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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 102967**

Prepared for Flywheel Energy (12096)

1408 Hwy 124 E  
Damascus, AR 72039

# Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *SH0912005*

**1.0**

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*Printed on 7/23/2024*

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

## AC Inspection as Found

Flywheel Energy (12096)

1408 Hwy 124 E

Damascus,, AR 72039

FolderID: 102967  
FormID: 20445189

### AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: SH0912005

Description: 40HP POWER TECH-QUOTE  
REPAIR OR REPLACE

Hi-Speed Job Number: 102967

Manufacturer: Other

Serial Number: SH0912005

HP/kW: 40 (HP)

RPM: 3555 (RPM)

Frame: 324TS

Voltage: 230 / 460

Current: 54.8 / 109.6 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

# of Leads: 3

J-box Included: Complete

Coupling/Sheave: None

Date Received: 05/21/2024

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: No

Shaft Machined Fit Repairs  
Required: No

Bearing Housing Machined  
Fit Repairs Required: Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 2 - High ● 9 - Good

### Overall Condition

1. Report Date

05/31/2024

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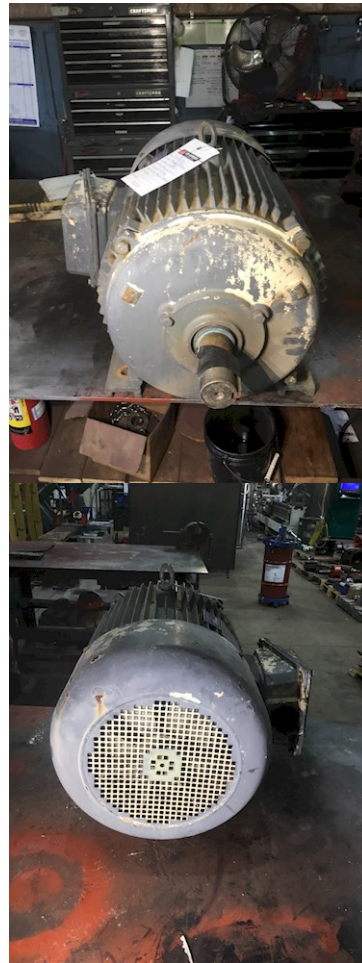
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1.0

## 2. Nameplate Picture



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





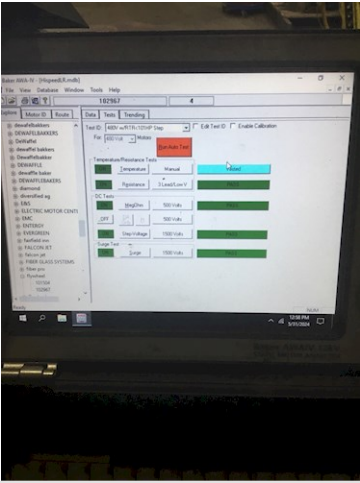
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1.2





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

### Initial Mechanical/Electrical

5. Does Shaft Turn Freely?	(Y) Yes
6. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
7. Does Shaft Have Visible Damage?	(No) No
8. Assembled Shaft Runout	0.001 Inches
9. Assembled Shaft End Play	0 inches
10. Air Gap Variation <10%	
11. Lead Condition	(P) Pass
12. Lead Length	14 Inches
13. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
14. Lead Numbers	1-3
15. Frame Condition	pass
16. Fan Condition	(P) Pass



17. Broken or Missing Components none

### Initial Electrical Inspection

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## 18. Insulation Resistance/Megger

Megohms

Coil 2 (Ohms)	0.252 Corr: 0.2...	6.285 Corr: 6.3...	1.216 Corr: 1.2...	
Coil 3 (Ohms)	0.252 Corr: 0.2...	6.288 Corr: 6.3...	1.211 Corr: 1.2...	
Megohm Stat.	PASS	PASS	PASS	No Test
Volts (V)	501	504	494	
µA(A)	0.0312	0.0272	1.286	
Resist	16047	18533	384	
At 40°C	5459	5404	103	
PI Status	No Test	No Test	No Test	No Test
Volts (V)				
DA Ratio				
PI Ratio				
DC Status	PASS	PASS	MIN MEGOHM	No Test
Test Time	Green-10kV/100V	Green-10kV/100V	Green-10kV/100V	
Nameplate	Application	Results Summary	Surge	PI Step/Ramp-Voltage

## 19. Winding Resistance

1-2

1-3

2-3

Test Date	5/31/2024	5/6/2024	5/6/2024	5/6/2024
Test Time	12:49:37 PM	11:05:15 AM	8:16:48 AM	8:09:19 AM
Resist Status	PASS	PASS	PASS	FAIL
Bal L1 (Ohms)				No Test
Bal L2 (Ohms)				
Bal L3 (Ohms)				
L1-L2 (Ohms)	0.168 Corr: 0.1...	4.194 Corr: 4.2...	0.806 Corr: 0.8...	
L2-L3 (Ohms)	0.168 Corr: 0.1...	4.191 Corr: 4.2...	0.810 Corr: 0.8...	
L3-L1 (Ohms)	0.168 Corr: 0.1...	4.186 Corr: 4.2...	0.808 Corr: 0.8...	
Max Delta R %	0.005	0.213	0.407	
Coil 1 (Ohms)	0.252 Corr: 0.2...	6.293 Corr: 6.3...	1.206 Corr: 1.2...	
Coil 2 (Ohms)	0.252 Corr: 0.2...	6.285 Corr: 6.3...	1.216 Corr: 1.2...	
Coil 3 (Ohms)	0.252 Corr: 0.2...	6.268 Corr: 6.3...	1.211 Corr: 1.2...	
Megohm Stat.	PASS	PASS	PASS	No Test
Volts (V)	501	504	494	
Nameplate	Application	Results Summary	Surge	PI Step/Ramp-Voltage

## 20. Perform Surge Test

(P) Pass

Resist	15084	19362	357	
At 40°C	5131	5646	96	
Surge Status	PASS	PASS	PASS	No Test
Peak Volt(V) L1	1520	2080	1500	
Peak Volt(V) L2	1510	2120	1510	
Peak Volt(V) L3	1510	2100	1510	
Max P-P EAR[...]	0.3/0.3/0.4	1.0/1.0/1.0	0.3/0.2/0.3	
EAR 1-2/2-3/...	No Test	No Test	1/0/1	
Nameplate	Application	Results Summary	Surge	PI Step/Ramp-Voltage

## 21. Number of Stator Slots

36

## 22. Stator Condition





pass

## 23. Stator Thermistors/Ohms

## 24. Stator Overloads/Ohms



## Mechanical Inspection

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25. Drive End Bearing Brand	koyo
26. Drive End Bearing Number-	6312 Z 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	worn
33. Opposite Drive End Bearing Brand	koyo
34. Opposite Drive End Bearing Number-	6312 Z 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?	none
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
40. Opposite Drive End Bearing Condition	worn
41. Drive End Seal	
42. Opposite Drive End Seal	
<b>Rotor Inspection</b>	
43. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
44. Growler Test	(Pass) Pass

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45. Number of Rotor Bars	28	
46. Rotor Condition	pass	
47. List the Parts needed for the Repair Below <i>Bearings / recondition.</i>		
48. Signature of Technician that Disassembled Motor	Terrence Holland	
		
<b>Mechanical Fits- Rotor</b>		
49. Shaft Runout	0.001 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
2.3628	2.3628	2.3628
54. Drive End Bearing Shaft Fit Condition	(P) Pass	
55. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.3629	2.3628	2.363
56. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	
57. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
<b>Mechanical Fits- Bearing Housings</b>		
58. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.1183	5.1187	5.1187
59. Drive End - Endbell Bearing Fit Condition	(F) Fail	
 Pitted		
60. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.1183	5.1184	5.1184
61. Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass	
62. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
pass	pass	
63. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	

64. List Machine Work Needed Below

*Sleeve DE housing fit*

65. Technician

Terrence Holland



Co sign: CRW

### Root Cause of Failure

66. Failure locations

*D.e housing fit, bearing grease dirty*

67. Root cause of failure

*Bearing grease in housings contaminated, DE housing fit pitted and out of tolerance.*

### Dynamic Balance Report

68. Rotor Weight and Balance Grade

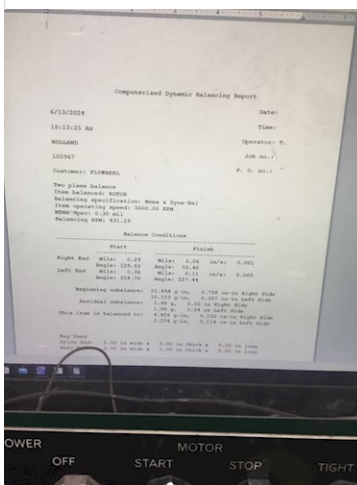
Rotor Weight

Balance Grade

69. Initial Balance Readings

Drive End

Opposite Drive End



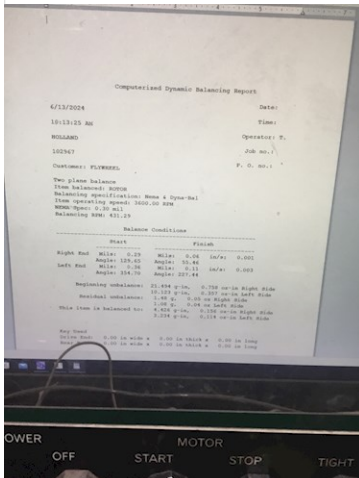
## 70. Final Balance Readings

Drive End

Opposite Drive End

.29

.06



## 71. Technician

Terrence Holland

## Mechanical Fits- Bearing Housings - Post Repair

## 72. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

5.1185

5.1184

5.1183



## 73. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

## 74. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

## 75. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

A handwritten signature in black ink, consisting of a series of connected loops and a final horizontal stroke.

Assembly



77. QC Check All Parts for Cleanliness Prior to Assembly

Cw

*Cw*



78. Photograph All Major Components prior to assembly

(Complete) Complete

79. Final Insulation Resistance Test

Megohms

Pass

80. Assembled Shaft Endplay

inches

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81. Assembled Shaft Runout	inches	
82. Test Run Voltage		
Volts	Volts	Volts



83. Test Run Amperage		
Amps	Amps	Amps
<p>Witnessed by Robert W.</p>		



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

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90. Final Pics and QC Review

Cw

*Chocint*

Co sign: RRW



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