



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

LR Motor Shop Repairs

**Job Number 103566**

Prepared for Georges Inc

1810 S. St. Louis Street  
Batesville AR 72501

# Table of Contents

AC Inspection as Found - *Shop*

AC Inspection - Rev. 2: 105020

1.0

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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: 103566  
FormID: 21755383

### AC Inspection - Rev. 2

Location: Shop  
Serial Number: 105020  
Description: 3KW DERTEC 1800RPM 100L  
STAINLESS STEEL WITH GEARBOX

Hi-Speed Job Number:	102090
Manufacturer:	Other
Product Number:	FP2SS 100L2-4 B14A
Serial Number:	105020
HP/kW:	3 (kW)
RPM:	1750 (RPM)
Frame:	100L
Voltage:	230 / 460
Current:	9.03/5.20
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.23
Enclosure:	TEFC
# of Leads:	6
J-box Included:	Complete
Coupling/Sheave:	Gear
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	No
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: ● 1 - High ● 12 - Good

### Overall Condition

1. Report Date	10/02/2024
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## 2. Nameplate Picture



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



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4.	Describe the Overall Condition of the Equipment as Received	
5.	Distance from the end of the shaft to the Coupling/Sheave	inches
6.	Report Date [COPY]	
<b>Initial Mechanical/Electrical</b>		
7.	Does Shaft Turn Freely?	(Y) Yes
8.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
9.	Does Shaft Have Visible Damage?	(No) No
10.	Assembled Shaft Runout	Inches
11.	Assembled Shaft End Play	inches

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12.	Air Gap Variation <10%	
● 13.	Lead Condition	(P) Pass
	3 leads unlabeled	
14.	Lead Length	8 Inches
● 15.	Does it have Lugs?, If so what is the Stud Size?	(No) No
16.	Lead Numbers	1-6
17.	Frame Condition	pass
● 18.	Fan Condition	(P) Pass
19.	Broken or Missing Components	
<b>Initial Electrical Inspection</b>		
20.	Insulation Resistance/Megger	Megohms
21.	Winding Resistance	
	1-2	1-3 2-3
● 22.	Perform Surge Test	(P) Pass
23.	Number of Stator Slots	36
24.	Stator Condition	wash and bake
25.	Stator Thermistors/Ohms	
26.	Stator Overloads/Ohms	
<b>Mechanical Inspection</b>		
27.	Drive End Bearing Brand	KOYO
28.	Drive End Bearing Number-	6306
29.	Drive End Bearing Qty.	1
30.	Drive End Bearing Type	(Ball) Ball Bearing
31.	Drive End Lubrication Type	(Grease) Grease Lubricated
32.	Drive End Bearing Insulation or Grounding Device?	
33.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	
	Snap ring	
34.	Drive End Bearing Condition	signs of frosting
35.	Opposite Drive End Bearing Brand	KOYO
36.	Opposite Drive End Bearing Number-	6306
37.	Opposite Drive End Bearing Qty.	1
38.	Opposite Drive End Bearing Type	(Ball) Ball Bearing
39.	Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
40.	Opposite Drive End Bearing Insulation or Grounding Device?	
41.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
42.	Opposite Drive End Bearing Condition	signs of frosting
● 43.	Drive End Seal	
● 44.	Opposite Drive End Seal	
<b>Rotor Inspection</b>		
45.	Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
46.	Growler Test	(Pass) Pass
47.	Number of Rotor Bars	32
48.	Rotor Condition	pass
49.	List the Parts needed for the Repair Below	
	6008 RSR x2	
	6306 x2	

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50. Signature of Technician that Disassembled Motor

Cw



### Mechanical Fits- Rotor

51. Shaft Runout inches

52. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

53. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

54. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

55. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.1814

1.1814

1.1815

56. Drive End Bearing Shaft Fit Condition

(P) Pass

57. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.1813

1.1813

1.1814

58. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass

59. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

### Mechanical Fits- Bearing Housings

60. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

2.8353

2.8354

2.8353

61. Drive End - Endbell Bearing Fit Condition

(P) Pass

62. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

2.8352

2.8353

2.8352

63. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass

64. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

65. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

66. List Machine Work Needed Below



67. Technician

Cw



Co sign: TH

**Root Cause of Failure**

68. Failure locations

*Motor bearings and input shaft bearings*

69. Root cause of failure

*Bearings failed due to EDM's from being ran off of a drive***Dynamic Balance Report**

70. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

71. Initial Balance Readings

Drive End

Opposite Drive End

72. Final Balance Readings

Drive End

Opposite Drive End

73. Technician

**Assembly**

74. QC Check All Parts for Cleanliness Prior to Assembly

75. Photograph All Major Components prior to assembly

76. Final Insulation Resistance Test

77. Assembled Shaft Endplay

78. Assembled Shaft Runout

79. Test Run Voltage

Volts

Volts

Volts

80. Test Run Amperage

Amps

Amps

Amps

81. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

82. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

83. Ambient Temperature - Fahrenheit

84. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

85. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

86. Document Final Condition with Pictures after paint

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