



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

LR Motor Shop Repairs

Job Number 102417

Prepared for Searcy Water and Sewer System (11242)

300 N. Elm Street
Searcy AR 72145

Table of Contents



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

AC Inspection as Found
Searcy Water and Sewer System (11242)
300 N. Elm Street
Searcy, AR 72145

FolderID: 102417
FormID: 19224722

AC Inspection - Rev. 2

Completed by: Motor Shop LR 3 on 04/22/2024

Location: MOTOR SHOP LR

Serial Number:

Description: 40 HP AERATOR

Hi-Speed Job Number: 102417

Manufacturer: Reliance

Spec/ID #: 6835071-1

Serial Number: L002FH

HP/kW: 40 (HP)

RPM: 1180 (RPM)

Frame: 364LPZ

Current: 49.4

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

of Leads: 3

J-box Included: Half

Coupling/Sheave: Propeller

Date Received: 02/01/2024

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: 3 - High 6 - Good

Overall Condition

1. Report Date

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1.0

2. Nameplate Picture



3. Photos of all six sides of the machine.







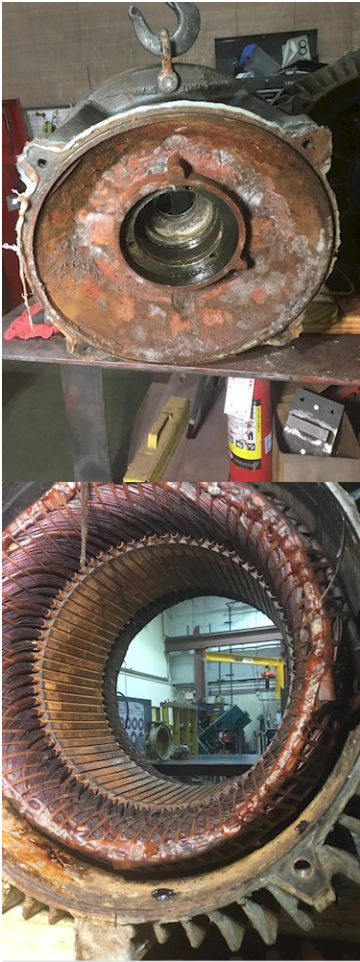
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1.3





4.	Describe the Overall Condition of the Equipment as Received	
	<i>Dirty</i>	
5.	Distance from the end of the shaft to the Coupling/Sheave	inches
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	
	<input checked="" type="checkbox"/> Yes.	
7.	Does the shaft require T.I.R in Lathe to identify additional repairs?	
8.	Does Shaft Have Visible Damage?	(Yes) Yes
<input checked="" type="radio"/> 9.	Assembled Shaft Runout	0.003 Inches
10.	Assembled Shaft End Play	inches
11.	Air Gap Variation <10%	

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12. Lead Condition



13. Lead Length **15.75 Inches**

14. Lead Numbers **1-3**

15. Frame Condition **pass**

● 16. Fan Condition **(P) Pass**

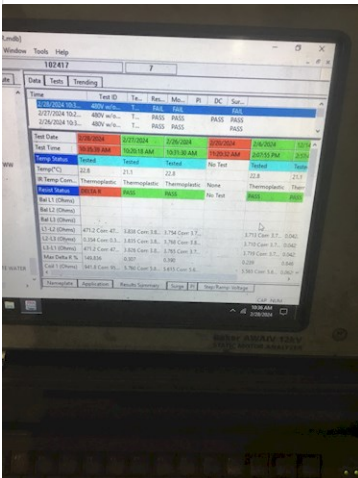


17. Broken or Missing Components **connection box top cover missing**

● 18. Does it have Lugs?, If so what is the Stud Size? **(No) No**

Initial Electrical Inspection

19. Insulation Resistance/Megger **Megohms**



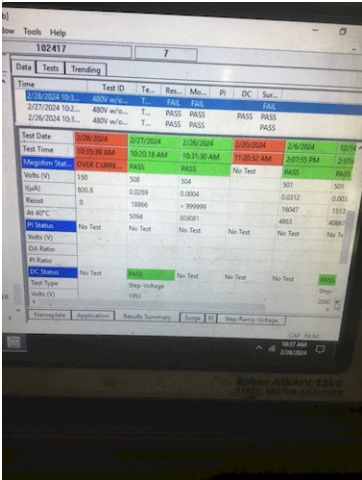
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20. Winding Resistance

1-2

1-3

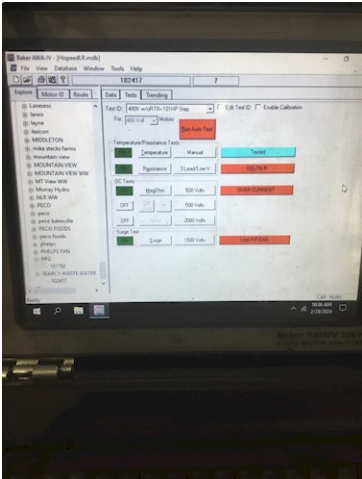
2-3



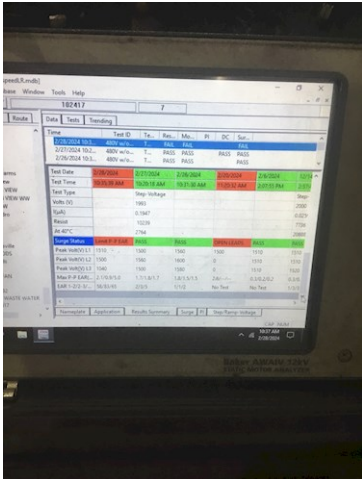
Test Date	Test Time	Test ID	Test Name	Test Result
2/26/2024	10:18 AM	102417	Winding Resistance	PASS
2/27/2024	10:18 AM	102418	Winding Resistance	PASS
2/28/2024	10:18 AM	102419	Winding Resistance	PASS

21. Perform Surge Test

(F) Fail



Test Date	Test Time	Test ID	Test Name	Test Result
2/26/2024	10:18 AM	102417	Perform Surge Test	FAIL
2/27/2024	10:18 AM	102418	Perform Surge Test	FAIL
2/28/2024	10:18 AM	102419	Perform Surge Test	FAIL



Test Date	Test Time	Test ID	Test Name	Test Result
2/26/2024	10:18 AM	102417	Perform Surge Test	FAIL
2/27/2024	10:18 AM	102418	Perform Surge Test	FAIL
2/28/2024	10:18 AM	102419	Perform Surge Test	FAIL

22. Number of Stator Slots

72

23. Stator Condition

rusted internally

24. Stator Thermistors/Ohms

25. Stator Overloads/Ohms

Mechanical Inspection

26. Drive End Bearing Brand

SKF

27. Drive End Bearing Number-

3215 A/C3

Double wide double row.



28. Drive End Bearing Qty.

1

29. Drive End Bearing Type

(Ball) Ball Bearing

30. Drive End Lubrication Type

(Grease) Grease Lubricated

31. Drive End Bearing Insulation or Grounding Device?

none

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

none

33. Drive End Bearing Condition

replace

34. Opposite Drive End Bearing Brand

FAG

35. Opposite Drive End Bearing Number-

6313 2Z - C3



36. Opposite Drive End Bearing Qty.

1

37. Opposite Drive End Bearing Type

(Ball) Ball Bearing

38. Opposite Drive End Lubrication Type

(Grease) Grease Lubricated

39. Opposite Drive End Bearing Insulation or Grounding Device?

none

40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?

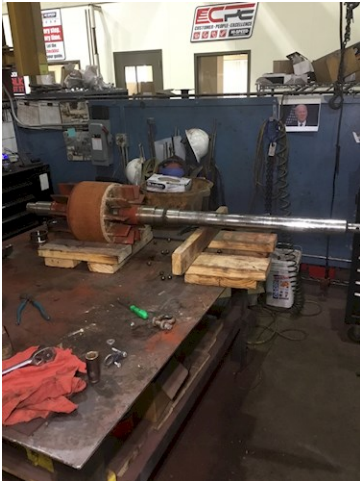
wavy washer



41. Opposite Drive End Bearing Condition	replace
42. Drive End Seal	in pro seal
43. Opposite Drive End Seal	dust seal

Rotor Inspection

44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
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45. Growler Test	(Pass) Pass
46. Number of Rotor Bars	58
47. Rotor Condition	pass
48. List the Parts needed for the Repair Below	
49. Signature of Technician that Disassembled Motor	Terrence Holland



Mechanical Fits- Rotor

50. Shaft Runout	0.002 inches	
51. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

52.	Coupling Fit Closest to Bearing Housing		
	0 Degrees	90 Degrees	120 Degrees
53.	Coupling Fit Closest to the end of the Shaft		
	0 Degrees	60 Degrees	120 Degrees
54.	Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	2.9532	2.9533	2.9531
55.	Drive End Bearing Shaft Fit Condition		(P) Pass
56.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	2.559	2.5591	2.5592
57.	Opposite Drive End Bearing Shaft Fit Condition		(P) Pass
58.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings			
59.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	Bad, has excessive wear.		
	<div><div></div><div></div></div>		
60.	Drive End - Endbell Bearing Fit Condition		(F) Fail
61.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	5.5126	5.1125	5.5126
62.	Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass

63. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap
pass



64. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

65. List Machine Work Needed Below

Shaft seal surface worn. Drill and tap multiple ode housing fan cover mount bolt holes.

66. Technician

Terrence Holland

Root Cause of Failure

67. Failure locations

Windings shorted to ground due to excessive amount of water penetration.

68. Root cause of failure
Water in housing.



Dynamic Balance Report

69. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade
--------------	---------------

70. Initial Balance Readings

Drive End	Opposite Drive End
0.25	0.30



71. Final Balance Readings

Drive End

Opposite Drive End

72. Technician

RW



Rewind

73. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

Na

74. Core Hot Spot Test

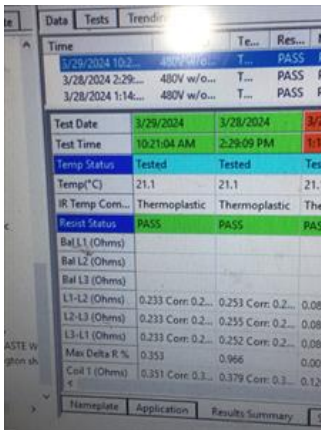
Pre-Burnout

Post-Burnout

Na

75. Post Rewind Electrical Test- Insulation Resistance

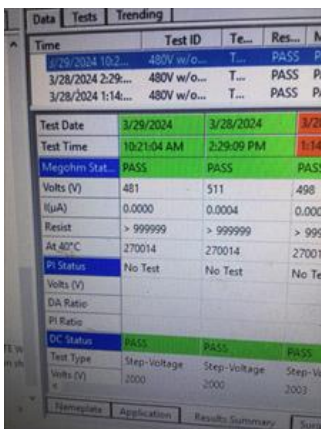
Megohms



Data	Tests	Trending
Time	3/29/2024 10:2...	3/28/2024 2:29...
Test Date	3/29/2024	3/28/2024
Test Time	10:21:04 AM	2:29:09 PM
Temp Status	Tested	Tested
Temp (°C)	21.1	21.1
IR Temp Com...	Thermoplastic	Thermoplastic
Resist Status	PASS	PASS
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.233 Corr: 0.2...	0.253 Corr: 0.2...
L2-L3 (Ohms)	0.233 Corr: 0.2...	0.255 Corr: 0.2...
L3-L1 (Ohms)	0.233 Corr: 0.2...	0.252 Corr: 0.2...
Max Delta R %	0.353	0.966
Coil T (Ohms)	0.331 Corr: 0.3...	0.379 Corr: 0.3...

76. Post Rewind Polarization Index

Polarization Index



Data	Tests	Trending
Time	3/29/2024 10:2...	3/28/2024 2:29...
Test ID	480V w/o...	480V w/o...
Test Date	3/29/2024	3/28/2024
Test Time	10:21:04 AM	2:29:09 PM
Megohm Stat.	PASS	PASS
Volts (V)	481	511
II (uA)	0.0000	0.0004
Resist	> 999999	> 999999
At 40°C	270014	270014
PI Status	No Test	No Test
Volts (V)		
DA Ratio		
PI Ratio		
DC Status	PASS	PASS
Test Type	Step-voltage	Step-voltage
Volts (V)	2000	2000

77. Post Rewind Winding Resistance

1-2

1-3

2-3

Date	Tests	Trending
3/28/2024 10:2	480V w/o...	T...
3/28/2024 2:29...	480V w/o...	T...
3/28/2024 1:14...	480V w/o...	T...
Test Date	3/28/2024	3/28/2024
Test Time	10:21:04 AM	2:29:09 PM
Result Status	PASS	PASS
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.233 Corr: 0.2...	0.253 Corr: 0.2...
L2-L3 (Ohms)	0.233 Corr: 0.2...	0.255 Corr: 0.2...
L3-L1 (Ohms)	0.233 Corr: 0.2...	0.252 Corr: 0.2...
Max Delta R %	0.353	0.966
Coil 1 (Ohms)	0.351 Corr: 0.3...	0.379 Corr: 0.3...
Coil 2 (Ohms)	0.349 Corr: 0.3...	0.384 Corr: 0.3...
Coil 3 (Ohms)	0.348 Corr: 0.3...	0.376 Corr: 0.3...
Max Delta R %	PASS	PASS

78. Post Rewind Surge Test

(Pass) Pass

Date	Tests	Trending
3/28/2024 10:2	480V w/o...	T...
3/28/2024 2:29...	480V w/o...	T...
3/28/2024 1:14...	480V w/o...	T...
Test Date	3/28/2024	3/28/2024
Test Time	10:21:04 AM	2:29:09 PM
Test Type	Step-Voltage	Step-Voltage
Volts (V)	2000	2000
I (uA)	0.0326	0.0334
Resist	61421	59939
Alt. 40°C	16584	16184
Surge Status	PASS	PASS
Peak Volt(V) L1	2000	2000
Peak Volt(V) L2	2000	2000
Peak Volt(V) L3	2000	2000
Max P-P EARI...	0.6/0.4/0.5	0.4/0.7/0.4
EARI 1-2/2-3/...	3/1/4	3/2/0

79. Post Rewind Hi-Pot

micro-amps

Na

80. Technician

Na

Mechanical Fits- Rotor - Post Repair

81. Shaft Runout Post Repair

0.002 inches

82. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0.001

0.002

0.001

83. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

84. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

85. Drive End Bearing Shaft Fit Post Repair

0 Degrees



60 Degrees

120 Degrees

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86. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
87. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
2.5		
Teflon bushing shaft fit.		



88. Shaft Repair Sign-off	Gary		
			
Mechanical Fits- Bearing Housings - Post Repair			
89. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
5.119	5.119	5.119	
90. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
91. Bearing Cap Condition Post Repair			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
92. End Bell Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
93. End Bell Repair Sign-off	RW		
			
Assembly			

94. QC Check All Parts for Cleanliness Prior to Assembly

RW

RL

95. Photograph All Major Components prior to assembly

(Complete) Complete



96. Final Insulation Resistance Test

Megohms

High Pot passed

97. Assembled Shaft Endplay

inches

Na

98. Assembled Shaft Runout

inches

99. Test Run Voltage

Volts

456

Volts

457

Volts

457



Assemble co witness TRH

100. Test Run Amperage

Amps

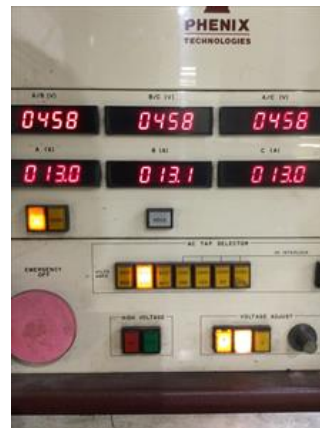
12.8

Amps

12.9

Amps

13.2



Assemble with impeller .co witness TRH

101. Drive End Vibration Readings - Inches Per Second

Horizontal

0.05

Vertical

0.05

Axial

0.05

102. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

0.05

Vertical

0.05

Axial

0.02

103. Ambient Temperature - Fahrenheit

NA

104. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

NA

105. Opposite Drive End Bearing Temps - Fahrenheit			
	5 Minutes	10 Minutes	15 Minutes
<div> <div></div> <div>NA</div> </div>			
106. Document Final Condition with Pictures after paint			



107. Final Pics and QC Review			RW
<div> <div></div> <div> <div></div> <div> <div></div> <div> <div></div> <div></div> </div> </div> </div> </div>			
<div> <div></div> <div>Co witness TRH</div> </div>			



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9. **LIMITATION OF DAMAGES.** HI-SPEED SHALL HAVE NO LIABILITY TO BUYER WITH RESPECT TO THE SALE OR DELIVERY OF ANY GOODS OR THE REPAIR THEREOF OR WITH RESPECT TO THE SALE OR PERFORMANCE OF ANY SERVICES, FOR LOST PROFITS, SPECIAL, CONSEQUENTIAL, EXEMPLARY, PUNITIVE OR INCIDENTAL DAMAGES OF ANY KIND OR NATURE WHETHER ARISING IN CONTRACT, TORT, GOODS LIABILITY OR OTHERWISE, EVEN IF HI-SPEED WAS ADVISED OF THE POSSIBILITY OF SUCH LOSS OR DAMAGES. HI-SPEED SHALL NOT BE LIABLE FOR ANY DAMAGES OR DELAYS CAUSED BY ANY FAILURE TO MAKE ANY DELIVERY OF GOODS BY ANY EXPECTED TIME OR DATE OR THE FAILURE TO PROVIDE OR COMPLETE ANY SERVICES BY ANY EXPECTED DATE OR TIME. IN NO EVENT SHALL HI-SPEED BE LIABLE TO BUYER FOR ANY DAMAGES WHATSOEVER IN EXCESS OF THE TOTAL PRICE PAID FOR ALL GOODS AND/OR SERVICES HEREUNDER OR REFERENCED IN ANY QUOTATION OR THE PURCHASE ORDER.
10. **SEVERABILITY.** The partial or complete invalidity of any provision of these Standard Terms and Conditions shall not affect the enforceability of the remainder of these Standard Terms and Conditions. If any provision is found to be invalid or unenforceable, that portion shall be modified to make it enforceable or shall be stricken and the remainder of these Standard Terms and Conditions shall enforced.
11. **GOVERNING LAW AND JURISDICTION.** Any controversy arising out of any quotation, the purchase order, the goods sold or delivered, repair or replacement thereof, or any services provided pursuant to any quotation or any purchase order, or these Standard Terms and Conditions shall be governed by the laws of the state of Tennessee without regard to any choice of law provisions and any cause of action related in any manner thereto shall be brought only in the state or federal courts of Shelby County, Tennessee.
12. **ABANDONED EQUIPMENT.** Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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.