



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

LR Motor Shop Repairs

Job Number 102313

Prepared for Georges Inc

1810 S. St. Louis Street
Batesville AR 72501

Table of Contents

AC Inspection as Found - *Shop*

AC Inspection - Rev. 2: *NO NP*

1.0

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Table of Contents



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

AC Inspection as Found

Georges Inc
1810 S. St. Louis Street
Batesville, AR 72501

FolderID: 102313
FormID: 18971135

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 |
| 2. Nameplate Picture | |



- | |
|--|
| 3. Photos of all six sides of the machine. |
|--|

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1.2





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4.	Describe the Overall Condition of the Equipment as Received	
	<i>Dirty and rusted</i>	
5.	Distance from the end of the shaft to the Coupling/Sheave	inches
	Na	
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	(Yes) Yes

7. Does Shaft Have Visible Damage?	(Yes) Yes
	
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	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

Coil 2 (Ohms)	0.099	Corr: 0.1...
Coil 3 (Ohms)	0.099	Corr: 0.1...
Megohm Stat...	PASS	No
Volts (V)	501	
I(μA)	0.0084	
Resist	59578	
At 40°C	16086	
DI Status	No Test	No Te
Nameplate	Application	Results

18. Winding Resistance

1-2

1-3

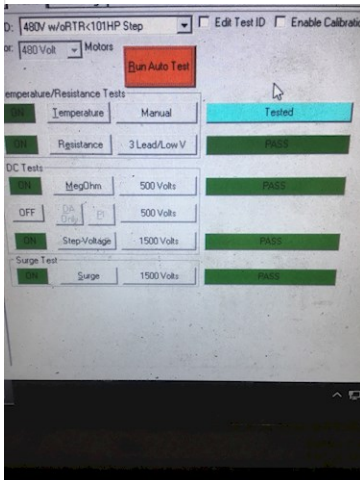
2-3

Test Date	1/17/2024	1/17/2024
Test Time	1:52:27 PM	1:38:28 PM
Resist Status	PASS	No Test
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.197	Corr: 0.2...
L2-L3 (Ohms)	0.198	Corr: 0.2...
L3-L1 (Ohms)	0.197	Corr: 0.2...
Max Delta R %	0.210	
Coil 1 (Ohms)	0.098	Corr: 0.1...
Coil 2 (Ohms)	0.099	Corr: 0.1...
Coil 3 (Ohms)	0.099	Corr: 0.1...
Megohm Stat...	PASS	No Test
Volts (V)	501	
Nameplate	Application	Results Summa

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19. Perform Surge Test

(P) Pass



20. Number of Stator Slots

21. Stator Condition

pass

22. Stator Thermistors/Ohms

Na

23. Stator Overloads/Ohms

Na

Mechanical 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

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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			
<div> <div></div> <div>Signs of wear</div> </div>			
			
40. Drive End Seal	<div> <div></div> <div>Na</div> </div>		
41. Opposite Drive End Seal	<div> <div></div> <div>Na</div> </div>		
Rotor Inspection			
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	<div> <div></div> <div>Cw</div> </div>		
Mechanical Fits- Rotor			
48. Shaft Runout	0.0015 inches		
49. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
<div> <div></div> <div>Na</div> </div>			
50. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
<div> <div></div> <div>Na</div> </div>			

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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		
Mechanical Fits- Bearing Housings		
57. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.119	5.1188	5.1189
58. Drive End - Endbell Bearing Fit Condition		(P) Pass
59. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.5128	5.513	5.5128
60. Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
61. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
Pass		
		
62. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
Na		
63. List Machine Work Needed Below		
DE shaft insert fit and insert		

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Chen

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

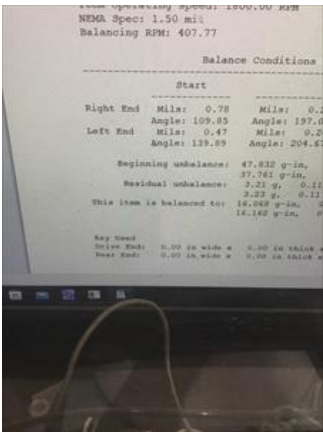
67. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade
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Na

68. Initial Balance Readings

Drive End	Opposite Drive End
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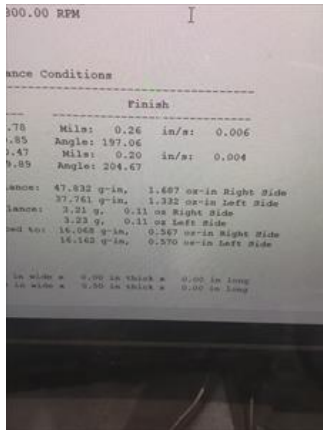
Without impeller

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69. Final Balance Readings

Drive End

Opposite Drive End



Without impeller

70. Technician

Cw

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

79. Shaft Runout Post Repair

0.001 inches

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 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

Gary

Mechanical Fits- Bearing Housings - Post Repair

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

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		
Assembly		
92. QC Check All Parts for Cleanliness Prior to Assembly		Cw
		
93. Photograph All Major Components prior to assembly		
<div></div>		
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



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98. Test Run Amperage

Amps

Amps

Amps



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. 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





105. Final Pics and QC Review

Cw

A handwritten signature in black ink, appearing to read "M. J. J.", is written across the page.



Co Signs: TRH



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8. **WARRANTIES.** 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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10. **SEVERABILITY.** The partial or complete invalidity of any provision of these Standard Terms and Conditions shall not affect the enforceability of the remainder of these Standard Terms and Conditions. If any provision is found to be invalid or unenforceable, that portion shall be modified to make it enforceable or shall be stricken and the remainder of these Standard Terms and Conditions shall enforced.
11. **GOVERNING LAW AND JURISDICTION.** Any controversy arising out of any quotation, the purchase order, the goods sold or delivered, repair or replacement thereof, or any services provided pursuant to any quotation or any purchase order, or these Standard Terms and Conditions shall be governed by the laws of the state of Tennessee without regard to any choice of law provisions and any cause of action related in any manner thereto shall be brought only in the state or federal courts of Shelby County, Tennessee.
12. **ABANDONED EQUIPMENT.** 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.
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.
14. **NONWAIVER.** No course of dealing or failure of either party to strictly enforce any term, right, or condition of these Standard Terms and Conditions will be construed as a waiver of such term, right or condition. Any waiver by Hi-Speed will only be in writing and will waive no succeeding breach of a term, right or condition.
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16. **NO INDIVIDUAL LIABILITY.** Notwithstanding any other agreement to the contrary, the Buyer agrees that in no event will the Buyer hold and Hi-Speed owner, director, officer or employee personally liable for unintentional tortious conduct or conduct that constitutes the breach of any contract between Hi-Speed and the Buyer, even if the Hi-Speed owner, director, officer or employee is or could be construed to be a party to such contract.