



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

LR Motor Shop Repairs

Job Number 103006

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

1.0

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Printed on 6/27/2024

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AC Inspection as Found

Process & Power

1625 East 145th Street
Little Rock, AR 72206

FolderID: 103006
FormID: 20476865

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: 125HP RELIANCE ELECTRIC
MOTOR EVAL

Hi-Speed Job Number: 103006

Manufacturer: Reliance

Spec/ID #: 01MIN61162

HP/kW: 125 (HP)

RPM: 1785 (RPM)

Frame: 405TDZ

Voltage: 230 / 460

Current: 300

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: DP

of Leads: 12

J-box Included: None

Coupling/Sheave: None

Date Received: 05/23/2024

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: ● 1 - High ● 8 - Good

Overall Condition

1. Report Date

05/30/2024

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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
Greasy



| Initial Mechanical/Electrical | | |
|----------------------------------|--------------------------------------------------------------------------|---------|
| <input checked="" type="radio"/> | 5. Does Shaft Turn Freely? | (Y) Yes |
| <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% | |

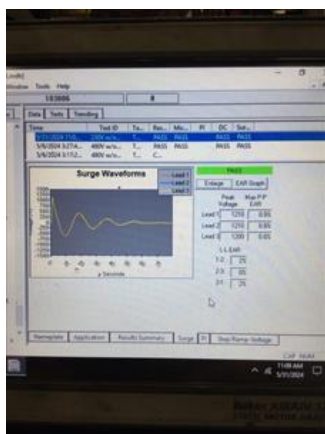
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11. Lead Condition

(P) Pass



| | | | |
|-------------------------------|--------------------------------------------------|--------------|---------|
| 12. | Lead Length | 54 Inches | |
| 13. | Does it have Lugs?, If so what is the Stud Size? | (No) No | |
| 14. | Lead Numbers | 1/12 | |
| 15. | Frame Condition | dirty | |
| 16. | Fan Condition | (N) NA | |
| 17. | Broken or Missing Components | | |
| Initial Electrical Inspection | | | |
| 18. | Insulation Resistance/Megger | 4136 Megohms | |
| 19. | Winding Resistance | | |
| | 1-2 | 1-3 | 2-3 |
| | 0.01086 | 0.01085 | 0.01085 |
| 20. | Perform Surge Test | (P) Pass | |



| | |
|----------------------------|----|
| 21. Number of Stator Slots | 72 |
|----------------------------|----|

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22. Stator Condition

very dirty



23. Stator Thermistors/Ohms

24. Stator Overloads/Ohms

Mechanical Inspection

25. Drive End Bearing Brand

NSK

26. Drive End Bearing Number-

NU316



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?

na

32. Drive End Bearing Condition

normal wear



33. Opposite Drive End Bearing Brand

NSK

34. Opposite Drive End Bearing Number-

6316



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?


40. Opposite Drive End Bearing Condition

Fatigue




41. Drive End Seal

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| | | | |
|-----------------------------------------------------------------------------------|------------|--------------------------------------------------------|--|
| 42. Opposite Drive End Seal | | | |
| Rotor Inspection | | | |
| 43. Rotor Type/Material | | (Squirrel Aluminum) Squirrel Cage Aluminum Die Cast | |
| 44. Growler Test | | (Pass) Pass | |
| 45. Number of Rotor Bars | | 47 | |
| 46. Rotor Condition | | dirty | |
| 47. List the Parts needed for the Repair Below <i>NU316 6316</i> | | | |
| 48. Signature of Technician that Disassembled Motor | | RW | |
|  | | | |
| Mechanical Fits- Rotor | | | |
| 49. Shaft Runout | | 0.0005 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 | |
| 3.1503 | 3.1503 | 3.1503 | |
| 54. Drive End Bearing Shaft Fit Condition | | (P) Pass | |
| 55. Opposite Drive End Bearing Shaft Fit | | | |
| 0 Degrees | 60 Degrees | 120 Degrees | |
| 3.1497 | 3.1497 | 3.1497 | |
| 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 | | pass | |
| Mechanical Fits- Bearing Housings | | | |
| 58. Drive End - Endbell Bearing Fit | | | |
| 0 Degrees | | 60 Degrees | 120 Degrees |
| 6.6939 | | 6.6939 | 6.6939 |
|  | 59. Drive End - Endbell Bearing Fit Condition | | (P) Pass |



| | | | |
|--------------------------------------------------------|--|------------|-------------|
| 60. Opposite Drive End - Endbell Bearing Fit | | | |
| 0 Degrees | | 60 Degrees | 120 Degrees |
| 6.6951 | | 6.6951 | 6.6951 |
| 61. Opposite Drive End - Endbell Bearing Fit Condition | | | (F) Fail |



| | |
|------------------------------------------------------------------------------------------------------------------------------|--------------------------------|
| 62. Bearing Cap Condition | |
| Drive End Bearing Cap | Opposite Drive End Bearing Cap |
| pass | |
|  | |
| 63. End Bell Air Seal Fits | |
| Drive End Air Seal | Opposite Drive End Air Seal |
| 64. List Machine Work Needed Below <i>ODE end bell bearing fit bad</i> | |
| 65. Technician | RW |
|  | |
| Co sign: CRW | |
| Root Cause of Failure | |
| 66. Failure locations <i>Ode bearing had metal fatigue.motor filled with grease and dirt</i> | |
| 67. Root cause of failure <i>Stator having low megs, Ode bearing had metal fatigue. motor filled with grease and dirt</i> | |
| Dynamic Balance Report | |
| 68. Rotor Weight and Balance Grade | |
| Rotor Weight | Balance Grade |

69. Initial Balance Readings

Drive End

Opposite Drive End

Balancing specification: Nema 6
 Item operating speed: 1785.00 RPM
 NEMA Spec: 1.50 mil
 Balancing RPM: 400.90

Balance Conditions

 Start

 Right End Mils: 0.38
 Angle: 130.74
 Left End Mils: 0.41
 Angle: 199.89

Key Used
 Drive End: 0.00 in wide x 0.00 in
 Rear End: 0.00 in wide x 0.00 in

70. Final Balance Readings

Drive End

Opposite Drive End

NEMA Spec: 1.50 mil
 Balancing RPM: 400.90

Balance Conditions

 Start

 Right End Mils: 0.38
 Angle: 130.74
 Left End Mils: 0.41
 Angle: 199.89

Key Used
 Drive End: 0.00 in wide x 0.00 in
 Rear End: 0.00 in wide x 0.00 in

71. Technician

Cw



Mechanical Fits- Bearing Housings - Post Repair

72. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees


120 Degrees

| | | |
|----------------------------------------------------------|------------|-------------|
| 73. Opposite Drive End - Endbell Bearing Fit Post Repair | | |
| 0 Degrees | 60 Degrees | 120 Degrees |
| 6.6933 | 6.6933 | 6.6934 |



| | | |
|----------------------------------------|--|--------------------------------|
| 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 | | |

Assembly

| | |
|-------------------------------------------------------------------------------------|----|
| 77. QC Check All Parts for Cleanliness Prior to Assembly | Cw |
|  | |

78. Photograph All Major Components prior to assembly



79. Final Insulation Resistance Test

Megohms

Pass

80. Assembled Shaft Endplay

inches

81. Assembled Shaft Runout

inches

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82. Test Run Voltage

Volts

Volts

Volts



83. Test Run Amperage

Amps

Amps

Amps

Witnessed by: TH



84. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.04

0.04

0.04

85. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.05

0.06

0.06

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



90. Final Pics and QC Review

Cw



Co sign: TH



STANDARD TERMS AND CONDITIONS FOR PURCHASE OF GOOD AND/OR SERVICES

1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
2. **PRICE.** All quoted prices shall remain firm and binding for a period of thirty (30) days from the date of quotation or for the period specifically stated in the quotation. The price for any and all goods and/or services ordered or approved by Buyer after thirty (30) days from the date of any quotation are subject to any increase in price that may occur after the expiration of thirty (30) days from the issuance of the quotation and the date the Buyer releases any shipment.
3. **SCOPE OF GOODS AND/OR SERVICES.** The goods and/or services provided by Hi-Speed pursuant to any quotation shall be limited exclusively to those goods and/or services expressly identified therein. Hi-Speed does not assume any responsibility and/or liability for the failure to provide any other goods and/or services not identified in any quotation. Modifications, additions or deletions to or from the scope referenced in any quotation shall only be effective if evidenced in writing and signed by Hi-Speed. The sale of any of all goods and/or services affected by such modification, addition or deletion shall be subject to these same Standard Terms and Conditions whether or not referenced therein.
4. **BILLING AND PAYMENT TERMS.** Hi-Speed shall invoice Buyer for all goods and/or services as same are rendered at the address listed on the quotation. Payments for all goods and/or services shall be due thirty (30) days from the date of the current invoice or as otherwise set forth in the quotation. Late payments are subject to a late fee of 5% of the total invoice amount. Recurring late payments may lead to a deposit requirement on future services or sale of goods. Buyer shall be liable to Hi-Speed for any and all fees and expenses incurred by Hi-Speed to collect any invoices or to enforce these Standard Terms and Conditions, including but not limited to, attorney's fees.
5. **DELIVERY OF GOODS AND/OR SERVICES.** Unless otherwise identified in the quotation, all shipments are F.O.B. Hi-Speed's warehouse and the title to and all risk of loss with respect to any goods shipped shall pass to Buyer when such goods are delivered to the carrier at Hi-Speed's warehouse. Hi-Speed will use its best efforts to affect delivery by the date or dates specified in the quotation. However, Hi-Speed shall not be liable for delay in or failure to make shipment, or to perform services, by any identified date for any reason whatsoever, including but not limited to, causes beyond its reasonable control, such as strikes, fires, floods, epidemics, quarantines, restrictions, severe weather, embargos, acts of God, or public enemy, war, riot, delays in transportation or the inability to obtain necessary labor, materials or manufacturing facilities.
6. **DELIVERY SITE AND TIME FOR PERFORMANCE.** Hi-Speed and Buyer agree that time is of the essence for the purchase order and that Buyer shall fully cooperate with Hi-Speed in order to allow Hi-Speed full access to prosecute its work diligently and in an orderly manner. Buyer shall assist Hi-Speed in every way possible to avoid delaying, disrupting or interfering with the progress of Hi-Speed's work at the project site. In the event Hi-Speed's work is delayed, hindered, suspended, disrupted, re-sequenced or interfered with or rendered less efficient or more costly or adversely affected in any way as a result of acts or omissions of Buyer or other contractors or employees of Buyer or by any other reason beyond Hi-Speed's control and without the fault of Hi-Speed, then, in such event, Buyer shall be liable to Hi-Speed for any damages, additional costs, expenses, labor, materials, man hours, acceleration costs, overtime, additional jobsite overhead, extended home office overhead, and any and all other direct and indirect expenses of whatsoever nature or kind, caused in whole or in part, as a result of any of the above-referenced occurrences. Hi-Speed's project records will be the basis for computing the additional costs and damages of Hi-Speed's labor, materials, expenses and overhead related to such changes. BUYER WARRANTS THAT THE SITE FOR DELIVERY OR INSTALLATION OF ANY GOODS AND/OR FOR THE PERFORMANCE OF ANY SERVICES SHALL BE READY AND ADEQUATE FOR HI-SPEED'S DELIVERY OF GOODS AND/OR PERFORMANCE OF SERVICES AND THAT HI-SPEED SHALL HAVE FULL ACCESS THERETO, FREE OF ALL OBSTRUCTIONS. BUYER SHALL ASSUME ALL EXTRA COSTS ASSOCIATED WITH HI-SPEED'S INABILITY TO INSTALL ANY GOODS OR PERFORM ANY SERVICES AS A RESULT OF BUYER'S FAILURE TO COMPLY WITH THIS PROVISION. HI-SPEED MAY NOT INSPECT THE SITE PRIOR TO DELIVERY AND/OR INSTALLATION OF GOODS AND/OR PERFORMANCE OF SERVICES AND MAKES NO WARRANTY AS TO THE SUFFICIENCY OF THE SITE FOR THE DELIVERY AND/OR INSTALLATION OF GOODS AND/OR THE PERFORMANCE OF SERVICES AT SUCH SITE.
7. **INSPECTION/ACCEPTANCE.** All goods and services ordered pursuant to any quotation shall be subject to inspection by Buyer after delivery or performance to determine conformity with the quotation and/or purchase order and Hi-Speed's advertised or published specifications. Buyer shall have a period of thirty (30) days from shipment of goods at the delivery destination specified in the quotation within which to inspect the goods for conformity with the quotation, order and/or Hi-Speed's advertised and published specifications and to provide Hi-Speed with written notice of any discrepancy or rejection. Buyer shall have a period of thirty (30) days following completion of any services within which to inspect the services for conformity with the quotation, purchase order and/or Hi-Speed's advertised and published specifications and to provide Hi-Speed with written notice of any discrepancy or rejection. If the goods delivered or services performed do not so conform, upon delivery of notice to Hi-Speed of any discrepancy, nonconformance or rejection, Hi-Speed shall have sixty (60) days to cure the alleged discrepancy and/or nonconformance. If Hi-Speed fails to cure in this time period, Buyer shall have the right to reject such goods or services. After the cure period, goods that have been delivered and rejected, in whole or in part, shall be returned to Hi-Speed. Buyer shall notify Hi-Speed and arrange for the return of the goods as required. Should such non-conforming services be rejected Hi-Speed shall, at its sole cost, re-perform the non-conforming services. Inspection or failure to inspect on any occasion shall not affect Buyer's rights under the warranty provisions herein.
8. **WARRANTIES.** Hi-Speed warrants that all goods shall conform in all material aspects to the goods identified in the quotation to Buyer and/or purchase order, and Hi-Speed makes to Buyer the manufacturer's express warranty for any goods sold to Buyer, which is offered by the manufacturer at the time of acceptance of any quotation by Buyer. This warranty is conditioned upon the installation, operation, and maintenance of the goods in accordance with the manufacturer's recommendations and/or standard industry practice and the goods at all times being operated or used under normal operating conditions for which they were designed. Hi-Speed, at its sole option, will repair or

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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.
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.