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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 103596**

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: *PART: 6236-1839-00*

**1.0**

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*Printed on 10/9/2024*

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

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

FolderID: 103596  
FormID: 21825327

**AC Inspection - Rev. 2**

**Location:** Shop  
**Serial Number:** PART: 6236-1839-00  
**Description:** 75KW SIEMENS 3582RPM

<b>Hi-Speed Job Number:</b>	103596
<b>Manufacturer:</b>	Siemens
<b>Product Number:</b>	M: 1LGS-258-2AA91-Z
<b>Serial Number:</b>	PART: 6236-1839-00
<b>HP/kW:</b>	75 (kW)
<b>RPM:</b>	3582 (RPM)
<b>Frame:</b>	250M
<b>Voltage:</b>	460
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b>Service Factor:</b>	1.15
<b>Enclosure:</b>	TEFC
<b># of Leads:</b>	12
<b>J-box Included:</b>	Complete
<b>Coupling/Sheave:</b>	Coupling
<b>Bearing RTDs:</b>	No
<b>Stator RTDs:</b>	No
<b>Repair Stage:</b>	Final
<b>Rewind:</b>	Yes
<b>Shaft Machined Fit Repairs Required:</b>	Yes
<b>Bearing Housing Machined Fit Repairs Required:</b>	Yes
<b>Heaters:</b>	No
<b>Winding Type :</b>	Random Wound
<b>Bearing Type:</b>	Rolling Element

Priorities Found: ● **8 - High** ● **2 - Good**

**Overall Condition**

1. Report Date

**10/09/2024**

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Technical specifications and dimensions for a metal plate, likely a DIN 9135 standard plate. The plate is mounted on a dark metal structure.

**Technical Specifications:**

- Material: **St 37-2**
- Thickness: **10 mm**
- Width: **100 mm**
- Length: **100 mm**
- Weight: **0.85 kg**
- Surface treatment: **galvanneal**
- Marking: **100 100 10**




**Table of Dimensions:**

Position	Distance from edge	Distance between holes	Distance from hole to center	Distance from hole to edge
1	10	10	10	10
2	10	10	10	10
3	10	10	10	10
4	10	10	10	10
5	10	10	10	10
6	10	10	10	10
7	10	10	10	10
8	10	10	10	10
9	10	10	10	10
10	10	10	10	10



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4. Describe the Overall Condition of the Equipment as Received	
<i>Serviceable</i>	
5. Distance from the end of the shaft to the Coupling/Sheave	inches
 3/32	
6. Report Date [COPY]	10/09/2024
Initial Mechanical/Electrical	
 7. Does Shaft Turn Freely?	(N) No
 8. Does the shaft require T.I.R in Lathe to identify additional repairs?	(Yes) Yes
9. Does Shaft Have Visible Damage?	(Yes) Yes



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10.	Assembled Shaft Runout	Inches
🗨	Na	
11.	Assembled Shaft End Play	inches
🗨	Na	
12.	Air Gap Variation <10%	
🗨	Na	
🔴	13. Lead Condition	(F) Fail
	14. Lead Length	6.5 Inches
🔴	15. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
	16. Lead Numbers	1-12
	17. Frame Condition	pass
🟢	18. Fan Condition	(P) Pass



19.	Broken or Missing Components	
🗨	None	
<b>Initial Electrical Inspection</b>		
20.	Insulation Resistance/Megger	0 Megohms
21.	Winding Resistance	
	1-2	1-3 2-3
🗨	Na	
🔴	22. Perform Surge Test	(F) Fail
🗨	Winding shorted in slot	
23.	Number of Stator Slots	36

## 24. Stator Condition

rewind



## 25. Stator Thermistors/Ohms

Na

## 26. Stator Overloads/Ohms

Na

**Mechanical Inspection**

27. Drive End Bearing Brand	ORS
28. Drive End Bearing Number-	6215
29. Drive End Bearing Qty.	1
30. Drive End Bearing Type	(Ball) Ball Bearing
31. Drive End Lubrication Type	(Grease) Grease Lubricated
32. Drive End Bearing Insulation or Grounding Device?	Na
33. Drive End Wavy Washer/Snap-Ring Other Retention Device?	Snap ring



### 34. Drive End Bearing Condition

No lubricant



35. Opposite Drive End Bearing Brand

ORS

36. Opposite Drive End Bearing Number-

6215



37. Opposite Drive End Bearing Qty.

1

38. Opposite Drive End Bearing Type

(Ball) Ball Bearing

39. Opposite Drive End Lubrication Type

(Grease) Grease Lubricated

40. Opposite Drive End Bearing Insulation or Grounding Device?

na

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

wavy washer

42. Opposite Drive End Bearing Condition

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Chemical discoloration

43. Drive End Seal	bad
44. Opposite Drive End Seal	pass
<b>Rotor Inspection</b>	
45. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast




46. Growler Test	(Pass) Pass
47. Number of Rotor Bars	31
48. Rotor Condition	pass




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49. List the Parts needed for the Repair Below			
2-6215 C3 Bearing			
50. Signature of Technician that Disassembled Motor	RW		
			
<b>Mechanical Fits- Rotor</b>			
51. Shaft Runout	inches		
Na			
52. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
Na			
53. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
Na			
54. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
Na			
55. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
Na			
56. Drive End Bearing Shaft Fit Condition	(F) Fail		
Needs new shaft			
57. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.9534	2.9534	2.9534	
58. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass		
59. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
bad	pass		
<b>Mechanical Fits- Bearing Housings</b>			
60. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.1201	5.12	5.1196	
61. Drive End - Endbell Bearing Fit Condition	(F) Fail		
Resleeve			
62. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.126	5.128	5.1192	
63. Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail		
Resleeve			

64. Bearing Cap Condition		
Drive End Bearing Cap		Opposite Drive End Bearing Cap
<b>fail</b>		<b>pass</b>
	<i>De cap needs sleeved</i>	



65. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
<b>bad</b>	<b>pass</b>	
66. List Machine Work Needed Below	<i>Needs new shaft both end bells need Resleeved de bearing cap needs sleeved</i>	
67. Technician		<b>RW</b>
<div>  </div>		
<div> <div></div> <i>Co sign TRH</i> </div>		

#### Root Cause of Failure

68. Failure locations	<i>De bearing failed because no lubricant de shaft bearing fit bad and both end bells</i>	
69. Root cause of failure	<i>No lubricant</i>	

#### Dynamic Balance Report

70. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
71. Initial Balance Readings		
Drive End	Opposite Drive End	
72. Final Balance Readings		
Drive End	Opposite Drive End	
73. Technician		

#### Rewind

74. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	

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75. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	
76. Post Rewind Electrical Test- Insulation Resistance		
77. Post Rewind Polarization Index		
78. Post Rewind Winding Resistance		
1-2	1-3	2-3
79. Post Rewind Surge Test		
80. Post Rewind Hi-Pot		
81. Technician		
<b>Mechanical Fits- Rotor - Post Repair</b>		
82. Shaft Runout Post Repair		
83. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
84. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
85. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
86. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
87. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
88. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
89. Shaft Repair Sign-off		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
90. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
91. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
92. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
93. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
94. End Bell Repair Sign-off		
<b>Assembly</b>		
95. QC Check All Parts for Cleanliness Prior to Assembly		

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96.	Photograph All Major Components prior to assembly		
97.	Final Insulation Resistance Test		
98.	Assembled Shaft Endplay		
99.	Assembled Shaft Runout		
100.	Test Run Voltage		
	Volts	Volts	Volts
101.	Test Run Amperage		
	Amps	Amps	Amps
102.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
103.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
104.	Ambient Temperature - Fahrenheit		
105.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
106.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
107.	Document Final Condition with Pictures after paint		
108.	Final Pics and QC Review		



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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.
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3. **SCOPE OF GOODS AND/OR SERVICES.** The goods and/or services provided by Hi-Speed pursuant to any quotation shall be limited exclusively to those goods and/or services expressly identified therein. Hi-Speed does not assume any responsibility and/or liability for the failure to provide any other goods and/or services not identified in any quotation. Modifications, additions or deletions to or from the scope referenced in any quotation shall only be effective if evidenced in writing and signed by Hi-Speed. The sale of any of all goods and/or services affected by such modification, addition or deletion shall be subject to these same Standard Terms and Conditions whether or not referenced therein.
4. **BILLING AND PAYMENT TERMS.** Hi-Speed shall invoice Buyer for all goods and/or services as same are rendered at the address listed on the quotation. Payments for all goods and/or services shall be due thirty (30) days from the date of the current invoice or as otherwise set forth in the quotation. Late payments are subject to a late fee of 5% of the total invoice amount. Recurring late payments may lead to a deposit requirement on future services or sale of goods. Buyer shall be liable to Hi-Speed for any and all fees and expenses incurred by Hi-Speed to collect any invoices or to enforce these Standard Terms and Conditions, including but not limited to, attorney's fees.
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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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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