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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 102911**

Prepared for CoorsTek Inc.

3315 Boone Road  
Benton AR 72015

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

## AC Inspection as Found

CoorsTek Inc.  
3315 Boone Road  
Benton, AR 72015

FolderID: 102911  
FormID: 20338535

### AC Inspection - Rev. 2

Location: LR MOTORSHOP

Serial Number: 2082-023

Description: 5HP STANCOR PUMP

Hi-Speed Job Number: 102911

Manufacturer: Other

Spec/ID #: 80LX63.7

Serial Number: 2082-023

HP/kW: 5 (HP)

RPM: 1750 (RPM)

Voltage: 460

Phase: Three

Hz: 60 (Hz)

Enclosure: Submersible

# of Leads: 3

J-box Included: None

Date Received: 05/09/2024

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: Yes



Shaft Machined Fit Repairs  
Required: No

Bearing Housing Machined  
Fit Repairs Required: No

Heaters: No

Winding Type : Random Wound

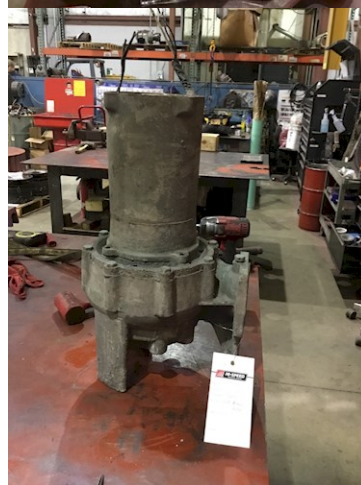
Bearing Type: Rolling Element

Priorities Found:  2 - High  9 - Good

### Overall Condition

- |                      |            |
|----------------------|------------|
| 1. Report Date       | 05/22/2024 |
| 2. Nameplate Picture |            |

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3. Photos of all six sides of the machine.



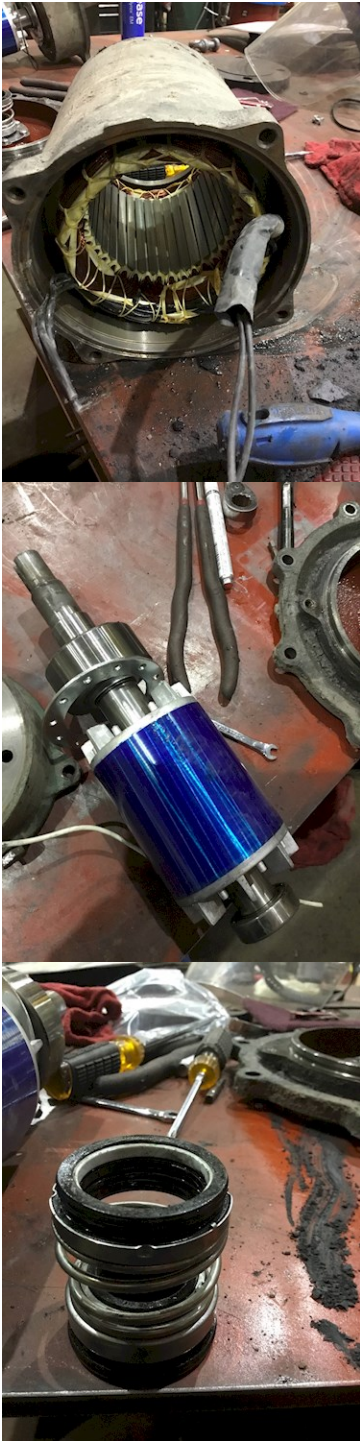




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1.4





4.	Describe the Overall Condition of the Equipment as Received	
	<i>Top cap removed. No cords</i>	
5.	Distance from the end of the shaft to the Coupling/Sheave	0 inches
<b>Initial Mechanical/Electrical</b>		
6.	Does Shaft Turn Freely?	(N) No
7.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
8.	Does Shaft Have Visible Damage?	(No) No
9.	Assembled Shaft Runout	0 Inches
10.	Assembled Shaft End Play	0 inches



11.	Air Gap Variation <10%	none
12.	Lead Condition	(P) Pass
13.	Lead Length	12 Inches
14.	Does it have Lugs?, If so what is the Stud Size?	(No) No
15.	Lead Numbers	none
16.	Frame Condition	good
17.	Fan Condition	(N) NA
18.	Broken or Missing Components	cord
Initial Electrical Inspection		
19.	Insulation Resistance/Megger	2000 Megohms
20.	Winding Resistance	
	1-2	1-3
	900	900
21.	Perform Surge Test	(F) Fail
22.	Number of Stator Slots	36
23.	Stator Condition	rewind
24.	Stator Thermistors/Ohms	na
25.	Stator Overloads/Ohms	0
Mechanical Inspection		
26.	Drive End Bearing Brand	na
27.	Drive End Bearing Number-	5307
28.	Drive End Bearing Qty.	1
29.	Drive End Bearing Type	(Ball) Ball Bearing
30.	Drive End Lubrication Type	(Grease) Grease Lubricated
31.	Drive End Bearing Insulation or Grounding Device?	none
32.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
33.	Drive End Bearing Condition	normal wear
34.	Opposite Drive End Bearing Brand	na
35.	Opposite Drive End Bearing Number-	6205
36.	Opposite Drive End Bearing Qty.	1
37.	Opposite Drive End Bearing Type	(Ball) Ball Bearing
38.	Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
39.	Opposite Drive End Bearing Insulation or Grounding Device?	none
40.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
41.	Opposite Drive End Bearing Condition	normal wear
42.	Drive End Seal	none
43.	Opposite Drive End Seal	none
Rotor Inspection		
44.	Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
45.	Growler Test	(Pass) Pass
46.	Number of Rotor Bars	44
47.	Rotor Condition	good
48.	List the Parts needed for the Repair Below	
	Rewind, 6205, 5307, 35*55mm mechanical seal, 35*47mm mechanical seal.	

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49. Signature of Technician that Disassembled Motor

Terrence Holland


**Mechanical Fits- Rotor**50. Shaft Runout **0 inches**

51. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

**0****0****0**

52. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

**0****0****0**

53. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

**0****0****0**

54. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

**1.3785****1.3785****1.3784**

● 55. Drive End Bearing Shaft Fit Condition

**(P) Pass**

56. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

**0.9846****0.9846****0.9846**

● 57. Opposite Drive End Bearing Shaft Fit Condition

**(P) Pass**

58. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

**ok****ok****Mechanical Fits- Bearing Housings**

59. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

**3.1501****3.15****3.1501**

● 60. Drive End - Endbell Bearing Fit Condition

**(P) Pass**

61. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

**2.0475****2.0475****2.0476**

● 62. Opposite Drive End - Endbell Bearing Fit Condition

**(P) Pass**

63. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

**ok****na**

64. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

65. List Machine Work Needed Below

*None*


**Root Cause of Failure**

67. Failure locations

*Stator shorted*

68. Root cause of failure

*Likely overloaded from impeller ring seized to bowl with material.***Dynamic Balance Report**

69. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

70. Initial Balance Readings

Drive End

Opposite Drive End

71. Final Balance Readings

Drive End

Opposite Drive End

72. Technician

**Rewind**

73. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

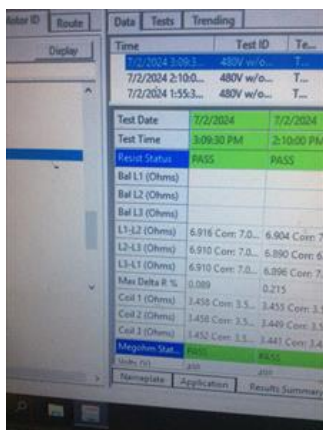
74. Core Hot Spot Test

Pre-Burnout

Post-Burnout

75. Post Rewind Electrical Test- Insulation Resistance

Megohms



Time	Test ID	Test Name
7/2/2024 3:09:30	480V w/o...	T...
7/2/2024 2:10:00...	480V w/o...	T...
7/2/2024 1:55:30...	480V w/o...	T...

Test Date	7/2/2024	7/2/2024
Test Time	3:09:30 PM	2:10:00 PM
Test Status	PASS	PASS
Ref L1 (Ohms)		
Ref L2 (Ohms)		
Ref L3 (Ohms)		
L1-L2 (Ohms)	6.916 Corr: 7.0...	6.904 Corr: 7.0...
L2-L3 (Ohms)	6.910 Corr: 7.0...	6.890 Corr: 6.9...
L1-L3 (Ohms)	6.910 Corr: 7.0...	6.896 Corr: 7.0...
Max Delta R %	0.089	0.215
Coil 1 (Ohms)	3.458 Corr: 3.5...	3.455 Corr: 3.5...
Coil 2 (Ohms)	3.458 Corr: 3.5...	3.449 Corr: 3.5...
Coil 3 (Ohms)	3.452 Corr: 3.5...	3.441 Corr: 3.4...
Megohm Stat	1000	PASS
Units (M)	1000	1000
Nameplate		
Application		
Results Summary		

76. Post Rewind Polarization Index

Polarization Index



77. Post Rewind Winding Resistance

1-2

1-3

2-3

Router ID	Route	Data	Tests	Trending
Display		Time	Test ID	Te...
		7/2/2024 1:06:1	400V w/o...	T...
		7/2/2024 2:10:0...	480V w/o...	T...
		7/2/2024 1:55:3...	480V w/o...	T...
Test Date	7/2/2024	7/2/2024		
Test Time	3:09:30 PM	2:10:00 PM		
Pass/Fail Status	PASS	PASS		
Bal L1 (Ohms)				
Bal L2 (Ohms)				
Bal L3 (Ohms)				
L1-L2 (Ohms)	6.918 Corr: 7.0...	6.904 Corr: 7...		
L2-L3 (Ohms)	6.910 Corr: 7.0...	6.890 Corr: 6...		
L3-L1 (Ohms)	6.910 Corr: 7.0...	6.896 Corr: 7...		
Max Delta R %	0.089	0.215		
Coil 1 (Ohms)	3.438 Corr: 3.5...	3.435 Corr: 3.5...		
Coil 2 (Ohms)	3.438 Corr: 3.5...	3.449 Corr: 3.5...		
Coil 3 (Ohms)	3.432 Corr: 3.5...	3.441 Corr: 3.4...		
Megohm Stat	PASS	PASS		
Units (V)	400	400		
Nameplate	Application	Results Summary		

78. Post Rewind Surge Test

(Pass) Pass

79. Post Rewind Hi-Pot

micro-amps

80. Technician

Ztw



Assembly

81. QC Check All Parts for Cleanliness Prior to Assembly

82. Photograph All Major Components prior to assembly

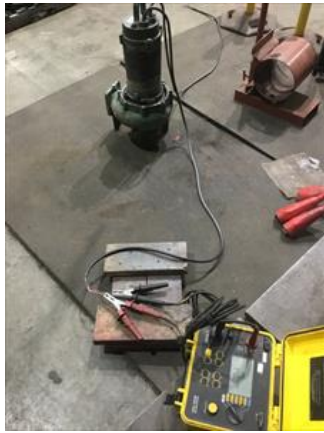
(Complete) Complete



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83. Final Insulation Resistance Test			Megohms
Pass			
84. Assembled Shaft Endplay			inches
85. Assembled Shaft Runout			inches
86. Test Run Voltage			
Volts	Volts	Volts	



87. Test Run Amperage			
Amps	Amps	Amps	

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88. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

89. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

90. Ambient Temperature - Fahrenheit

91. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

92. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

93. Document Final Condition with Pictures after paint



94. Final Pics and QC Review

Cw

Co sign: TRH



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

## AC Random Coil Rewind Report

FolderID: 102911  
FormID: 20851200

**CoorsTek Inc.**  
3315 Boone Road  
Benton, AR 72015  
LR MOTORSHOP  
Priorities Found:

General	
1.	Job Number
2.	Report Date
3.	Customer
Stator Winding	
4.	Core Length
5.	Core ID
6.	Back Iron Depth
7.	Slot Depth
8.	Tooth Width
9.	Number of Vents
10.	Vent Width
11.	Before Burnout Core loss
12.	Flux Before Burnout
13.	Watts before burnout
14.	Watts loss per lb. before burnout
15.	After Burnout Core Loss
16.	Flux After burnout
17.	Watts After Burnout
18.	Watts loss per lb After Burnout
19.	Core Iron Condition
20.	RTD's
21.	RTD's Reading
22.	Motor Heaters
23.	Heater Qty.
24.	Heater Voltage
25.	Heater Wattage
26.	Thermistors
27.	Number of Poles
28.	Slots
29.	Number of Coils
30.	Coil Weight
31.	Lead Markings
32.	Grouping
33.	Multiple Wires
34.	Wire Size
35.	Turns per coil

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36.	Pitch 1 to:
37.	Connection
38.	Lead Length
39.	Lead Size
40.	Number of Leads
41.	Megger Reading After Rewind
42.	Coil Machine Slot
43.	Coil Machine Tip
44.	Coil Machine Pitch
45.	Hi Pot Reading After Rewind
46.	Surge Pattern After Rewind
47.	Service Technician





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