



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

LR Motor Shop Repairs

Job Number 103209

Prepared for CINTAS (10704)

102 CHAMPS BLVD
MAUMELLE AR 72113

Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: 16893

1.0

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Printed on 7/30/2024

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Table of Contents



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Millington, Tn 38053
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AC Inspection as Found

CINTAS (10704)
102 CHAMPS BLVD
MAUMELLE, AR 72113

FolderID: 103209
FormID: 20963719

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: 16893

Description: 13.2KW KUEENLE EVAL

Hi-Speed Job Number: 103209

Manufacturer: Other

Serial Number: 16893

HP/kW: 13.2 (kW)

RPM: 3470 (RPM)

Voltage: 460

Current: 20.5A

Phase: Three

Hz: 60 (Hz)

Enclosure: TEFC

of Leads: 6

J-box Included: Half

Coupling/Sheave: None

Date Received: 07/11/2024

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: ● 6 - High ● 3 - Good

Overall Condition

1. Report Date

07/12/2024

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2. Nameplate Picture



3. Photos of all six sides of the machine.





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






Initial Mechanical/Electrical

- | | |
|--|-----------|
| 5. Does Shaft Turn Freely? | (N) No |
| 6. Does the shaft require T.I.R in Lathe to identify additional repairs? | (Yes) Yes |



- | | |
|------------------------------------|-----------|
| 7. Does Shaft Have Visible Damage? | (Yes) Yes |
| 8. Assembled Shaft Runout | Inches |
| 9. Assembled Shaft End Play | inches |
| 10. Air Gap Variation <10% | |

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	11. Lead Condition	(P) Pass	
	12. Lead Length	8 Inches	
	13. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes	
	14. Lead Numbers	1-6	
	15. Frame Condition	pass	
	16. Fan Condition	(N) NA	
	Fan missing		
	17. Broken or Missing Components	fan cover fan and connection box cover	
	And hardware		
Initial Electrical Inspection			
	18. Insulation Resistance/Megger	6636 Megohms	
	19. Winding Resistance		
	1-2	1-3	2-3
	0.633	0.634	0.631
	20. Perform Surge Test	(P) Pass	



21. Number of Stator Slots	36
22. Stator Condition	wash and bake



23. Stator Thermistors/Ohms	196.8
24. Stator Overloads/Ohms	
Mechanical Inspection	
25. Drive End Bearing Brand	SKF


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26. Drive End Bearing Number-	6309 2RS
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?	wavy washer
32. Drive End Bearing Condition	bad



33. Opposite Drive End Bearing Brand	SKF
34. Opposite Drive End Bearing Number-	6308 2RS




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?	
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	na
40. Opposite Drive End Bearing Condition	
 Contamination	

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41. Drive End Seal	Na
42. Opposite Drive End Seal	Na
Rotor Inspection	
43. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast



44. Growler Test	(Pass) Pass
45. Number of Rotor Bars	28
46. Rotor Condition	wash
47. List the Parts needed for the Repair Below 6309 2RS 6308 2RS	
48. Signature of Technician that Disassembled Motor	RW
	

Mechanical Fits- Rotor		
49. Shaft Runout		inches
 Na		
50. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

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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	
54. Drive End Bearing Shaft Fit Condition			(F) Fail



55. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
1.5751	1.5751	1.5751	
56. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
57. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Pass			

Mechanical Fits- Bearing Housings

58. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
3.9527	3.9527	3.9527	
59. Drive End - Endbell Bearing Fit Condition			(F) Fail
60. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
3.5457	3.5457	3.5457	
61. Opposite Drive End - Endbell Bearing Fit Condition			(F) Fail
62. Bearing Cap Condition			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
NA			
63. End Bell Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Pass			

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64. List Machine Work Needed Below

Both end bell bearing fit bad .Shaft de bearing fit bad



65. Technician

RW

Co witness TRH

Root Cause of Failure

66. Failure locations

Bearings shaft and end bells

67. Root cause of failure

No lubricant

Dynamic Balance Report

68. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

69. Initial Balance Readings

Drive End

Opposite Drive End

Balancing specification: NEMA
Item operating speed: 3600.00
NEMA Spec: 0.30 mil
Balancing RPM: 771.36

Balance Cond:

Start

Right End	Mils: 1.36	Mils
	Angle: 123.13	Angle
Left End	Mils: 4.10	Mils
	Angle: 265.22	Angle

Beginning unbalance: 22.258
Residual unbalance: 122.619
This item is balanced to: 2.668 g
4.135 g

Key Used
Drive End: 0.00 in wide x 0.00 in
Wear End: 0.00 in wide x 0.00 in

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70. Final Balance Readings

Drive End

Opposite Drive End



71. Technician

Cw

Mechanical Fits- Rotor - Post Repair

72. Shaft Runout Post Repair

0.0004 inches

73. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

NA

74. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

NA

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

0 Degrees

60 Degrees

120 Degrees

NA

76. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

1.7722

1.7722

1.7722



77. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

NA

78. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

NA

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

3.9375

3.9375

3.9375

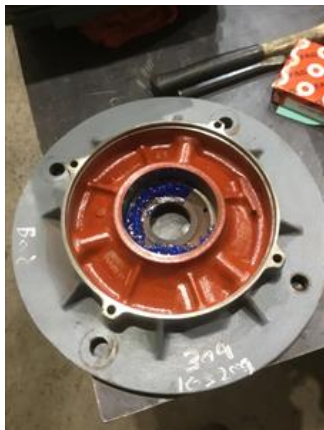


81. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
3.5437	3.5437	3.5437



82. Bearing Cap Condition Post Repair		
Drive End Bearing Cap		Opposite Drive End Bearing Cap
<div><div></div><div>NA</div></div>		
83. End Bell Air Seal Fits Post Repair		
Drive End Air Seal		Opposite Drive End Air Seal
<div><div></div><div>NA</div></div>		
84. End Bell Repair Sign-off		RW
<div><div></div><div><div></div><div></div></div></div>		
Assembly		
85. QC Check All Parts for Cleanliness Prior to Assembly		Cw
<div><div></div><div><div></div><div></div></div></div>		

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

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90. Test Run Voltage

Volts

Volts

Volts

Witnessed by T Holland



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. Document Final Condition with Pictures after paint

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98. Final Pics and QC Review

Cw



Co sign: RRW



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