



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

LR Motor Shop Repairs

Job Number 102813

Prepared for Process & Power

1625 East 145th Street
Little Rock AR 72206

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AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: 733926/002

1.0

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Printed on 4/25/2024

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AC Inspection as Found

Process & Power

1625 East 145th Street
Little Rock, AR 72206

FolderID: 102813
FormID: 20129448

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: 733926/002

Description: 250 HP INGERSOLL RAND 2680 RPM

Hi-Speed Job Number: 102813

Manufacturer: Ingersoll-Rand

Product Number: TYPE: HPM250 SM

Spec/ID #: PART: 23271000

Serial Number: 733926/ 002

HP/kW: 250 (HP)

RPM: 2680 (RPM)

Voltage: 460

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.21

of Leads: Other

J-box Included: Complete

Coupling/Sheave: None

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: No

Shaft Machined Fit Repairs
Required: No

Bearing Housing Machined
Fit Repairs Required: Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 3 - High ● 5 - Good

Overall Condition

1. Report Date

04/22/2024

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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>Dirty</i> | | |
| Initial Mechanical/Electrical | | |
| <input checked="" type="radio"/> 5. Does Shaft Turn Freely? | | (N) 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? | | (No) No |
| 8. Assembled Shaft Runout | | Inches |
| 9. Assembled Shaft End Play | | inches |
| 10. Air Gap Variation <10% | | |
| <input checked="" type="radio"/> 11. Lead Condition | | (P) Pass |
| 12. Lead Length | | 144 Inches |
| <input checked="" type="radio"/> 13. Does it have Lugs?, If so what is the Stud Size? | | (Yes) Yes |
| 14. Lead Numbers | | 123 |
| 15. Frame Condition | | |
| <input checked="" type="radio"/> <i>Dirty</i> | | |
| 16. Fan Condition | | (N) NA |
| 17. Broken or Missing Components | | na |
| Initial Electrical Inspection | | |
| 18. Insulation Resistance/Megger | | |
| 19. Winding Resistance | | |
| 1-2 | 1-3 | 2-3 |

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| | |
|-------------------------------|---------------|
| 20. Perform Surge Test | |
| 21. Number of Stator Slots | 17 |
| 22. Stator Condition | wash and bake |
| 23. Stator Thermistors/Ohms | na |
| 24. Stator Overloads/Ohms | na |
| Mechanical Inspection | |
| 25. Drive End Bearing Brand | SkF |
| 26. Drive End Bearing Number- | 320 Nu |



| | |
|---|----------------------------|
| 27. Drive End Bearing Qty. | 1 |
| 28. Drive End Bearing Type | (Roller) Roller Bearing |
| 29. Drive End Lubrication Type | (Grease) Grease Lubricated |
| 30. Drive End Bearing Insulation or Grounding Device? | na |
| 31. Drive End Wavy Washer/Snap-Ring Other Retention Device? | wavy washer |
| 32. Drive End Bearing Condition | normal wear |



| | |
|--|----|
| 33. Opposite Drive End Bearing Brand | LS |
| 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? | na |
| 39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? | |
| Na | |
| 40. Opposite Drive End Bearing Condition | normal wear |



| | |
|-----------------------------|------------|
| 41. Drive End Seal | 110 130 12 |
| 42. Opposite Drive End Seal | na |
| Rotor Inspection | |
| 43. Rotor Type/Material | |
| Magnetic | |
| 44. Growler Test | |
| 45. Number of Rotor Bars | |



47. List the Parts needed for the Repair Below

NU 320 C3. 6320 C3

48. Signature of Technician that Disassembled Motor

RW

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

52. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

53. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.9377

3.9377

3.9377

54. Drive End Bearing Shaft Fit Condition

(P) Pass



55. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.937

3.937

3.937

DW

56. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass



57. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Pass

Mechanical Fits- Bearing Housings

58. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

8.466799999999999

8.467000000000001

8.4671

59. Drive End - Endbell Bearing Fit Condition

(F) Fail

Resleeve



60. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

8.466699999999999

8.466699999999999

8.466699999999999

61. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail

Resleeve



62. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass

pass

63. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

pass

pass

64. List Machine Work Needed Below

Both end bells need resleeved

65. Technician

RW


RW

Root Cause of Failure

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| | | | |
|---|--|--------------------|-------------|
| 66. | Failure locations <i>Bearing housing fits oversized</i> | | |
| 67. | Root cause of failure | | |
| 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 | | |
| Mechanical Fits- Bearing Housings - Post Repair | | | |
| 72. | Drive End - Endbell Bearing Fit Post Repair | | |
| | 0 Degrees | 60 Degrees | 120 Degrees |
| | 8.465199999999999 | 8.465199999999999 | 8.4651 |



| | | | |
|---|--|--------------------------------|-------------|
| 73. | Opposite Drive End - Endbell Bearing Fit Post Repair | | |
| | 0 Degrees | 60 Degrees | 120 Degrees |
| | 8.4657 | 8.4656 | 8.4657 |
| 74. | Bearing Cap Condition Post Repair | | |
| | Drive End Bearing Cap | Opposite Drive End Bearing Cap | |
| 75. | End Bell Air Seal Fits Post Repair | | |
| | Drive End Air Seal | Opposite Drive End Air Seal | |
| 76. | End Bell Repair Sign-off | | Gary |
|  | | | |
| Assembly | | | |

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77. QC Check All Parts for Cleanliness Prior to Assembly

RW

h w

78. Photograph All Major Components prior to assembly

(Complete) Complete





| | | | | |
|-----|---|------------|------------|---------|
| 79. | Final Insulation Resistance Test | | | Megohms |
| 80. | Assembled Shaft Endplay | | | inches |
| 81. | Assembled Shaft Runout | | | inches |
| 82. | Test Run Voltage | | | |
| | Volts | Volts | Volts | |
| 83. | Test Run Amperage | | | |
| | Amps | Amps | Amps | |
| 84. | Drive End Vibration Readings - Inches Per Second | | | |
| | Horizontal | Vertical | Axial | |
| 85. | Opposite Drive End Vibration Readings - Inches Per Second | | | |
| | Horizontal | Vertical | Axial | |
| 86. | Ambient Temperature - Fahrenheit | | | |
| 87. | Drive End Bearing Temps - Fahrenheit | | | |
| | 5 Minutes | 10 Minutes | 15 Minutes | |
| 88. | Opposite Drive End Bearing Temps - Fahrenheit | | | |
| | 5 Minutes | 10 Minutes | 15 Minutes | |
| 89. | Document Final Condition with Pictures after paint | | | |

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90. Final Pics and QC Review

RW

RW

Co witness: CRW



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