



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

LR Motor Shop Repairs

Job Number 102766

Prepared for Miller Spectacular Shows (12776)

79 Mountain Drive
Greenbrier AR 72058

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AC Inspection as Found - *LITTLE ROCK MOTOR SHOP*

AC Inspection - Rev. 2: 132

1.0

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Hi-Speed Industrial Service
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AC Inspection as Found
Miller Spectacular Shows (12776)
79 Mountain Drive
Greenbrier, AR 72058

FolderID: 102766
FormID: 20121499

AC Inspection - Rev. 2

Location: LITTLE ROCK MOTOR SHOP

Serial Number: 132

Description: 4.5KW ROWAN ELECTRONICA

Hi-Speed Job Number: 102766

Manufacturer: Other

Product Number: M: 45601

Serial Number: 132

HP/kW: 4.5 (kW)

RPM: 700 (RPM)

Current: 33 (Amps)

Phase: Three

Hz: 60 (Hz)

of Leads: 6

J-box Included: Complete

Coupling/Sheave: None

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: ● 7 - High ● 4 - Good

Overall Condition

1. Report Date
2. Nameplate Picture



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3. Photos of all six sides of the machine.





4. Describe the Overall Condition of the Equipment as Received

Serviceable

Initial Mechanical/Electrical

| | |
|--|--------------|
| 5. Does Shaft Turn Freely? | (Y) Yes |
| 6. Does the shaft require T.I.R in Lathe to identify additional repairs? | (No) No |
| 7. Does Shaft Have Visible Damage? | (No) No |
| 8. Assembled Shaft Runout | 0.003 Inches |
| 9. Assembled Shaft End Play | inches |
| 10. Air Gap Variation <10% | |

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11. Lead Condition

(F) Fail



12. Lead Length

6 Inches



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

(Yes) Yes

14. Lead Numbers

1-6

15. Frame Condition

pass

16. Fan Condition

(N) NA

17. Broken or Missing Components

tach broken, connection box broken.

Initial Electrical Inspection

18. Insulation Resistance/Megger

Megohms

Na

19. Winding Resistance

1-2

1-3

2-3

Na

20. Perform Surge Test

(F) Fail

Na

21. Number of Stator Slots

36

22. Stator Condition

rewind

23. Stator Thermistors/Ohms

na

24. Stator Overloads/Ohms

na

Mechanical Inspection

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| | |
|-------------------------------|----------|
| 25. Drive End Bearing Brand | skf |
| 26. Drive End Bearing Number- | 6209 2rs |



| | |
|---|----------------------------|
| 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? | snap rings |
| 32. Drive End Bearing Condition | replace |
| 33. Opposite Drive End Bearing Brand | nsk |
| 34. Opposite Drive End Bearing Number- | 6207 DU |



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| | |
|--|---|
| 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? | wavy washer |
| 40. Opposite Drive End Bearing Condition | replace |
| 41. Drive End Seal | none |
| 42. Opposite Drive End Seal | none |
| Rotor Inspection | |
| 43. Rotor Type/Material | (Squirrel Aluminum) Squirrel Cage Aluminum Die Cast |
| <div>   </div> | |
| 44. Growler Test | (Pass) Pass |
| 45. Number of Rotor Bars | 0 |
| 46. Rotor Condition | <div> <div></div> <div>Pass</div> </div> |
| 47. List the Parts needed for the Repair Below | <i>Re-sleeve both housing fits. Repair both shaft bearing journals. Replace broken tach and associated hardware. Rewind stator.</i> |

48. Signature of Technician that Disassembled Motor

Terrence Holland



Mechanical Fits- Rotor

49. Shaft Runout inches

50. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

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

1.7647

1.7649

1.7644

54. Drive End Bearing Shaft Fit Condition

(F) Fail

55. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.3776

1.3777

1.3779

56. Opposite Drive End Bearing Shaft Fit Condition

(F) Fail

57. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

58. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

Excessive wear and pitting.



59. Drive End - Endbell Bearing Fit Condition

(F) Fail

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| | | |
|---|--------------------------------|------------------|
| 60. Opposite Drive End - Endbell Bearing Fit | | |
| 0 Degrees | 60 Degrees | 120 Degrees |
| <div> <div></div> <div>Excessive wear and pitting.</div> </div> | | |
|  | | |
| 61. Opposite Drive End - Endbell Bearing Fit Condition | | (F) Fail |
| 62. Bearing Cap Condition | | |
| Drive End Bearing Cap | Opposite Drive End Bearing Cap | |
| 63. End Bell Air Seal Fits | | |
| Drive End Air Seal | Opposite Drive End Air Seal | |
| 64. List Machine Work Needed Below | | |
| Re-sleeve both housing fits. Repair both shaft bearing journals. Replace broken tach and associated hardware. Rewind stator. | | |
| 65. Technician | | Terrence Holland |
|  | | |
| Root Cause of Failure | | |
| 66. Failure locations | | |
| Re-sleeve both housing fits. Repair both shaft bearing journals. Replace broken tach and associated hardware. Rewind stator. | | |
| 67. Root cause of failure | | |
| Multiple. Bearing grease in both bearings contaminated. Both housing and shaft fits out of tolerance. All leads have no insulation which 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 | | |

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| 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 |
| 78. | Post Rewind Hi-Pot | | micro-amps |
| 79. | Technician | | |
| 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 | 0.001 | 0.0015 |
| 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 |
| | 1.772 | 1.772 | 1.772 |



85. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

1.3783

60 Degrees

1.3784

120 Degrees

1.3784



86. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

87. Shaft Repair Sign-off

Gary

Gary

Mechanical Fits- Bearing Housings - Post Repair

88. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

3.3465

60 Degrees

3.3465



120 Degrees

3.3465



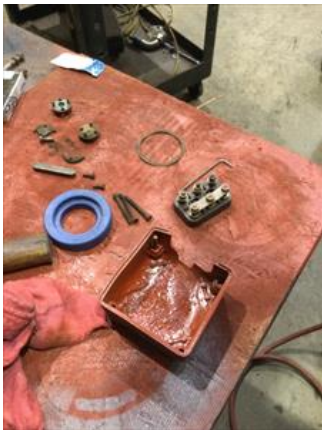
| | | |
|--|------------|-------------|
| 89. Opposite Drive End - Endbell Bearing Fit Post Repair | | |
| 0 Degrees | 60 Degrees | 120 Degrees |
| 2.835 | 2.835 | 2.835 |



| | | |
|---|--|--------------------------------|
| 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 | | Gary |
|  | | |
| Assembly | | |
| 93. QC Check All Parts for Cleanliness Prior to Assembly | | RW |
|  | | |

94. Photograph All Major Components prior to assembly

(Complete) Complete



| | | | |
|--------------------------------------|-------|-------|---------|
| 95. Final Insulation Resistance Test | | | Megohms |
| Passed HI POT | | | |
| 96. Assembled Shaft Endplay | | | inches |
| 97. Assembled Shaft Runout | | | inches |
| 98. Test Run Voltage | | | |
| Volts | Volts | Volts | |
| 216 | 216 | 216 | |



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99. Test Run Amperage

Amps

28.3

Amps

26.4

Amps

26.2



Co witness RR

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

RW



CO WITNESS TRH



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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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