



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

LR Motor Shop Repairs

Job Number 102566

Prepared for FUTURE FUEL CHEMICAL

2800 GAP RD HWY 394 SO
BATESVILLE AR 72501

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Hi-Speed Industrial Service
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DC Repair Report
FUTURE FUEL CHEMICAL
2800 GAP RD HWY 394 SO
BATESVILLE, AR 72501

FolderID: 102566
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DC Repair Report Rev. 2

Location: MOTOR SHOP LR
Job Number: 102566
Serial Number: WP-8-139-WP
Status: Quarantine for review
Description: 25HP 1150 RPM GE

Hi-Speed Job Number: 102566
Manufacturer: GE
Product Number : 5CD184ZA877B800
Serial Number: WP-8-139-WP
HP/KW: 75 (HP)
RPM: 1150
Armature Voltage: 92 (Volts)
Field Voltage: 160 (Volts)
J-Box Included: Yes

Priorities Found: ● 2 - High ● 10 - Good

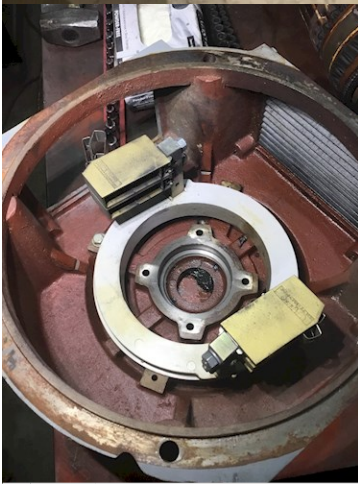
Overall Condition

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



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2. Nameplate Picture



Printed on 5/13/2024



3. Distance From the End of the Shaft to the end of the Face of the Sheave/Coupling

Initial Mechanical/Electrical

- ☒ 4. Does the Shaft Turn Freely?
- (Y) Yes
- ☒ 5. Does Shaft Have Visible Damage?
- (No) No



6. Assembled Shaft Runout

Inches
7. Assembled Shaft End Play

Inches
8. Air Gap Variation <10%
- ☒ 9. Lead Condition

(P) Pass



10. Lead Length

6 Inches

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● 11. Frame Condition	(P) Pass
● 12. Fan Condition	(P) Pass



13. Brush Information		
Brush Number	Quantity	Condition
36A167402AA	4	replace



14. Brush Holder Condition - Verify proper gap to Commutator	pass
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Incoming Electrical Test

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15. General Condition of the Armature/Commutator



16. Armature Insulation Resistance to Ground

Megohms



17. Field Circuit Insulation Resistance to Ground

Megohms



18. Interpole Circuit Insulation Resistance to Ground

Megohms



19. Total Field Ohms

48



20. Field Ohms

Between F1/F2

24.2

Between F3/F4

24.2



21. MegOhms between Fields and Series

22. Series Drop Test 1&2

Series 1

Series 2



23.	Series Drop Test 3&4		
	Series 3	Series 4	
24.	Field Drop Test Fields 1&2		
	Total AC Voltage	Field #1	Field #2
	300	1.7	1.8
25.	Field Drop Test Fields 3&4		
	Field #3	Field #4	Field #2
26.	Field Drop Test Fields 5&6		
	Field #5	Field #6	Field #2
27.	Field Drop Test Fields 7&8		
	Field #7	Field #8	Field #2
28.	Interpole Drop Test 1&2		
	Total AC Voltage	Interpole #1	Interpole #2
	57	34	35
29.	Interpole Drop Test 3&4		
	Interpole #3	Interpole #4	Field #2
30.	Interpole Drop Test 5&6		
	Interpole #5	Interpole #6	Field #2
31.	Interpole Drop Test 7&8		
	Interpole #7	Interpole #8	Field #2
32.	Armature Number of Bars - Bar to Bar Test		
	Number of Bars	Bar to Bar Test	
		pass	
Mechanical Inspection			
33.	Shaft Runout Drive End		0.002 inches
34.	Shaft Runout Armature		
	Drive End Bearing Journal	Armature Core	ODE Bearing Journal
35.	Drive End Bearing Number		6211
36.	Drive End Bearing Quantity		1

37. Drive End Bearing Type

(Ball) Ball Bearing



38. Drive End Lubrication Type

(Grease) Grease Lubricated

39. Drive End Bearing Insulation or Grounding Device?

None

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

none

41. Drive End Bearing Condition

replace/frosting



42. Opposite Drive End Bearing Number

6210

43. Opposite Drive End Bearing Quantity

1

44. Opposite Drive End Bearing Type

(Ball) Ball Bearing



45. Opposite Drive End Lubrication Type

(Grease) Grease Lubricated

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46. Opposite Drive End Bearing Insulation or Grounding Device?	None
47. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
48. Opposite Drive End Bearing Condition	replace/frosted



49. Signature of Technician who Performed Teardown	Terrence Holland
	

50. List Parts Needed Prior to Reassembly	
Mechanical Fits - Armature	
51. Coupling Fit Closest to Bearing Housing	
0 Degrees	60 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
2.1659	2.1657
	2.1658
54. Drive End Bearing Shaft Fit Condition	(P) Pass
55. Opposite Drive End Bearing Shaft Fit	
0 Degrees	60 Degrees
	120 Degrees
1.9688	1.9687
	1.9687
56. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass
57. Shaft Air Seal Fits	
Drive End Air Seal	Opposite Drive End Air Seal
Mechanical Fits- Bearing Housings	
58. Drive End - End Bell Bearing Fit	
0 Degrees	60 Degrees
	120 Degrees
3.939	3.939
59. Drive End - Endbell Bearing Fit Condition	(F) Fail

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60. Opposite Drive End - End Bell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
61. Opposite Drive End - Endbell Bearing Fit Condition (F) Fail		
ODE housing fit requires insulated fit		
62. Bearing Cap Condition		
Drive End	Opposite Drive End	
pass	pass	
<div></div>		
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63. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
64. List any Machine work Needed Below D.E & ODE housing fits bad		
ODE housing fit requires insulated fit.		
65. Signature of Technician Performing Measurements Terrence Holland		
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Root Cause of Failure

66. Failure Locations
D.e and ode bearings, and comm requires polishing.



67. Root Cause of Failure

Motor has no shaft current protection i.e. aegis shaft grounding ring or insulated housing fit or bearing. Both bearings show evidence of electrical discharge machining in the form of frosting.



Commutator Data

68.	Total Copper Segment Length			inches
69.	Number of Bars			
70.	Number of Wires Per Copper Bar and Size			
	Number of Wires per Bar		Wire Size	
71.	Equalizers per Copper Bar and Equalizer Wire Size			
	Equalizers per Bar		Wire Size	
72.	Document Commutator Diameter, Minimum and Max			
	Current Comm Diameter	Minimum Comm Diameter		Maximum Comm Diameter
73.	Commutator Shaft Diameter			
	Front Shaft Diameter		Back Shaft Diameter	
74.	Commutator Type			
75.	Commutator Bore			
76.	Signature of Technician Recording Data			

Dynamic Balance Report

77. Rotor Weight and Balance Grade			
Rotor Weight	Balance Grade		
78. Initial Balance Readings			
Drive End Readings	Opposite Drive End Readings		
79. Final Balance Readings			
Drive End Readings	Opposite Drive End Readings		
80. Signature of the Balance Technician			

Post Armature Rewind Testing

81. Post Rewind Armature Insulation Resistance to Ground	Megohms
82. Post Rewind Field Circuit Measure the Insulation Resistance to Ground	Megohms

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83.	Post Rewind Armature Number of Bars - Bar to Bar Test		
	Number of Bars	Bar to Bar Test	
84.	Post Rewind Field Circuit Insulation Resistance to Ground		Megohms
85.	Post Rewind Interpole Circuit Insulation Resistance to Ground		Megohms
86.	Post Rewind Field Drop Test Fields 1&2		
	Total AC Voltage	Field #1	Field #2
87.	Post Rewind Field Drop Test Fields 3&4		
	Field #3	Field #4	Field #2
88.	Post Rewind Field Drop Test Fields 5&6		
	Field #5	Field #6	Field #2
89.	Post Rewind Field Drop Test Fields 7&8		
	Field #7	Field #8	Field #2
90.	Post Rewind Interpole Drop Test 1&2		
	Total AC Voltage	Interpole #1	Interpole #2
91.	Post Rewind Interpole Drop Test 3&4		
	Interpole #3	Interpole #4	Field #2
92.	Post Rewind Interpole Drop Test 5&6		
	Interpole #5	Interpole #6	Field #2
93.	Post Rewind Interpole Drop Test 7&8		
	Interpole #7	Interpole #8	Field #2
Post Mechanical Repair			
94.	Post Repair Coupling Fit Closest to Bearing Housing		
	0 Degrees	60 degrees	120 degrees
95.	Post Repair Coupling Fit Closest to the End of the Shaft		
	0 Degrees	60 degrees	120 degrees
96.	Post Repair Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
97.	Post Repair Drive End Bearing Shaft Fit Condition		
98.	Post Repair Drive End Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
99.	Post Repair Drive End Opposite Drive End Bearing Shaft Fit Condition		

100. Post Repair Drive End - End Bell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
3.9372	3.9372	3.9372

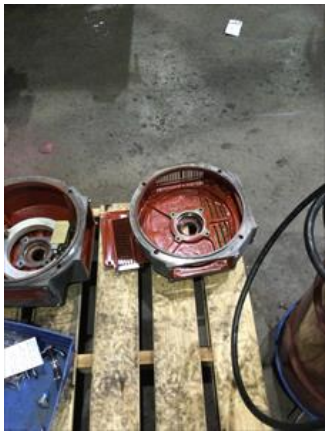
101. Post Repair Drive End - Endbell Bearing Fit Condition		(P) Pass
102. Post Repair Opposite Drive End - End Bell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
103. Post Repair Opposite Drive End - Endbell Bearing Fit Condition		(NA) Not Applicable
104. Post Repair Bearing Cap Condition		
Drive End	Opposite Drive End	

Mounted Agis ring on o.d.e. Bearing cap.

105. Post Repair End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
106. Signature of Tech Performing Mechanical Repairs		Gary

Assembly

107. Take Pictures of all Major Components Prior to Reassembly



108. Verify Brush Box Holders Have the Proper Clearance, and Brushes have been Seated Properly

(P) Pass

109. Assembled Shaft End Play and Runout

Shaft Endplay

Shaft Runout

110. Perform No-Load Test Run, Record Armature Voltage and Current

Voltage	Current
239	1.4



Co witness CRW

111. Perform No-Load Test Run, Record Field Voltage and Current

Voltage	Current
160.5	3.1



112. Document Vibration Readings Drive End

Horizontal	Vertical	Axial
.03	.02	.02

113. Document Vibration Readings Opposite Drive End

Horizontal	Vertical	Axial
.04	.007	.02

114. Perform Full-Load Test Run, Record Armature Voltage and Current

Voltage	Current

115. Perform Full-Load Test Run, Record Field Voltage and Current

Voltage	Current

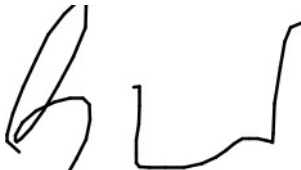

116. Document Vibration Readings Under Full Load Drive End

Horizontal	Vertical	Axial

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117. Document Vibration Readings Under Full Load Opposite Drive End		
Horizontal	Vertical	Axial
118. Ambient Temperature		
		Fahrenheit
119. Drive End Bearing Temps Under Full Load		
5 Minutes	10 Minutes	15 Minutes
120. Opposite Drive End Bearing Temps Under Full Load		
5 Minutes	10 Minutes	15 Minutes
121. Final Test Run Sign-Off		
122. Document Final Condition With Pictures		



123. Final QC Sign-Off	RW
<div>  </div> <div>  Co witness CRW </div>	



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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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