



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

LR Motor Shop Repairs

Job Number 102906

Prepared for Kroger

20820 interstate 30 N
Benton AR 72019

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AC Inspection as Found - *Motor Shop*

AC Inspection - Rev. 2: 32-12-200A 2A

1.0

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Printed on 7/22/2024

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AC Inspection as Found

Kroger

20820 interstate 30 N
Benton, AR 72019

FolderID: 102906
FormID: 20326568

AC Inspection - Rev. 2

Location: Motor Shop

Serial Number: 32-12-200A 2A

Description: 6HP ILG IND

Hi-Speed Job Number: 102906

Manufacturer: Other

Serial Number: 32-12-200A 2A

HP/kW: 6 (HP)

RPM: 855 (RPM)

Frame: 32

Voltage: Other

Current: 18 (Amps)

Phase: Three

Hz: 60 (Hz)

Enclosure: TENV

of Leads: 3

J-box Included: None

Coupling/Sheave: None

Date Received: 05/08/2024

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: Yes

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: ● 5 - High ● 4 - Good

Overall Condition

1. Report Date

05/20/2024

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1.0

2. Nameplate Picture



3. Photos of all six sides of the machine.





4. Describe the Overall Condition of the Equipment as Received		
<i>Serviceable</i>		
Initial Mechanical/Electrical		
● 5. Does Shaft Turn Freely?		(N) No
● 6. Does the shaft require T.I.R in Lathe to identify additional repairs?		(Yes) Yes
☞ <i>ODE bearing journal.</i>		
7. Does Shaft Have Visible Damage?		(No) No
8. Assembled Shaft Runout		Inches
☞ <i>Couldn't perform. Motor locked up.</i>		
9. Assembled Shaft End Play		inches
☞ <i>Na</i>		
10. Air Gap Variation <10%		
☞ <i>Na</i>		
● 11. Lead Condition		(P) Pass

12. Lead Length

3 Inches



13. Does it have Lugs?, If so what is the Stud Size?	(No) No
14. Lead Numbers	1-3
15. Frame Condition	pass
16. Fan Condition	(N) NA
Na	
17. Broken or Missing Components	none
Initial Electrical Inspection	
18. Insulation Resistance/Megger	Megohms
Na	
19. Winding Resistance	
1-2	1-3 2-3
Na	
20. Perform Surge Test	(NA) Not Applicable
Windings charred	



21. Number of Stator Slots	54
22. Stator Condition	rewind
23. Stator Thermistors/Ohms	
Na	
24. Stator Overloads/Ohms	
Na	

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Mechanical Inspection

25. Drive End Bearing Brand

KBC

26. Drive End Bearing Number-



27. Drive End Bearing Qty.

1

28. Drive End Bearing Type

(Ball) Ball Bearing

29. Drive End Lubrication Type

(Grease) Grease Lubricated

30. Drive End Bearing Insulation or Grounding Device?

none

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

none

32. Drive End Bearing Condition

locked up

33. Opposite Drive End Bearing Brand

JAF

34. Opposite Drive End Bearing Number-





35. Opposite Drive End Bearing Qty.	6206
Sealed double wide	
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?	



40. Opposite Drive End Bearing Condition	worn
41. Drive End Seal	none
42. Opposite Drive End Seal	none

Rotor Inspection

43. Rotor Type/Material

(Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast

44. Growler Test (Pass) Pass

45. Number of Rotor Bars 67

46. Rotor Condition pass

47. List the Parts needed for the Repair Below

Bearings,

48. Signature of Technician that Disassembled Motor Terrence Holland

Mechanical Fits- Rotor

49. Shaft Runout inches

ODE shaft bearing journal out of tolerance. Unable to perform measurement.

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

Na

52. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

Na

53. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.575**1.575****1.5749**

54. Drive End Bearing Shaft Fit Condition (P) Pass

55. Opposite Drive End Bearing Shaft Fit


0 Degrees

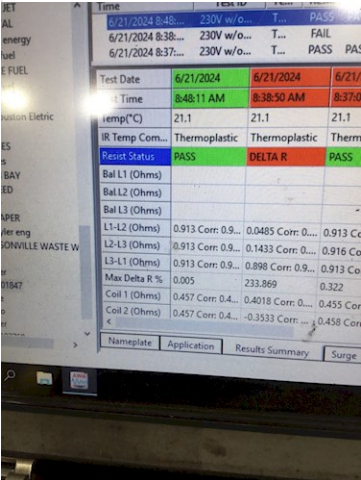
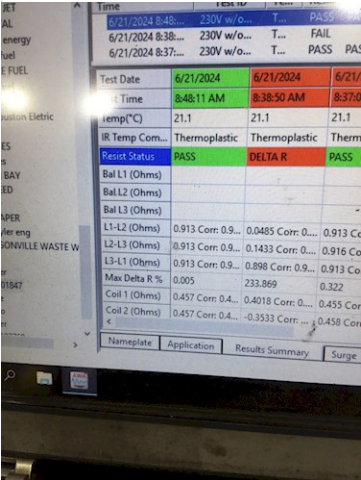
60 Degrees

120 Degrees

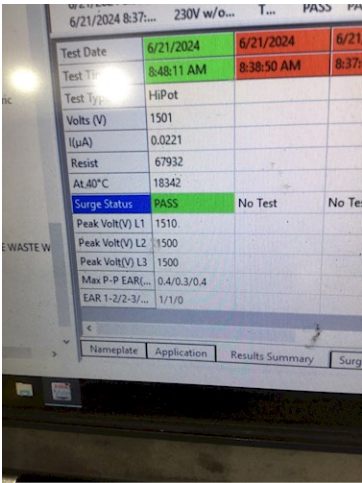
Excessive wear. Bearing came off in housing.

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56.	Opposite Drive End Bearing Shaft Fit Condition	(F) Fail
57.	Shaft Air Seal Fits	
	Drive End Air Seal	Opposite Drive End Air Seal
	Na	
Mechanical Fits- Bearing Housings		
58.	Drive End - Endbell Bearing Fit	
	0 Degrees	60 Degrees 120 Degrees
	Lip worn in.	
59.	Drive End - Endbell Bearing Fit Condition	(F) Fail
60.	Opposite Drive End - Endbell Bearing Fit	
	0 Degrees	60 Degrees 120 Degrees
	Lip worn in	
61.	Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail
62.	Bearing Cap Condition	
	Drive End Bearing Cap	Opposite Drive End Bearing Cap
	Na	
63.	End Bell Air Seal Fits	
	Drive End Air Seal	Opposite Drive End Air Seal
	Na	
64.	List Machine Work Needed Below	
	Both housing fits, and ode shaft bearing journal, and stator windings	
65.	Technician	Terrence Holland
		
	Witness: RRW	
Root Cause of Failure		
66.	Failure locations	
	Both housing fits, ode shaft bearing fit, and rewind stator.	
67.	Root cause of failure	
	Excessive amounts of moisture entered into the stator housings and bearings causing them to lock up. Also contributed to windings shorted to ground.	
Dynamic Balance Report		
68.	Rotor Weight and Balance Grade	
	Rotor Weight	Balance Grade
69.	Initial Balance Readings	
	Drive End	Opposite Drive End
70.	Final Balance Readings	
	Drive End	Opposite Drive End

71. Technician		
Rewind		
72. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	
73. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	
74. Post Rewind Electrical Test- Insulation Resistance		Megohms
		
75. Post Rewind Polarization Index		Polarization Index
76. Post Rewind Winding Resistance		
1-2	1-3	2-3
		
77. Post Rewind Surge Test		(Pass) Pass

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78.	Post Rewind Hi-Pot	micro-amps	
79.	Technician	Ztw	
Mechanical Fits- Rotor - Post Repair			
80.	Shaft Runout Post Repair	0.001 inches	
81.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
	0.001	0.0015	0.002
82.	Coupling Fit Closest to Bearing Housing Post Repair		
	0 Degrees	90 Degrees	120 Degrees
83.	Coupling Fit Closest to the end of the Shaft Post Repair		
	0 Degrees	60 Degrees	120 Degrees
84.	Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	1.5751	1.5751	1.575



85. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

1.1812

60 Degrees

1.1812

120 Degrees

1.1812



86. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

87. Shaft Repair Sign-off

Gary ,Robert

Mechanical Fits- Bearing Housings - Post Repair

88. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

3.1499

60 Degrees

3.1499




120 Degrees

3.1499



89. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
2.4414	2.4414	2.4414



90. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
91. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
92. End Bell Repair Sign-off		RW
		
Assembly		
93. QC Check All Parts for Cleanliness Prior to Assembly		Cw
		
94. Photograph All Major Components prior to assembly		
95. Final Insulation Resistance Test		Megohms
 Pass		
96. Assembled Shaft Endplay		inches
97. Assembled Shaft Runout		inches

98. Test Run Voltage

Volts

Volts

Volts



99. Test Run Amperage

Amps

Amps

Amps



100. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

101. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

102. Ambient Temperature - Fahrenheit

103. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

104. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

105. Document Final Condition with Pictures after paint

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106. Final Pics and QC Review

Cw

Cw



Co sign: RRW



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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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