



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

LR Motor Shop Repairs

**Job Number 103198**

Prepared for Evonik(10512)

10300 Arch St. Pike  
Little Rock AR 72206

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

## AC Inspection as Found

Evonik(10512)

10300 Arch St. Pike  
Little Rock, AR 72206

FolderID: 103198  
FormID: 20942755

### AC Inspection - Rev. 2

Location: LR MOTOR SHOP

Serial Number: 1080061170

Description: 125HP WEG EVAL

Hi-Speed Job Number: 103198

Manufacturer: WEG

Product Number: 12518ET3E444T-W22

Serial Number: 1080061170

HP/kW: 125 (HP)

RPM: 1780 (RPM)

Frame: 444/5T

Voltage: 230 / 460

Current: 278/139A

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

# of Leads: 12

J-box Included: Half

Coupling/Sheave: None

Date Received: 07/09/2024

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: ● 3 - High ● 7 - Good

### Overall Condition

1. Report Date

07/11/2024

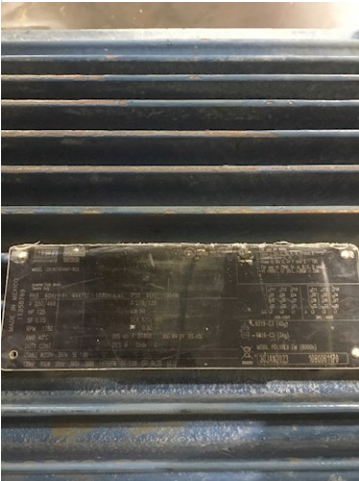
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1.0

## 2. Nameplate Picture



## 3. Photos of all six sides of the machine.





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1.2





*Has a water line almost half way up the windings*





4. Describe the Overall Condition of the Equipment as Received

#### Initial Mechanical/Electrical

5. Does Shaft Turn Freely?

6. Does the shaft require T.I.R in Lathe to identify additional repairs?

7. Does Shaft Have Visible Damage?

8. Assembled Shaft Runout

Inches

9. Assembled Shaft End Play

inches

10. Air Gap Variation <10%

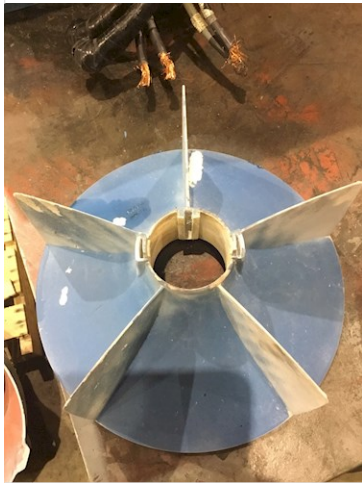
11. Lead Condition

(P) Pass



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12. Lead Length	12 Inches
13. Does it have Lugs?, If so what is the Stud Size?	(No) No
14. Lead Numbers Connected: (1&12), (2&10), (3&11)--line (4&7), (5&8), (6&9)	1-12
15. Frame Condition	pass
16. Fan Condition	(P) Pass



17. Broken or Missing Components	none
<b>Initial Electrical Inspection</b>	
18. Insulation Resistance/Megger	Megohms



19. Winding Resistance			
1-2	1-3	2-3	
20. Perform Surge Test			
21. Number of Stator Slots			48
22. Stator Condition			rewind
23. Stator Thermistors/Ohms			
24. Stator Overloads/Ohms			

### Mechanical Inspection

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25. Drive End Bearing Brand

C&U



26. Drive End Bearing Number-

6319 C3



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?

none

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

none

32. Drive End Bearing Condition

replace

33. Opposite Drive End Bearing Brand

C&U

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1.6



34. Opposite Drive End Bearing Number-

6316 C3



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?

spring loaded bearing cap & snap ring



Replace springs with .100" spacers on each side of the bearing.

40. Opposite Drive End Bearing Condition

worn

41. Drive End Seal

42. Opposite Drive End Seal

lip seal in cap

Rotor Inspection

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## 43. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast

44. Growler Test (Pass) Pass

45. Number of Rotor Bars 41

46. Rotor Condition pass

47. List the Parts needed for the Repair Below

*Rewind stator. Replace bearings.**ODE: 6316**DE: 6319*

48. Signature of Technician that Disassembled Motor Terrence Holland

**Mechanical Fits- Rotor**

49. Shaft Runout 0.002 inches

50. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

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

3.7405

3.7404

3.7405

54. Drive End Bearing Shaft Fit Condition (P) Pass

55. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.1498

3.15

3.15

56. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

57. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

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## Mechanical Fits- Bearing Housings

58. Drive End - Endbell Bearing Fit

0 Degrees

7.8748

60 Degrees

7.8746

120 Degrees

7.8748

59. Drive End - Endbell Bearing Fit Condition

(P) Pass

60. Opposite Drive End - Endbell Bearing Fit

0 Degrees

6.6931

60 Degrees

6.6933

120 Degrees

6.6933

61. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass

62. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap  
pass



63. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

64. List Machine Work Needed Below

None

65. Technician

Terrence Holland

## Root Cause of Failure

66. Failure locations

Windings

67. Root cause of failure

Significant water intrusion inside stator on both ends.

## Dynamic Balance Report

## 68. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



## 69. Initial Balance Readings

Drive End

Opposite Drive End

.46

.36

## 70. Final Balance Readings

Drive End

Opposite Drive End

.46

.36

## 71. Technician

RW

## Rewind

## 72. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

## 73. Core Hot Spot Test

Pre-Burnout

Post-Burnout

## 74. Post Rewind Electrical Test- Insulation Resistance

Megohms

## 75. Post Rewind Polarization Index

Polarization Index

## 76. Post Rewind Winding Resistance

1-2

1-3

2-3

## 77. Post Rewind Surge Test

(Pass) Pass

## 78. Post Rewind Hi-Pot

micro-amps

## 79. Technician

## Assembly

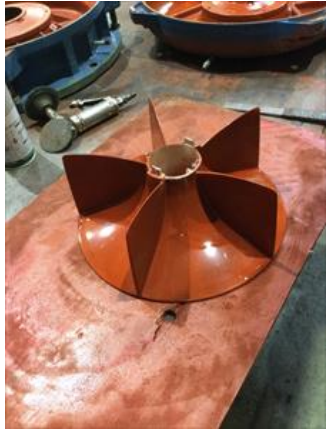
80. QC Check All Parts for Cleanliness Prior to Assembly

RW

*RW*

81. Photograph All Major Components prior to assembly

(Complete) Complete



82. Final Insulation Resistance Test

Megohms

Pass the Hi pot

83. Assembled Shaft Endplay

inches

84. Assembled Shaft Runout

inches

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85. Test Run Voltage			
Volts	Volts	Volts	
456	457	457	



Co sign TRH

86. Test Run Amperage			
Amps	Amps	Amps	
42.1	42.6	42.2	



87. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
88. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
89. Ambient Temperature - Fahrenheit			
90. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
91. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
92. Document Final Condition with Pictures after paint			

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93. Final Pics and QC Review

RW

RL

Co sign TRH



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

## AC Random Coil Rewind Report

FolderID: 103198  
FormID: 21923374

### Evonik(10512)

10300 Arch St. Pike  
Little Rock, AR 72206

LR MOTOR SHOP  
Winding

Priorities Found: ● 3 - High ● 4 - Good

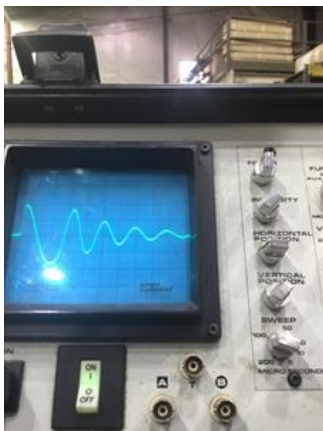
General		
1. Job Number		103198
2. Report Date		10/11/2024
3. Customer		Evonik
Stator Winding		
4. Core Length		9.5 "
5. Core ID		12.5 "
6. Back Iron Depth		2.8125 "
7. Slot Depth		1.3125 "
8. Tooth Width		0.4375 "
9. Number of Vents		0
10. Vent Width		0 "
<span style="color: green;">●</span> 11. Before Burnout Core loss		(P) Pass
12. Flux Before Burnout		
13. Watts before burnout		
14. Watts loss per lb. before burnout		2.193 W/lbs.
<span style="color: green;">●</span> 15. After Burnout Core Loss		(P) Pass
16. Flux After burnout		
17. Watts After Burnout		
18. Watts loss per lb After Burnout		2 W/lbs.
<span style="color: green;">●</span> 19. Core Iron Condition		(P) Pass
<span style="color: red;">●</span> 20. RTD's		(N) No
21. RTD's Reading		
<span style="color: red;">●</span> 22. Motor Heaters		(N) No
23. Heater Qty.		0
24. Heater Voltage		
25. Heater Wattage		
<span style="color: red;">●</span> 26. Thermistors		(N) No
27. Number of Poles		4
28. Slots		48
29. Number of Coils		36
30. Coil Weight		120 Lbs.
31. Lead Markings		
1-12		
32. Grouping		
12g 4c		

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33. Multiple Wires	(Y) Yes
34. Wire Size 5# 16 3# 17	
35. Turns per coil 1-8 1-10 1-12 9. 8. 17	
36. Pitch 1 to: 1-8,10,12	
37. Connection 2 Wye delta @460 4 Wye Delta @230	
38. Lead Length	12 "
39. Lead Size	6
40. Number of Leads	12
41. Megger Reading After Rewind	
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	Ua



46. Surge Pattern After Rewind



47. Service Technician

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SK

- 120 lbs copper wire
- 60lbs #17
- 40lbs #16
- 20lbs #15
- 30' #6 epdm lead wire







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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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