



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

LR Motor Shop Repairs

**Job Number 102896**

Prepared for Peco Foods

625 S. Allen Street  
Batesville AR 72501

# Table of Contents

AC Inspection as Found - *Shop*

AC Inspection - Rev. 2: *LSP-S19-6265-3-KT*

**1.0**

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

## AC Inspection as Found

**Peco Foods**  
625 S. Allen Street  
Batesville, AR 72501

FolderID: 102896  
FormID: 20301037

### AC Inspection - Rev. 2

**Location:** Shop  
**Serial Number:** LSP-S19-6265-3-KT  
**Description:** 570HP MARATHON MOTOR

<b>Hi-Speed Job Number:</b>	102896
<b>Manufacturer:</b>	Marathon
<b>Serial Number:</b>	LSP-S19-6265-3-KT
<b>HP/kW:</b>	570 (HP)
<b>RPM:</b>	3530 (RPM)
<b>Frame:</b>	5008DZ
<b>Voltage:</b>	460
<b>Current:</b>	635 (Amps)
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b>Enclosure:</b>	TEFC
<b># of Leads:</b>	6
<b>J-box Included:</b>	None
<b>Coupling/Sheave:</b>	Coupling
<b>Date Received:</b>	05/06/2024
<b>Bearing RTDs:</b>	No
<b>Stator RTDs:</b>	No
<b>Repair Stage:</b>	Final
<b>Rewind:</b>	No
<b>Shaft Machined Fit Repairs Required:</b>	Yes
<b>Bearing Housing Machined Fit Repairs Required:</b>	Yes
<b>Heaters:</b>	Yes
<b>Winding Type :</b>	Random Wound
<b>Bearing Type:</b>	Rolling Element

Priorities Found: ● 2 - High ● 8 - Good

### Overall Condition

1. Report Date

05/13/2024

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1.2





4. Describe the Overall Condition of the Equipment as Received  
*Dirty*

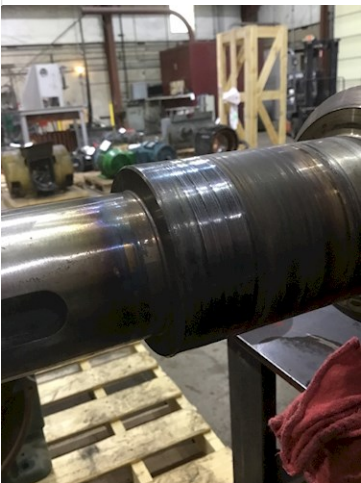
5. Distance from the end of the shaft to the Coupling/Sheave

inches



**Initial Mechanical/Electrical**





- |  |           |
|--|-----------|
| 6. Does Shaft Turn Freely?   | (N) No    |
| 7. Does the shaft require T.I.R in Lathe to identify additional repairs? | (Yes) Yes |
| 8. Does Shaft Have Visible Damage?                                       | (Yes) Yes |



9. Assembled Shaft Runout

Inches

Na

10.	Assembled Shaft End Play	inches
	Na	
11.	Air Gap Variation <10%	
	Na	
	12. Lead Condition	(P) Pass
	13. Lead Length	24 Inches
	14. Does it have Lugs?, If so what is the Stud Size?	
	Yes	
	15. Lead Numbers	1-6
	16. Frame Condition	pass
	17. Fan Condition	(N) NA
	18. Heater Quantity, Ratings	
	Quantity	Volts/Watts
	1	120V/300W
		Pass/Fail
		Pass
	19. Broken or Missing Components	J-Box
Initial Electrical Inspection		
	20. Insulation Resistance/Megger	Megohms

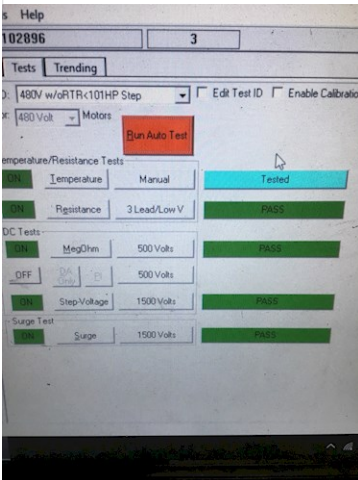
Coil 1 (Ohms)	0.01015 Corr: ..	
Coil 2 (Ohms)	0.01013 Corr: ..	
Coil 3 (Ohms)	0.01012 Corr: ..	
Megohm Stat...	PASS	
Volts (V)	501	
I(μA)	0.0887	
Resist	5651	
At 40°C	1525	
PI Status	No Test	
Volts (V)		
DA Ratio ~		
PI Ratio		
Nameplate	Application	Res

21. Winding Resistance		
1-2	1-3	2-3

Test Time	7:58:10 AM	
Resist Status	PASS	
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.00676 Corr: ...	
L2-L3 (Ohms)	0.00676 Corr: ...	
L3-L1 (Ohms)	0.00675 Corr: ...	
Max Delta R %	0.142	
Coil 1 (Ohms)	0.01015 Corr: ...	
Coil 2 (Ohms)	0.01013 Corr: ...	
Coil 3 (Ohms)	0.01012 Corr: ...	
Megohm Stat...	PASS	
Volts (V)	501	
Nameplate	Application	Res

## 22. Perform Surge Test

(P) Pass



23. Number of Stator Slots 48

24. Stator Condition needs cleaned

25. Stator Thermistors/Ohms

Na

26. Stator Overloads/Ohms

Na

### Mechanical Inspection

27. Drive End Bearing Brand Skf

28. Drive End Bearing Number- 6316



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? na

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

34. Drive End Bearing Condition ball cage failed

35. Opposite Drive End Bearing Brand SKF

36. Opposite Drive End Bearing Number- 6316

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? na

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41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer	
42. Opposite Drive End Bearing Condition		
<div> <div></div> <div>Signs of metal fatigue and contamination</div> </div>		
		
43. Drive End Seal	na	
44. Opposite Drive End Seal	na	
<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	40	
48. Rotor Condition	needs washed	
49. List the Parts needed for the Repair Below	6316x2	
50. Signature of Technician that Disassembled Motor	<div>Cw</div> 	
<b>Mechanical Fits- Rotor</b>		
51. Shaft Runout	0.002 inches	
52. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
<div> <div></div> <div>Na</div> </div>		
53. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
<div> <div></div> <div>Na</div> </div>		
54. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
<div> <div></div> <div>Na</div> </div>		
55. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
3.1499	3.1498	3.1499

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56.	Drive End Bearing Shaft Fit Condition	(P) Pass
57.	Opposite Drive End Bearing Shaft Fit	
	0 Degrees                      60 Degrees                      120 Degrees	
	3.1498                      3.1499                      3.1499	
58.	Opposite Drive End Bearing Shaft Fit Condition	(P) Pass
59.	Shaft Air Seal Fits	
	Drive End Air Seal                      Opposite Drive End Air Seal	
	Na	
<b>Mechanical Fits- Bearing Housings</b>		
60.	Drive End - Endbell Bearing Fit	
	0 Degrees                      60 Degrees                      120 Degrees	
	6.6937                      6.6937                      6.6938	
61.	Drive End - Endbell Bearing Fit Condition	(P) Pass
62.	Opposite Drive End - Endbell Bearing Fit	
	0 Degrees                      60 Degrees                      120 Degrees	
	6.6927                      6.5929                      6.6928	
63.	Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass
64.	Bearing Cap Condition	
	Drive End Bearing Cap                      Opposite Drive End Bearing Cap	
	Pass	
65.	End Bell Air Seal Fits	
	Drive End Air Seal                      Opposite Drive End Air Seal	
	Na	
66.	List Machine Work Needed Below <i>DE of shaft where shaft seats in end bell</i>	
67.	Technician	Crw
		
	Co sign: TRH	
<b>Root Cause of Failure</b>		
68.	Failure locations <i>Bearings</i>	
69.	Root cause of failure <i>Cage failed</i>	
<b>Dynamic Balance Report</b>		

## 70. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



## 71. Initial Balance Readings

Drive End

Opposite Drive End

0.17

0.14

## 72. Final Balance Readings

Drive End

Opposite Drive End

0.17

0.14

## 73. Technician

RW

## Mechanical Fits- Rotor - Post Repair

## 74. Shaft Runout Post Repair

inches

## 75. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

## 76. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

## 77. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

## 78. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

## 79. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

80. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal



Turned air seal shoulder to 3.135"

81. Shaft Repair Sign-off

Gary

**Mechanical Fits- Bearing Housings - Post Repair**

82. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

83. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

84. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

85. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal



Sleeved air seal fit to 3.160"

86. End Bell Repair Sign-off

**Assembly**

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87. QC Check All Parts for Cleanliness Prior to Assembly

RW

*h w*

88. Photograph All Major Components prior to assembly

(Complete) Complete



89. Final Insulation Resistance Test

7100 Megohms

☒ Passed hi pot

90. Assembled Shaft Endplay

inches

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91. Assembled Shaft Runout	0.0004 inches	
92. Test Run Voltage		
Volts	Volts	Volts
455	454	457
Delta		



O witness SC

Y

93. Test Run Amperage		
Amps	Amps	Amps
191	172	179
Delta		



Y

94. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.01	0.01	0.01
95. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.03	0.02	0.01
96. Ambient Temperature - Fahrenheit		
97. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes

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98. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

99. Document Final Condition with Pictures after paint



100. Final Pics and QC Review

RW

*[Handwritten signature]*

Co witness SC



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