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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 103289**

Prepared for ARKANSAS INDUSTRIAL MACHINERY

3804 N. NONA ST  
NORTH LITTLE ROCK AR 72118

# Table of Contents



Hi-Speed Industrial Service  
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**AC Inspection as Found**  
**ARKANSAS INDUSTRIAL MACHINERY**  
3804 N. NONA ST  
NORTH LITTLE ROCK, AR 72118

FolderID: 103289  
FormID: 21155191

**AC Inspection - Rev. 2**

Location: Shop

Serial Number:

Description: 140HP/104KW

Hi-Speed Job Number: 103289

Manufacturer: Siemens

Product Number: 1622-4608-80

HP/kW: 140 (HP)

RPM: 2510 (RPM)

Voltage: Other

Current: 194A

Phase: Three

Hz: 84.3 (Hz)

Enclosure: TEFC

# of Leads: 6

J-box Included: Half

Coupling/Sheave: Gear

Date Received: 07/30/2024

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:  8 - High  5 - Good

**Overall Condition**

1. Report Date

**08/02/2024**

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1.0

## A close-up photograph of a metal nameplate from a Siemens motor. The plate contains technical specifications such as power (750W), voltage (230V), current (3.6A), speed (1400 RPM), and efficiency (89%). It also features the Siemens logo and various certification marks like CE and SPS. The plate is mounted on a dark, possibly painted, metal surface.

## The image consists of two photographs of a large industrial motor. The top photograph shows the motor with its front cover removed, revealing the internal gear and wiring. The motor is mounted on a metal base and is surrounded by various cables and hoses. The bottom photograph shows the motor with its front cover installed, hanging from a chain. The motor is mounted on a metal base and is surrounded by various cables and hoses.



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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>Flush</i>	
6.	Report Date [COPY]	
Initial Mechanical/Electrical		
7.	Does Shaft Turn Freely?	(N) No
8.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No

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9. Does Shaft Have Visible Damage?

(Yes) Yes



10. Assembled Shaft Runout	Inches
11. Assembled Shaft End Play	inches
12. Air Gap Variation <10%	
13. Lead Condition	(P) Pass
14. Lead Length	Inches
15. Does it have Lugs?, If so what is the Stud Size?	
16. Lead Numbers	1-6
17. Frame Condition	pass
18. Fan Condition	(P) Pass
19. Broken or Missing Components	shaft

#### Initial Electrical Inspection

20. Insulation Resistance/Megger	Megohms
----------------------------------	---------

Coil 2 (Ohms)	0.0235	Corr: 0....
Coil 3 (Ohms)	0.0235	Corr: 0....
Megohm Stat...	PASS	No Test
Volts (V)	501	
I(μA)	0.0465	
Resist	10770	
At 40°C	2908	
DI Status	No Test	No Test
Nameplate	Application	Results Summ

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## 21. Winding Resistance

1-2

1-3

2-3

IR Temp Com...	Thermoplastic	None
Resist Status	PASS	No Test
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.0156 Corr: 0....	
L2-L3 (Ohms)	0.0157 Corr: 0....	
L3-L1 (Ohms)	0.0157 Corr: 0....	
Max Delta R %	0.289	
Coil 1 (Ohms)	0.0234 Corr: 0....	
Coil 2 (Ohms)	0.0235 Corr: 0....	
Coil 3 (Ohms)	0.0235 Corr: 0....	
Megohm Stat	PASS	No Test
Nameplate	Application	Results Summary

## 22. Perform Surge Test

(P) Pass

103289	2
Tests	Trending
ID: 480V w/48VTR:101HP Step	Edit Test ID Enable Calibration
For: 480 Volts Motors	
Run Auto Test	
Temperature/Resistance Tests	
Temperature	Manual Tested
Resistance	3 Lead/Low V PASS
DC Tests	
MegOhm	500 Volts PASS
OFF	500 Volts
Step Voltage	1500 Volts PASS
Surge Test	
Surge	1500 Volts PASS

## 23. Number of Stator Slots

## 24. Stator Condition

needs cleaned

## 25. Stator Thermistors/Ohms

## 26. Stator Overloads/Ohms

## Mechanical Inspection

## 27. Drive End Bearing Brand

SKF

## 28. Drive End Bearing Number-

NU215EC

## 29. Drive End Bearing Qty.

1

## 30. Drive End Bearing Type

(Roller) Roller Bearing

## 31. Drive End Lubrication Type

(Oil) Oil Lubricated

## 32. Drive End Bearing Insulation or Grounding Device?

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

snap ring

## 34. Drive End Bearing Condition

replace

## 35. Opposite Drive End Bearing Brand

KOYO

## 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

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40. Opposite Drive End Bearing Insulation or Grounding Device?	
41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>snap ring</b>
42. Opposite Drive End Bearing Condition	
<div> <div></div> <div>Signs of frosting</div> </div> 	
<div> <div></div> <div>43. Drive End Seal</div> </div>	<b>seal kit</b>
44. Opposite Drive End Seal	
<b>Rotor Inspection</b>	
45. Rotor Type/Material	<b>(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast</b>
46. Growler Test	<b>(Pass) Pass</b>
47. Number of Rotor Bars	
48. Rotor Condition	
<div> <div></div> <div>Pass</div> </div>	
49. List the Parts needed for the Repair Below	
NU215EC 6215 New shaft Seal kit	
50. Signature of Technician that Disassembled Motor	<b>Cw</b>
	
<b>Mechanical Fits- Rotor</b>	
51. Shaft Runout	<b>inches</b>
52. Rotor Runout	
Drive End Bearing Fit	Rotor Body
Opposite Drive End Bearing	
53. Coupling Fit Closest to Bearing Housing	
0 Degrees	90 Degrees
120 Degrees	
54. Coupling Fit Closest to the end of the Shaft	
0 Degrees	60 Degrees
120 Degrees	

55.	Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
56.	Drive End Bearing Shaft Fit Condition		(F) Fail
57.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
58.	Opposite Drive End Bearing Shaft Fit Condition		(F) Fail
59.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
<b>Mechanical Fits- Bearing Housings</b>			
60.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	5.1168	5.1174	5.1201
61.	Drive End - Endbell Bearing Fit Condition		(F) Fail
62.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	5.1181	5.1182	5.1182
63.	Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
64.	Bearing Cap Condition		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
<div> <div></div> <div>Pass</div> </div>			
65.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
66.	List Machine Work Needed Below		
	New shaft		
67.	Technician		Cw
			
<div> <div></div> <div>Co sign: RRW</div> </div>			
<b>Root Cause of Failure</b>			
68.	Failure locations		
	Bearings, shaft, key, seal and DE end bell bearing fit		
69.	Root cause of failure		
	Gear wasn't properly installed leaving space between spacer and bearing allowing spacer to freely spine causing metal shavings to go into bearing locking it up and breaking the key and shaft also taking out the seal		
<b>Dynamic Balance Report</b>			

## 70. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



## 71. Initial Balance Readings

Drive End

Opposite Drive End

4.03

1.98

## 72. Final Balance Readings

Drive End

Opposite Drive End

.06

.24

## 73. Technician

RW

## Mechanical Fits- Rotor - Post Repair

## 74. Shaft Runout Post Repair

inches

Na

## 75. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

Na

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

0 Degrees

90 Degrees

120 Degrees

Na

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

0 Degrees

60 Degrees

120 Degrees

Na

## 78. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees


Na

79. Opposite Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
Na			
80. Shaft Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
Na			
81. Shaft Repair Sign-off			
Na			
<b>Mechanical Fits- Bearing Housings - Post Repair</b>			
82. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
5.1184	5.1184	5.1183	



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

### Assembly

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

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88. Photograph All Major Components prior to assembly

(Complete) Complete



89. Final Insulation Resistance Test

Megohms

Pass the Hi pot

90. Assembled Shaft Endplay

inches

Na

91. Assembled Shaft Runout

inches

Na

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92. Test Run Voltage			
Volts	Volts	Volts	
222	221	222	



Co sign DM

93. Test Run Amperage			
Amps	Amps	Amps	
64	62	65	
94. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
Na			
95. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
Na			
96. Ambient Temperature - Fahrenheit			
Na			
97. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
Na			
98. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
Na			
99. Document Final Condition with Pictures after paint			

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100. Final Pics and QC Review

RW

h W



Co sign DM



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