



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

LR Motor Shop Repairs

Job Number 103042

Prepared for PRODUCERS RICE STUTTGART

603 N. PARK AVE
STUTTGART AR 72160

Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *WAA127255*

1.0

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Hi-Speed Industrial Service
7030 Ryburn Dr
Millington, Tn 38053
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AC Inspection as Found
PRODUCERS RICE STUTTGART
603 N. PARK AVE
STUTTGART, AR 72160

FolderID: 103042
FormID: 20521950

AC Inspection - Rev. 2

Location: MOTOR SHOP LR
Serial Number: WAA127255
Description: 500HP Marathon 2800RPM

| | |
|---|--------------------|
| Hi-Speed Job Number: | 103042 |
| Manufacturer: | Marathon |
| Product Number: | VN5011LHFS16049AAW |
| Spec/ID #: | TYPE: TFS |
| Serial Number: | WAA127255 |
| HP/kW: | 500 (HP) |
| RPM: | 2800 (RPM) |
| Frame: | 5011L |
| Voltage: | 460 |
| Current: | 555 (Amps) |
| Phase: | Three |
| Hz: | 60 (Hz) |
| Service Factor: | 1.00 |
| Enclosure: | TEFC |
| # of Leads: | 12 |
| J-box Included: | None |
| Coupling/Sheave: | None |
| Date Received: | 05/09/2024 |
| 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: 2 - High 9 - Good

Overall Condition

| | |
|----------------|------------|
| 1. Report Date | 06/03/2024 |
|----------------|------------|

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2. Nameplate Picture



3. Photos of all six sides of the machine.





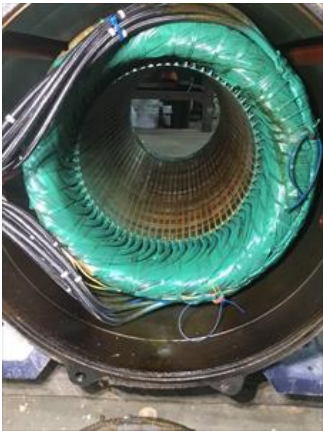
P1 & P2



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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 | 0.001 Inches |
| 9. Assembled Shaft End Play | 0 inches |
| 10. Air Gap Variation <10% | |
| 11. Lead Condition | (P) Pass |



| | |
|--|-------------|
| 12. Lead Length | 15.5 Inches |
| 13. Does it have Lugs?, If so what is the Stud Size? | (Yes) Yes |
| 14. Lead Numbers | 1, 2, 3 |
| 15. Frame Condition | pass |
| 16. Fan Condition | (N) NA |

tac mount bracket



Megohms



1.7

19. Winding Resistance

1-2

1-3

2-3

| Test ID | Test Name | Test Date | Test Time | Test Result |
|---------|--------------------|-----------|-------------|-------------|
| 14 | Winding Resistance | 5/15/2024 | 11:45:00 AM | PASS |
| 14 | Winding Resistance | 5/16/2024 | 11:45:00 AM | PASS |

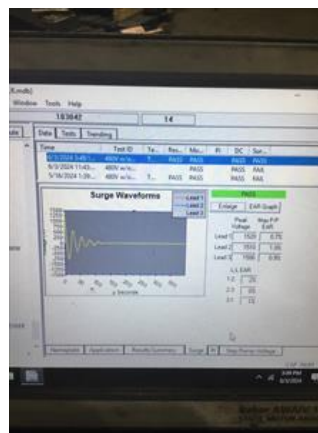
| Test ID | Test Name | Test Date | Test Time | Test Result |
|---------|--------------------|-----------|-------------|-------------|
| 14 | Winding Resistance | 5/15/2024 | 11:45:00 AM | PASS |
| 14 | Winding Resistance | 5/16/2024 | 11:45:00 AM | PASS |

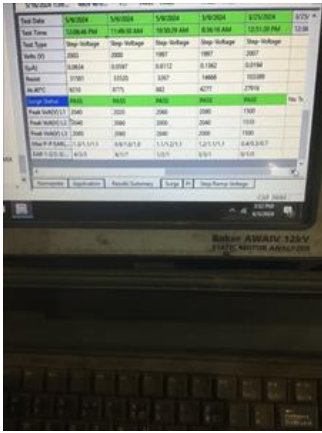
| Test ID | Test Name | Test Date | Test Time | Test Result |
|---------|--------------------|-----------|-------------|-------------|
| 14 | Winding Resistance | 5/15/2024 | 11:45:00 AM | PASS |
| 14 | Winding Resistance | 5/16/2024 | 11:45:00 AM | PASS |

20. Perform Surge Test

(P) Pass

| Test ID | Test Name | Test Date | Test Time | Test Result |
|---------|------------|-----------|-------------|-------------|
| 14 | Surge Test | 5/15/2024 | 11:45:00 AM | PASS |
| 14 | Surge Test | 5/16/2024 | 11:45:00 AM | PASS |





| | |
|-----------------------------|------|
| 21. Number of Stator Slots | 72 |
| 22. Stator Condition | pass |
| 23. Stator Thermistors/Ohms | |



| | |
|------------------------------|-----|
| 24. Stator Overloads/Ohms | |
| Mechanical Inspection | |
| 25. Drive End Bearing Brand | FAG |

26. Drive End Bearing Number-

6324 M/C3 VL0241



| | |
|---|----------------------------|
| 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? | grounding brush |
| 31. Drive End Wavy Washer/Snap-Ring Other Retention Device? | none |
| 32. Drive End Bearing Condition | replace |
| 33. Opposite Drive End Bearing Brand | FAG |
| 34. Opposite Drive End Bearing Number- | 6318 M/C3 VL0241 |



35. Opposite Drive End Bearing Qty.

1

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| | |
|--|-----------------------------------|
| 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 | 9000-A-16968-0 |



42. Opposite Drive End Seal

 *Replace o-rings*



Rotor Inspection

43. Rotor Type/Material

(Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast

44. Growler Test (Pass) Pass

45. Number of Rotor Bars 55

46. Rotor Condition pass

47. List the Parts needed for the Repair Below

Replace bearings & sleeve both housing fits. Opposite drive end fit needs to be insulated and opposite driven bearing needs to be a hybrid insulated bearing. Replace broken tach mounting bracket. Install aegis grounding ring internally on drive end bearing cap.

48. Signature of Technician that Disassembled Motor Terrence Holland

Mechanical Fits- Rotor

49. Shaft Runout 0.002 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

4.7257

4.7258

4.7258

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

55. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.5435

3.5436

3.5437

56. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

57. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

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Mechanical Fits- Bearing Housings

58. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

10.2382

10.238

10.2382

59. Drive End - Endbell Bearing Fit Condition

(F) Fail

Out of tolerance. Max allowed is 10.2375

60. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

7.4822

7.4821

7.4823

61. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail

Max allowed is 7.4814

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

64. List Machine Work Needed Below

Sleeve both housing fits. ODE housing fit needs to be insulated.

65. Technician

Terrence Holland



Witness: ROW

Root Cause of Failure

66. Failure locations

Both housing fits out of tolerance. Replace broken tach mount bracket.

67. Root cause of failure

D.E shaft grounding brush was worn and had minimal contact with shaft. Both bearings showed signs of frosting from electrical discharge to ground causing the blackened grease to lose its lubrication qualities.



Dynamic Balance Report

68. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



69. Initial Balance Readings


Drive End

Opposite Drive End

0.03

0.08

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| | | | |
|---|--|--------------------|----------------|
| 70. Final Balance Readings | | | |
| Drive End | | Opposite Drive End | |
| 0.03 | | 0.08 | |
| 71. Technician | | | SC |
|  | | | |
| Mechanical Fits- Bearing Housings - Post Repair | | | |
| 72. Drive End - Endbell Bearing Fit Post Repair | | | |
| 0 Degrees | | 60 Degrees | 120 Degrees |
| 10.2366 | | 10.2366 | 10.2367 |



| | | | |
|--|--|---------------|---------------|
| 73. Opposite Drive End - Endbell Bearing Fit Post Repair | | | |
| 0 Degrees | | 60 Degrees | 120 Degrees |
| 7.4812 | | 7.4812 | 7.4812 |



74. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Installed Agis ring on D.E. 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

77. QC Check All Parts for Cleanliness Prior to Assembly

RW

AW

78. Photograph All Major Components prior to assembly

(Complete) Complete



79. Final Insulation Resistance Test

7000 Megohms



| | | |
|-----------------------------|---------------|-------|
| 80. Assembled Shaft Endplay | inches | |
| 81. Assembled Shaft Runout | 0.0003 inches | |
| 82. Test Run Voltage | | |
| Volts | Volts | Volts |
| 454 | 454 | 457 |



Co witness CRW

| | | |
|-----------------------|-------|------|
| 83. Test Run Amperage | | |
| Amps | Amps | Amps |
| 160.1 | 154.1 | 156 |



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| | | |
|---|-------------|-----------------------------|
| 84. Drive End Vibration Readings - Inches Per Second | | |
| Horizontal | Vertical | Axial |
| 0.01 | 0.05 | 0.01 |
| 85. Opposite Drive End Vibration Readings - Inches Per Second | | |
| Horizontal | Vertical | Axial |
| 0.05 | 0.08 | 0.008999999999999999 |
| 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

RW

A handwritten signature in black ink, consisting of a stylized 'C' and 'R' followed by a 'W'.

Co sign: CRW



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