures after paint

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99. Final Pics and QC Review

Cw

A large, stylized handwritten signature in black ink, appearing to read "RRW".

Co sign: RRW



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