



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

LR Motor Shop Repairs

Job Number 102456

Prepared for Kimberly Clark (10176-KCM)

500 Murphy Dr.
Maumelle AR 72113

Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *RKG173045*

1.0

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

AC Inspection as Found
Kimberly Clark (10176-KCM)
500 Murphy Dr.
Maumelle, AR 72113

FolderID: 102456
FormID: 19281272

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: RKG173045

Description: 150HP GE 1800RPM 449T

Hi-Speed Job Number: 102456

Manufacturer: GE

Product Number: 5KAF44933229AP

Serial Number: RKG173045

HP/kW: 150 (HP)

RPM: 1790 (RPM)

Frame: 449T

Voltage: 460

Current: 161

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

J-box Included: Complete

Coupling/Sheave: None

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: No

Shaft Machined Fit Repairs Required: Yes

Bearing Housing Machined Fit Repairs Required: Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● **4 - High** ● **7 - Good**

Overall Condition

1. Report Date

04/02/2024

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2. Nameplate Picture



3. Photos of all six sides of the machine.



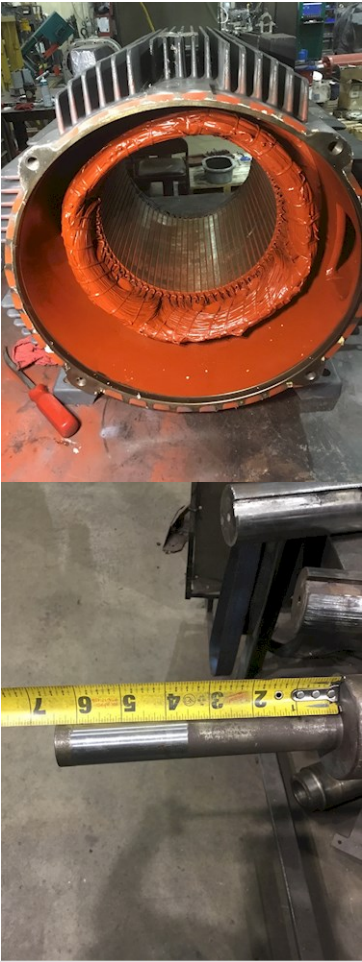
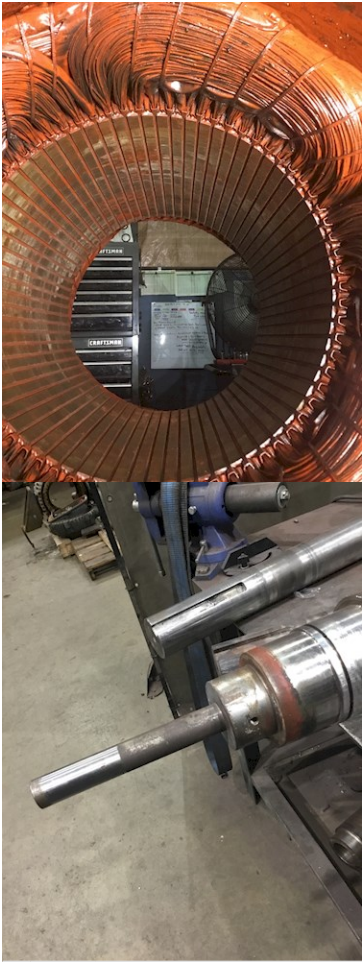


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1.2



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

Initial Mechanical/Electrical

<input checked="" type="radio"/>	5. Does Shaft Turn Freely?	(No) No
<input checked="" type="radio"/>	6. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
	7. Does Shaft Have Visible Damage?	(Yes) Yes
	8. Assembled Shaft Runout	Inches
<input type="text"/>	<i>Na</i>	
	9. Assembled Shaft End Play	inches
<input type="text"/>	<i>Na</i>	
	10. Air Gap Variation <10%	
<input type="text"/>	<i>Na</i>	

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11. Lead Condition

(P) Pass



12. Lead Length

7 Inches

13. Does it have Lugs?, If so what is the Stud Size?

(Yes) Yes

Ok

14. Lead Numbers

1-3

15. Frame Condition

pas

16. Fan Condition

(P) Pass



17. Broken or Missing Components

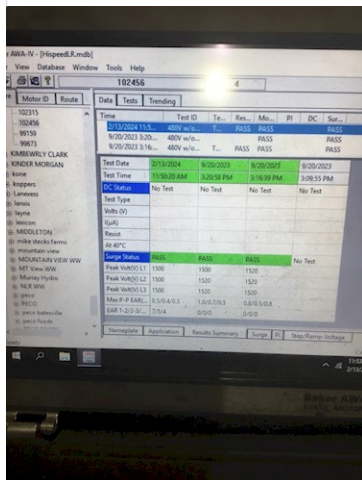
none

Initial Electrical Inspection

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18. Insulation Resistance/Megger

Megohms

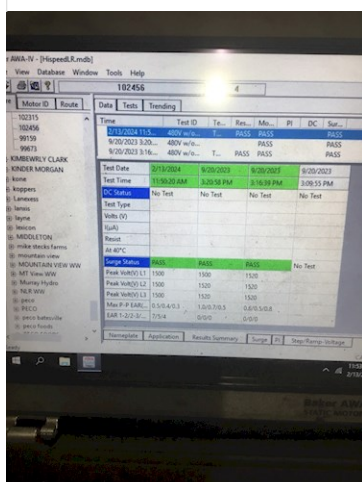


19. Winding Resistance

1-2

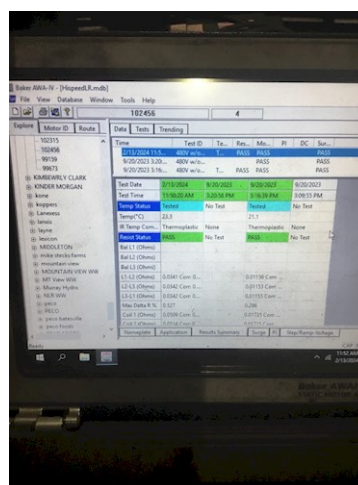
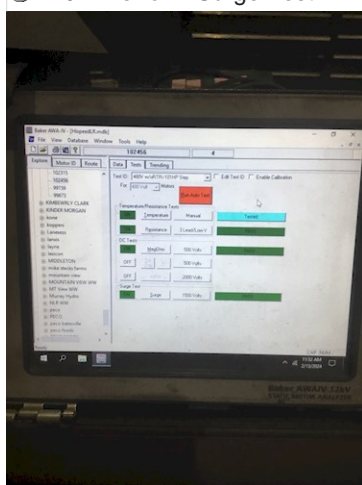
1-3

2-3

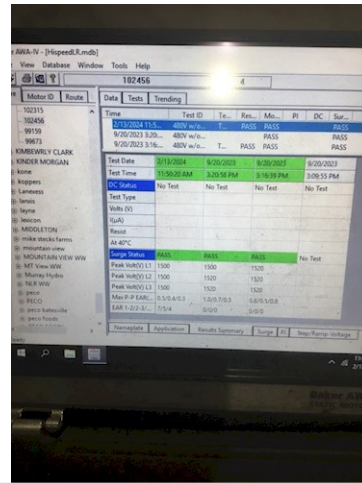
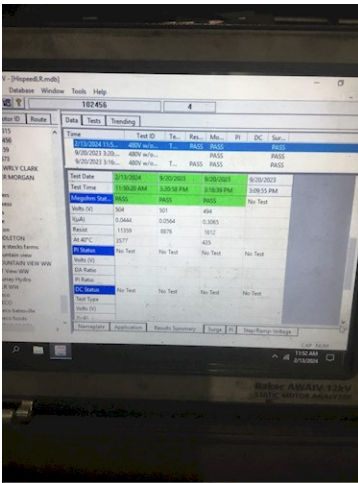


20. Perform Surge Test

(P) Pass



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21. Number of Stator Slots	72
22. Stator Condition	pass
23. Stator Thermistors/Ohms	
24. Stator Overloads/Ohms	.1
Mechanical Inspection	
25. Drive End Bearing Brand	FAG
26. Drive End Bearing Number-	NU 318-E-XL-M1-C3
Motor to be engineered for a 318 ball bearing instead of a NU 318.	



27. Drive End Bearing Qty.	1
28. Drive End Bearing Type	(Roller) Roller Bearing
29. Drive End Lubrication Type	(Grease) Grease Lubricated

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30. Drive End Bearing Insulation or Grounding Device?

aegis ring



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

none

32. Drive End Bearing Condition

destroyed



33. Opposite Drive End Bearing Brand

FAG



34. Opposite Drive End Bearing Number-



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?	snap ring
40. Opposite Drive End Bearing Condition	replace
41. Drive End Seal	na
42. Opposite Drive End Seal	na
Rotor Inspection	
43. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast



44. Growler Test	(Pass) Pass
45. Number of Rotor Bars	58
46. Rotor Condition	
<div>  Good, needs new shaft. </div>	
47. List the Parts needed for the Repair Below	
<i>New shaft, and new DE bearing cap. Sleeve DE housing and shaft opening. Replace plastic fan with metal one. Replace aegis ring, shaft diameter 4.1875. Drill and tap ODE fan cover mount bolt hole. Motor needs to be converted from using a 318 NU to a 318 ball bearing.</i>	

48. Signature of Technician that Disassembled Motor

Terrence Holland


Mechanical Fits- Rotor49. Shaft Runout inches
 *New shaft needed.*

50. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

 *Na*

51. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

0**0****0**

52. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

0**0****0**

53. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees


 54. Drive End Bearing Shaft Fit Condition **(F) Fail**

55. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.5431**3.543****3.5431**
 56. Opposite Drive End Bearing Shaft Fit Condition **(P) Pass**

57. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

ok**ok****Mechanical Fits- Bearing Housings**

58. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees


120 Degrees

 *Lip worn in.*

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59.	Drive End - Endbell Bearing Fit Condition	(F) Fail	
	<i>Lip ring worn in.</i>		
60.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	7.4811	7.4812	7.4812
61.	Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass	
62.	Bearing Cap Condition		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	fail	pass	
	<i>D.E bearing cap stuck on shaft.</i>		



63.	End Bell Air Seal Fits	
	Drive End Air Seal	Opposite Drive End Air Seal
	ok	ok
64.	List Machine Work Needed Below	
	<i>Recommend new shaft. Sleeve D.E housing, shaft opening. Repair D.E bearing cap. Remove, drill and tap ODE housing fan cover mount bolt.</i>	
65.	Technician	Terrence Holland
		

Root Cause of Failure

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66. Failure locations

D.E housing and shaft-fits.

67. Root cause of failure

Drive end bearing had catastrophic failure, bearing is too destroyed to find root cause, plus bearing had contaminated lubrication.

Dynamic Balance Report

68. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

Na

69. Initial Balance Readings

Drive End

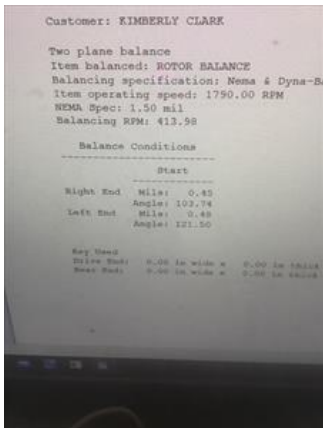
Opposite Drive End



70. Final Balance Readings

Drive End

Opposite Drive End



71. Technician

Cw

Chrim

Mechanical Fits- Rotor - Post Repair

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72. Shaft Runout Post Repair

inches

New shaft



73. Rotor Runout Post Repair

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0	0	0

74. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees	90 Degrees	120 Degrees
0	0	0

75. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees	60 Degrees	120 Degrees
0	0	0

76. Drive End Bearing Shaft Fit Post Repair

0 Degrees	60 Degrees	120 Degrees
0	0	0

77. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees	60 Degrees	120 Degrees
0	0	0

78. Shaft Air Seal Fits Post Repair

Drive End Air Seal	Opposite Drive End Air Seal
ok	ok

79. Shaft Repair Sign-off

Gary

Mechanical Fits- Bearing Housings - Post Repair

80. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

7.4805



60 Degrees

7.4806

120 Degrees

7.4806



Sleeved exit bore .

81. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

0

60 Degrees

0

120 Degrees

0

82. Bearing Cap Condition Post Repair

Drive End Bearing Cap

4.217



Opposite Drive End Bearing Cap



Reduced O.D.E. bearing cap shoulder by .06 and increased housing depth by .06 for thermal expansion. Changed locked bearing from O.D.E. to D.E.

83. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

N/A

84. End Bell Repair Sign-off

Gary

[Handwritten signature]

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Assembly

85. QC Check All Parts for Cleanliness Prior to Assembly

David Maclin

[Handwritten signature]

86. Photograph All Major Components prior to assembly

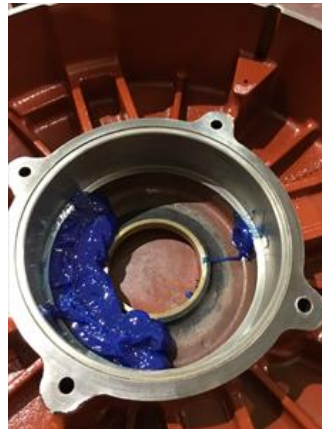
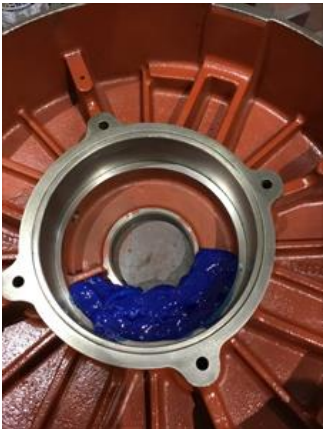


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87.	Final Insulation Resistance Test	2000 Megohms	
88.	Assembled Shaft Endplay	0 inches	
89.	Assembled Shaft Runout	0.001 inches	
	Tach shaft <.001 RWiley		
90.	Test Run Voltage		
	Volts	Volts	Volts
	458	458	458
	Witnessed by r wiley		



91. Test Run Amperage

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	Amps	Amps	Amps
	34.8	35	34.2
92.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
	0.0455	0.0541	0.0212
93.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
	0.0388	0.0468	0.056
94.	Ambient Temperature - Fahrenheit		72.8
95.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
	74.59999999999999	76.59999999999999	80.40000000000001
	20min- 84.2 25min-82.2 30min- 82.2		
96.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
	0	0	0
97.	Document Final Condition with Pictures after paint		looks ok
98.	Final Pics and QC Review		David Maclin
			
	Co sign: Crw		





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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.
15. **ASSIGNMENT.** The rights and obligations of the parties shall neither be assigned nor delegated without the prior written consent of the other party. However, any party may assign or delegate its respective rights and obligations, in whole or in part, (i) to any subsidiary, (ii) pursuant to other financing, merger or reorganization or (iii) pursuant to any sale or transfer of substantially all of the assets of the assigning party. These Standard Terms and Conditions shall bind the heirs, successors and assigns of the parties hereto.
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.