

LR Motor Shop Repairs

Job Number 102313

Prepared for Georges Inc

1810 S. St. Louis Street Batesville AR 72501

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AC Inspection as Found - Shop

AC Inspection - Rev. 2: NO NP

1.0



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AC Inspection as Found

Georges Inc

1810 S. St. Louis Street Batesville, AR 72501

AC Inspection - Rev. 2

Location: Shop Serial Number: NO NP

Description:75HP AQUA JET 1200RPM

Hi-Speed Job Number:	102313
Manufacturer:	Reliance
HP/kW:	75 (HP)
RPM:	1200 (RPM)
Voltage:	460
Phase:	Three
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: 1 - High



7 - Good

Overall Condition

1. Report Date 1/18/2024

Nameplate Picture



Photos of all six sides of the machine.

















4. Describe the Overall Condition of the Equipment as Received *Dirty and rusted*

5. Distance from the end of the shaft to the Coupling/Sheave

Na

Initial Mechanical/Electrical

6. Does Shaft Turn Freely?

(Yes) Yes

inches

7. Does Shaft Have Visible Damage?





2.41		
8.	Assembled Shaft Runout	Inches
-	Na	
9.	Assembled Shaft End Play	inches
-	Na	
10.	Air Gap Variation <10%	
-	Na	
1 1.	Lead Condition	(P) Pass



12.	Lead Length	8 Inches
13.	Lead Numbers	1-3
14.	Frame Condition	
-	Pass	
15.	Fan Condition	(F) Fail



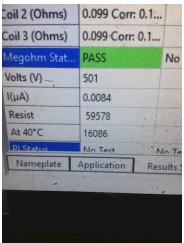


16. Broken or Missing Components

fan cover hood and fan cover bolts and fan

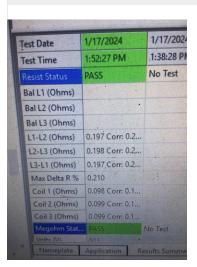
Initial Electrical Inspection

17. Insulation Resistance/Megger Megohms



18. Winding Resistance

1-2 1-3 2-3





(P) Pass



20.	Number of Stator Slots	
21.	Stator Condition	pass
22.	Stator Thermistors/Ohms	
-	Na	
23.	Stator Overloads/Ohms	
-	Na	
Mecha	nical Inspection	
24.	Drive End Bearing Brand	na
25.	Drive End Bearing Number-	5215
26.	Drive End Bearing Qty.	1
27.	Drive End Bearing Type	(Other) Other
-	Double ball double row	
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?	spanner nut
31.	Drive End Bearing Condition	signs of wear



32. Opposite Drive End Bearing Brand	na
33. Opposite Drive End Bearing Number-	6313
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
39. Opposite Drive End Bearing Condition	
Signs of wear	



40. Drive End Seal

Na

41. Opposite Drive End Seal

Na

Rotor	Inspectio	n
IVOLOI	mopecho	

42. Rotor Type/Material (Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
43. Growler Test (Pass) Pass
44. Number of Rotor Bars
45. Rotor Condition pass

46. List the Parts needed for the Repair Below

5215 6313

Bolts for fan cover Bolts for j-box Fan cover hood

47. Signature of Technician that Disassembled Motor

Cw

Mechanical Fits- Rotor

48. Shaft Runout 0.0015 inches

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	
		2.9533	2.9532	2.9532	
	53.	Drive End Bearing Shaft Fit Condition			(P) Pass
	54.	Opposite Drive End Bearing Shaft Fit			
		0 Degrees	60 Degrees	120 Degrees	
		2.5596	2.5597	2.5597	
	55.	Opposite Drive End Bearing Shaft Fit	Condition		(P) Pass
	56.	Shaft Air Seal Fits			
		Drive End Air Seal	Opposite Drive End Air Seal		
	-	Na			
IV		Na anical Fits- Bearing Housings			
IV	lecha				
IV	lecha	anical Fits- Bearing Housings	60 Degrees	120 Degrees	
N	lecha	anical Fits- Bearing Housings Drive End - Endbell Bearing Fit	60 Degrees 5.1188	120 Degrees 5.1189	
N	57.	anical Fits- Bearing Housings Drive End - Endbell Bearing Fit O Degrees	5.1188	_	(P) Pass
N	57. 58.	anical Fits- Bearing Housings Drive End - Endbell Bearing Fit 0 Degrees 5.119	5.1188 tion	_	(P) Pass
N	57. 58.	anical Fits- Bearing Housings Drive End - Endbell Bearing Fit 0 Degrees 5.119 Drive End - Endbell Bearing Fit Condi	5.1188 tion	_	(P) Pass
N	57. 58.	anical Fits- Bearing Housings Drive End - Endbell Bearing Fit 0 Degrees 5.119 Drive End - Endbell Bearing Fit Condition Opposite Drive End - Endbell Bearing	5.1188 tion Fit	5.1189	(P) Pass
•	57. 58. 59.	anical Fits- Bearing Housings Drive End - Endbell Bearing Fit 0 Degrees 5.119 Drive End - Endbell Bearing Fit Condit Opposite Drive End - Endbell Bearing 0 Degrees	5.1188 tion Fit 60 Degrees 5.513	5.1189 120 Degrees	(P) Pass
•	57. 58. 59.	anical Fits- Bearing Housings Drive End - Endbell Bearing Fit O Degrees 5.119 Drive End - Endbell Bearing Fit Condit Opposite Drive End - Endbell Bearing O Degrees 5.5128	5.1188 tion Fit 60 Degrees 5.513	5.1189 120 Degrees	·
•	57. 58. 59.	anical Fits- Bearing Housings Drive End - Endbell Bearing Fit O Degrees 5.119 Drive End - Endbell Bearing Fit Condit Opposite Drive End - Endbell Bearing O Degrees 5.5128 Opposite Drive End - Endbell Bearing	5.1188 tion Fit 60 Degrees 5.513	5.1189 120 Degrees	·
•	57. 58. 59.	anical Fits- Bearing Housings Drive End - Endbell Bearing Fit O Degrees 5.119 Drive End - Endbell Bearing Fit Condit Opposite Drive End - Endbell Bearing O Degrees 5.5128 Opposite Drive End - Endbell Bearing Bearing Cap Condition	5.1188 tion Fit 60 Degrees 5.513 Fit Condition	5.1189 120 Degrees	



62.	End Bell Air Seal Fits	
	Drive End Air Seal	Opposite Drive End Air Seal
-	Na	
63.	Na List Machine Work Needed Below	

64. Technician Cw



Root Cause of Failure

65. Failure locations

Bearings, shaft, and base insert



Machined new shaft bushing.

66. Root cause of failure

After disassembly other than normal bearing wear and bushing fit on shaft being bad, motor is in rather good shape.

Dynamic Balance Report

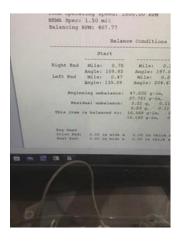
67. Rotor Weight and Balance Grade

Rotor Weight Balance Grade

Na

68. Initial Balance Readings

Drive End Opposite Drive End



Without impeller

69. Final Balance Readings

Drive End

Opposite Drive End



Without impeller

70. Technician Cw

(Mu

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

Mechanical Fits- Rotor - Post Repair

Welded shaft at bushing fit.



80.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
81.	Coupling Fit Closest to Bearing Housi	ng 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 Repa	air	
	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		Gary

In in

Drive End Bearing Cap

Mechanical Fits- Bearing Housings - Post Repair

moonamoar rito	Boaring Housings 1	oot itopan	
87. Drive End	Endbell Bearing Fit Post F	Repair	
0 Degrees	\$	60 Degrees	120 Degrees
88. Opposite D	rive End - Endbell Bearing	Fit Post Repair	
0 Degrees	;	60 Degrees	120 Degrees
89. Bearing Ca	p Condition Post Repair		

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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

Assembly

92. QC Check All Parts for Cleanliness Prior to Assembly

Cw

(//m

93. Photograph All Major Components prior to assembly





94.	Final Insulation Resistance Test Na		Megohms
95.	Assembled Shaft Endplay Na		inches
96.	Assembled Shaft Runout Na		inches
97.	Test Run Voltage		
	Volts	Volts	Volts





99.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
	0.002	0.003	0.002
100.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
	0.003	0.002	0.003
101.	. Ambient Temperature - Fahrenheit		
-	Na		
102.	2. 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.	04. Document Final Condition with Pictures after paint		







105. Final Pics and QC Review

 Cw

Co Signs: TRH



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- 8. <u>WARRANTIES.</u> Hi-Speed warrants that all goods shall conform in all material aspects to the goods identified in the quotation to Buyer and/or purchase order, and Hi-Speed makes to Buyer the manufacturer's express warranty for any goods sold to Buyer, which is offered by the manufacturer at the time of acceptance of any quotation by Buyer. This warranty is conditioned upon the installation, operation, and maintenance of the goods in accordance with the manufacturer's recommendations and/or standard industry practice and the goods at all times being operated or used under normal operating conditions for which they were designed. Hi-Speed, at its sole option, will repair or

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- 12. <u>ABANDONED EQUIPMENT.</u> Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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