



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

LR Motor Shop Repairs

Job Number 102178

Prepared for ARKANSAS INDUSTRIAL MACHINERY

3804 N. NONA ST
NORTH LITTLE ROCK AR 72118

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AC Inspection as Found - *Shop*

AC Inspection - Rev. 2: 3G1P163602217

1.0

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Millington, Tn 38053
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AC Inspection as Found
ARKANSAS INDUSTRIAL MACHINERY
3804 N. NONA ST
NORTH LITTLE ROCK, AR 72118

FolderID: 102178
FormID: 18658817

AC Inspection - Rev. 2

Location: Shop
Serial Number: 3G1P163602217
Description: 90KW ABB 3600RPM 250S

Hi-Speed Job Number:	102178
Manufacturer:	ABB
Product Number:	M3AA 250 SMC 2
Spec/ID #:	3GAA251914-VCG
Serial Number:	3G1P163602217
HP/kW:	90 (kW)
RPM:	3579 (RPM)
Frame:	250S
Voltage:	460
Current:	133
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.06
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	Gear
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found:  **9 - Good**

Overall Condition

1. Report Date
2. Nameplate Picture

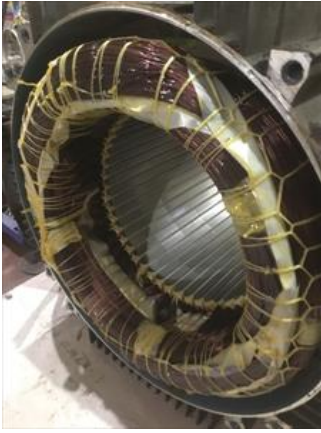


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3. Photos of all six sides of the machine.







4.	Describe the Overall Condition of the Equipment as Received	
	<i>Dirty</i>	
5.	Distance from the end of the shaft to the Coupling/Sheave	inches
	<i>Na</i>	
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	(Yes) Yes
7.	Does Shaft Have Visible Damage?	(No) No
8.	Assembled Shaft Runout	Inches
	<i>Na</i>	
9.	Assembled Shaft End Play	inches
	<i>Na</i>	
10.	Air Gap Variation <10%	
	<i>Na</i>	
11.	Lead Condition	(P) Pass
12.	Lead Length	12 Inches
13.	Lead Numbers	1-6
14.	Frame Condition	dirty
15.	Fan Condition	(P) Pass



16.	Broken or Missing Components	
Initial Electrical Inspection		
17.	Insulation Resistance/Megger	52517 Megohms

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18. Winding Resistance		
1-2	1-3	2-3
.0246	.0243	.0240
19. Perform Surge Test	(P) Pass	



20. Number of Stator Slots	48
21. Stator Condition	wash and bake
22. Stator Thermistors/Ohms	na
23. Stator Overloads/Ohms	na
Mechanical Inspection	
24. Drive End Bearing Brand	SKF
25. Drive End Bearing Number-	NU213EC
26. Drive End Bearing Qty.	1
27. Drive End Bearing Type	(Roller) Roller Bearing



28. Drive End Lubrication Type	(Oil) Oil Lubricated
29. Drive End Bearing Insulation or Grounding Device?	na
30. Drive End Wavy Washer/Snap-Ring Other Retention Device?	Snap ring
31. Drive End Bearing Condition	Na
32. Opposite Drive End Bearing Brand	SKF
33. Opposite Drive End Bearing Number-	6215
34. Opposite Drive End Bearing Qty.	1

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35. Opposite Drive End Bearing Type

(Ball) Ball Bearing



36. Opposite Drive End Lubrication Type

(Grease) Grease Lubricated

37. Opposite Drive End Bearing Insulation or Grounding Device?

Na

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

bearing cap

39. Opposite Drive End Bearing Condition

pass

40. Drive End Seal

16228798-00 Lot #404646



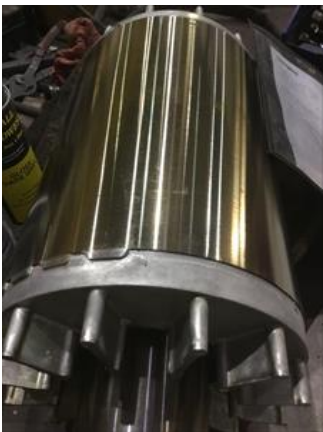
41. Opposite Drive End Seal

Na

Rotor Inspection

42. Rotor Type/Material

(Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast







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43. Growler Test	(Pass) Pass
44. Number of Rotor Bars	40



45. Rotor Condition	pass
46. List the Parts needed for the Repair Below <i>Lip seal NU213EC roller Bearing and a 6215ZZ BEARING</i>	
47. Signature of Technician that Disassembled Motor	RW

Mechanical Fits- Rotor

48.	Shaft Runout	0.002 inches	
49.	Rotor Runout		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
	Na		
50.	Coupling Fit Closest to Bearing Housing		
	0 Degrees	90 Degrees	120 Degrees
	Na		
51.	Coupling Fit Closest to the end of the Shaft		
	0 Degrees	60 Degrees	120 Degrees
	Na		
52.	Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	2.5599	2.5599	2.5599
	53.	Drive End Bearing Shaft Fit Condition	(P) Pass

54. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.9531	2.9531	2.9531



●	55.	Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
	56.	Shaft Air Seal Fits			
		Drive End Air Seal	Opposite Drive End Air Seal		
		pass	pass		
	Mechanical Fits- Bearing Housings				
	57.	Drive End - Endbell Bearing Fit			
		0 Degrees	60 Degrees	120 Degrees	
		4.725	4.725	4.725	
●	58.	Drive End - Endbell Bearing Fit Condition			(P) Pass



59. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.1189	5.1189	5.1189



61. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

na

pass



62. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

A

63. List Machine Work Needed Below

Na

64. Technician

RW

[Handwritten signature]

Root Cause of Failure

65. Failure locations

Loud bearings

66. Root cause of failure

Dirty

Dynamic Balance Report

67. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

0

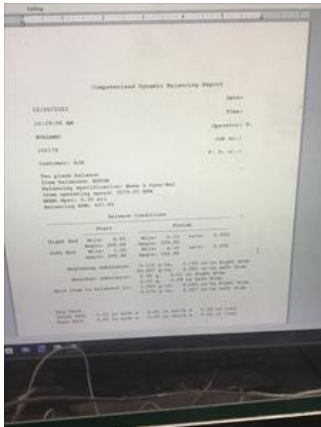
68. Initial Balance Readings

Drive End

Opposite Drive End

.82

.98



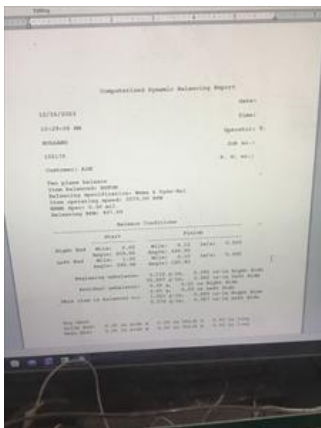
69. Final Balance Readings

Drive End

Opposite Drive End

.1

.08



70. Technician

David Maclin


 Rebalanced
Rewind

71. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

0

72. Core Hot Spot Test

Pre-Burnout

Post-Burnout

0

73. Post Rewind Electrical Test- Insulation Resistance

0 Megohms

74. Post Rewind Polarization Index

0 Polarization Index

75. Post Rewind Winding Resistance

1-2

1-3

2-3

0

76. Post Rewind Surge Test

(Pass) Pass

77. Post Rewind Hi-Pot

0 micro-amps

78. Technician

David Maclin


Mechanical Fits- Rotor - Post Repair

79. Shaft Runout Post Repair

0 inches

80. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0

0

0

81. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

0

0

0

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

0 Degrees

60 Degrees

120 Degrees

0

0

0

83. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

0

0

0

84. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

0

0

0

85. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

ok

ok

86. Shaft Repair Sign-off

David Mackin



Mechanical Fits- Bearing Housings - Post Repair

87. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

0

0

0

88. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

5.1189

5.1189

5.1189



89. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

na

ok

90. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

ok

ok

91. End Bell Repair Sign-off

Gary



Assembly

92. QC Check All Parts for Cleanliness Prior to Assembly

David Maclin



93. Photograph All Major Components prior to assembly

(Complete) Complete



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94. Final Insulation Resistance Test	2000 Megohms	
95. Assembled Shaft Endplay	0 inches	
96. Assembled Shaft Runout	0 inches	
97. Test Run Voltage		
Volts	Volts	Volts
461	460	462
Witnessed by Trevor Halo		



98. Test Run Amperage		
Amps	Amps	Amps
41.1	40	39.5
99. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0	0	0
100. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0	0	
101. Ambient Temperature - Fahrenheit	0	
102. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
0	0	0
103. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes

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0

0

0

104. Document Final Condition with Pictures after paint

looks nice

105. Final Pics and QC Review

David Maclin





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1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
2. **PRICE.** All quoted prices shall remain firm and binding for a period of thirty (30) days from the date of quotation or for the period specifically stated in the quotation. The price for any and all goods and/or services ordered or approved by Buyer after thirty (30) days from the date of any quotation are subject to any increase in price that may occur after the expiration of thirty (30) days from the issuance of the quotation and the date the Buyer releases any shipment.
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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

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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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