



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

LR Motor Shop Repairs

**Job Number 102302**

Prepared for Delta Plastics (11016)

8801 Frazier Pike  
Little Rock AR 72206

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AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *BN 10324402 003 /0917*

**1.0**

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

## AC Inspection as Found

Delta Plastics (11016)

8801 Frazier Pike  
Little Rock, AR 72206

FolderID: 102302  
FormID: 18969821

### AC Inspection - Rev. 2

Location: MOTOR SHOP LR  
Serial Number: BN 10324402 003 /0917  
Description: 16KW GARDNER DENVER  
BLOWER 3600RPM

Hi-Speed Job Number:	102302
Manufacturer:	Other
Product Number:	G-BH1 2BH1900-6AH37-Z
Serial Number:	BN 10324402 003 /0917
HP/kW:	16 (kW)
RPM:	3535 (RPM)
Voltage:	460
Current:	30
Phase:	Three
Hz:	60 (Hz)
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	Propeller
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 2 - High ● 6 - Good

### Overall Condition

- Report Date
- Nameplate Picture



- Photos of all six sides of the machine.

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4.	Describe the Overall Condition of the Equipment as Received	
5.	Distance from the end of the shaft to the Coupling/Sheave	
<b>Initial Mechanical/Electrical</b>		
● 6.	Does Shaft Turn Freely?	(No) No
7.	Does Shaft Have Visible Damage?	(No) No
8.	Assembled Shaft Runout	Inches
■	Na	
9.	Assembled Shaft End Play	inches
■	Na	
10.	Air Gap Variation <10%	
■	Na	
● 11.	Lead Condition	(P) Pass



12.	Lead Length	10 Inches
13.	Lead Numbers	1-6
14.	Frame Condition	Dirty



16. Broken or Missing Components			conn box cover
Initial Electrical Inspection			
17. Insulation Resistance/Megger			53150 Megohms
18. Winding Resistance			
1-2	1-3	2-3	
0.388	0.343	0.351	
	19. Perform Surge Test (P) Pass		





## 21. Stator Condition

Wash and bake



## 22. Stator Thermistors/Ohms

193.6 ohms

## 23. Stator Overloads/Ohms

Na

**Mechanical Inspection**

24. Drive End Bearing Brand	SKF
25. Drive End Bearing Number-	6308
26. Drive End Bearing Qty.	1
27. Drive End Bearing Type	(Ball) Ball Bearing
28. Drive End Lubrication Type	(Grease) Grease Lubricated
29. Drive End Bearing Insulation or Grounding Device?	NA
30. Drive End Wavy Washer/Snap-Ring Other Retention Device?	Na
31. Drive End Bearing Condition	no grease and cage came apart



32. Opposite Drive End Bearing Brand	ORS
33. Opposite Drive End Bearing Number-	6209
34. Opposite Drive End Bearing Qty.	1
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?	Wavy washer

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39. Opposite Drive End Bearing Condition



40. Drive End Seal

Na

41. Opposite Drive End Seal

yes

45-52-5



Rotor Inspection

42. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast

43. Growler Test

(Pass) Pass

44. Number of Rotor Bars

12


45. Rotor Condition

clean



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46. List the Parts needed for the Repair Below <i>6308 6209 bearing</i>			
47. Signature of Technician that Disassembled Motor			RW
			
<b>Mechanical Fits- Rotor</b>			
48. Shaft Runout			inches
Na			
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	
1.575	1.575	1.575	
53. Drive End Bearing Shaft Fit Condition			(P) Pass



54. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
1.7719	1.7719	1.7719	



## 56. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

**Mechanical Fits- Bearing Housings**

## 57. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

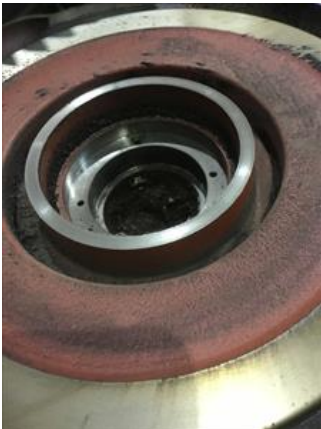
3.544

3.544

3.544

## 58. Drive End - Endbell Bearing Fit Condition

(P) Pass



## 59. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

3.357

3.357

3.357



61. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Na

62. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

63. List Machine Work Needed Below

*Ode end bell bearing fit*

64. Technician

RW

**Root Cause of Failure**

65. Failure locations

66. Root cause of failure

**Dynamic Balance Report**

67. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

68. Initial Balance Readings

Drive End

Opposite Drive End

69. Final Balance Readings

Drive End

Opposite Drive End

70. Technician

**Rewind**

71. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout


72. Core Hot Spot Test			
Pre-Burnout	Post-Burnout		
73. Post Rewind Electrical Test- Insulation Resistance			
74. Post Rewind Polarization Index			
75. Post Rewind Winding Resistance			
1-2	1-3	2-3	
76. Post Rewind Surge Test			
77. Post Rewind Hi-Pot			
78. Technician			
<b>Mechanical Fits- Rotor - Post Repair</b>			
79. Shaft Runout Post Repair			
80. Rotor Runout Post Repair			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
81. Coupling Fit Closest to Bearing Housing Post Repair			
0 Degrees	90 Degrees	120 Degrees	
82. Coupling Fit Closest to the end of the Shaft Post Repair			
0 Degrees	60 Degrees	120 Degrees	
83. Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
84. Opposite Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
85. Shaft Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
86. Shaft Repair Sign-off			
<b>Mechanical Fits- Bearing Housings - Post Repair</b>			
87. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	

88. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
3.347	3.3471	3.3471



89. Bearing Cap Condition Post Repair		
Drive End Bearing Cap		Opposite Drive End Bearing Cap
90. End Bell Air Seal Fits Post Repair		
Drive End Air Seal		Opposite Drive End Air Seal

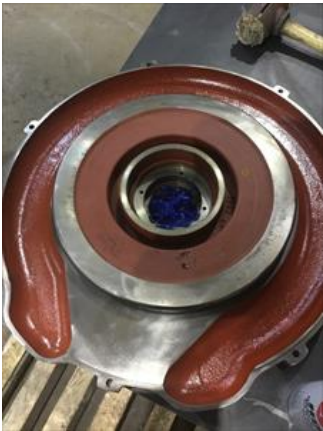
91. End Bell Repair Sign-off	Gary
	

Assembly		
92. QC Check All Parts for Cleanliness Prior to Assembly		Cw
		

93. Photograph All Major Components prior to assembly	(Complete) Complete	
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94. Final Insulation Resistance Test	Megohms	
Na		
95. Assembled Shaft Endplay	inches	
Na		
96. Assembled Shaft Runout	inches	
Na		
97. Test Run Voltage		
Volts	Volts	Volts
In picture		

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98. Test Run Amperage

Amps

Amps

Amps

In picture



99. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

Na

100. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

Na

101. Ambient Temperature - Fahrenheit

Na

102. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

103. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

104. Document Final Condition with Pictures after paint

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105. Final Pics and QC Review

Cw



CO SIGN: RRW



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