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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 103064

Prepared for TECO-Westinghouse Motors.Inc-Warranty Dept

5100 N I-H 35
Round Rock TX 78680

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AC Inspection as Found - *LR MOTOR SHOP*

AC Inspection - Rev. 2: *NJE9231612001*

1.0

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Millington, Tn 38053
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AC Inspection as Found
TECO-Westinghouse Motors.Inc-Warranty Dept
5100 N I-H 35
Round Rock, TX 78680

FolderID: 103064
FormID: 20562460

AC Inspection - Rev. 2

Location: LR MOTOR SHOP
Serial Number: NJE9231612001
Description:400HP TECO WARRANTY EVAL

Hi-Speed Job Number:	103064
Manufacturer:	TECO Westinghouse
Product Number:	EPS4004
Serial Number:	NJE9231612001
HP/kW:	400 (HP)
RPM:	1788 (RPM)
Frame:	447T
Voltage:	460
Current:	433A
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TEFC
# of Leads:	12
J-box Included:	Half
Coupling/Sheave:	None
Date Received:	06/03/2024
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	No
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: ● **7 - High** ● **6 - Good**

Overall Condition

1. Report Date

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4. Describe the Overall Condition of the Equipment as Received

Dirty

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
<input type="text"/>	<i>Na</i>	
	9. Assembled Shaft End Play	inches
<input type="text"/>	<i>Na</i>	
	10. Air Gap Variation <10%	
<input type="text"/>	<i>Na</i>	
<input checked="" type="radio"/>	11. Lead Condition	(P) Pass
	12. Lead Length	14 Inches
<input checked="" type="radio"/>	13. Does it have Lugs?, If so what is the Stud Size?	
<input type="text"/>	<i>Yes</i>	
	14. Lead Numbers	T1-T1/T2-T2/T3-T3/T4-T4/T5-T5/T6-T6
	15. Frame Condition	pass
<input checked="" type="radio"/>	16. Fan Condition	(F) Fail



17. Broken or Missing Components

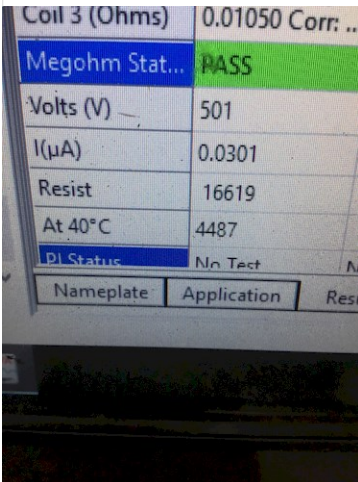
fan

Initial Electrical Inspection

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18. Insulation Resistance/Megger

Megohms

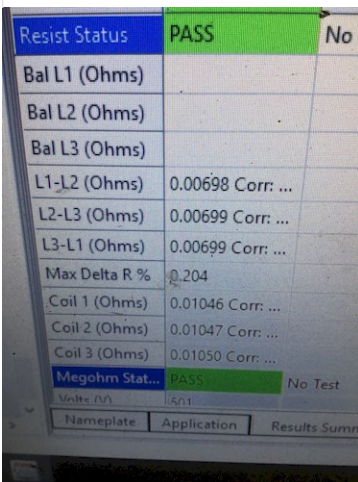


19. Winding Resistance

1-2

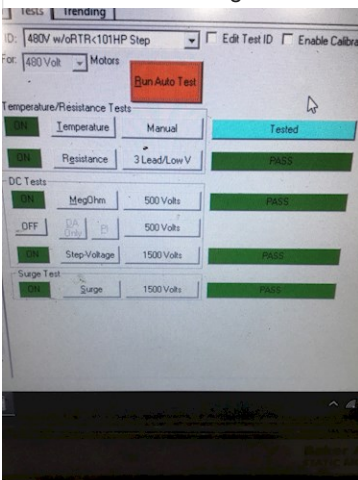
1-3

2-3



20. Perform Surge Test

(P) Pass



21. Number of Stator Slots

Na

22. Stator Condition

pass

23. Stator Thermistors/Ohms

Na

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24. Stator Overloads/Ohms	
Na	
Mechanical Inspection	
25. Drive End Bearing Brand	SKF
26. Drive End Bearing Number-	6320
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?	
Na	
31. Drive End Wavy Washer/Snap-Ring Other Retention Device?	
Na	
32. Drive End Bearing Condition	signs of axial load and fluting



33. Opposite Drive End Bearing Brand	
Na	
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?	na
40. Opposite Drive End Bearing Condition	bearing cage failed



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41. Drive End Seal	labyrinth		
42. Opposite Drive End Seal	labyrinth		
Rotor Inspection			
43. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast		
44. Growler Test	(Pass) Pass		
45. Number of Rotor Bars	Na		
46. Rotor Condition	Pass		
<div> ● 47. List the Parts needed for the Repair Below <div> 6320 6316 New fan 6316 sleeve for ODE end bell bearing fit 6320 sleeve for DE end bell bearing fit </div> </div>			
48. Signature of Technician that Disassembled Motor			Cw
Mechanical Fits- Rotor			
49. Shaft Runout	inches		
Na			
50. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
Na			
51. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
Na			
52. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
Na			
53. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
3.9376	3.9377	3.9376	
54. Drive End Bearing Shaft Fit Condition	(P) Pass		
55. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
Inner Race welded to shaft			
56. Opposite Drive End Bearing Shaft Fit Condition	(F) Fail		
57. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Na			

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Mechanical Fits- Bearing Housings

58. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

8.4674

8.4672

8.4673

59. Drive End - Endbell Bearing Fit Condition (F) Fail

60. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

Excessive lip worn into fit

61. Opposite Drive End - Endbell Bearing Fit Condition (F) Fail

62. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

ODE inner bearing cap may need sleeved

63. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

64. List Machine Work Needed Below

DE end bell bearing fit

ODE shaft and end bell bearing fits need machined

Possibly ODE inner bearing cap

Slinger seal needs replaced or repaired

65. Technician

Cw

Co sign: Dwm

Root Cause of Failure

66. Failure locations

ODE bearing and ODE bearing fits

67. Root cause of failure

Power supply leads distance from VFD to motor without load reactor causing shaft currents, no aegis ring, or insulated bearing, and bearing have fluting in them from shaft currents off of the VFD.

Dynamic Balance Report

68. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



69. Initial Balance Readings

Drive End

Opposite Drive End

1.04**1.10**

70. Final Balance Readings

Drive End

Opposite Drive End

.4**.33**

71. Technician

RW**Mechanical Fits- Rotor - Post Repair**

72. Shaft Runout Post Repair

0.001 inches

73. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0.002**0.001****0.001**

74. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

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

0 Degrees

60 Degrees

120 Degrees

76. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

77. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

Welded bearing fit to repair .035" runout and shaft damage



78. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal



79. Shaft Repair Sign-off

Gary

A handwritten signature in black ink, appearing to be 'Gary', written on a white background.

Mechanical Fits- Bearing Housings - Post Repair

80. Drive End - Endbell Bearing Fit Post Repair

0 Degrees	60 Degrees	120 Degrees
8.465	8.4649	8.4649



81. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees	60 Degrees	120 Degrees
6.6935	6.6935	6.6934



82. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap



Sleeved o.d.e. Inner bearing cap.

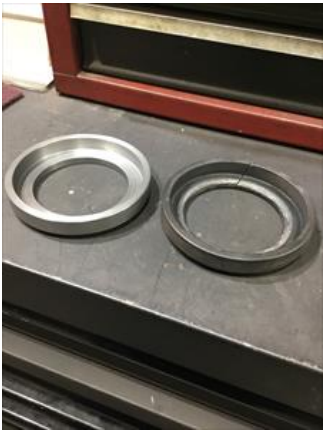
Sleeved o.d.e. outer bearing cap

83. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

 *Machined new labyrinth seal.*



84. End Bell Repair Sign-off

GM



Assembly

85. QC Check All Parts for Cleanliness Prior to Assembly

RW



86. Photograph All Major Components prior to assembly

(Complete) Complete



87. Final Insulation Resistance Test

Megohms

Pass hi pot

88. Assembled Shaft Endplay

inches

Na

89. Assembled Shaft Runout

0.0004 inches

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90. Test Run Voltage		
Volts	Volts	Volts
456	455	459



Co witness TRH

91. Test Run Amperage		
Amps	Amps	Amps
127.1	118.2	121



92. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
93. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
94. Ambient Temperature - Fahrenheit		
95. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
96. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
97. Document Final Condition with Pictures after paint		

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98. Final Pics and QC Review

RW

h w

Co witness TRH

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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.
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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.
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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

replace any defective or non-conforming goods in accordance with the applicable manufacturer's warranty. Warranty for any defective or incorrect parts is limited to the repair or replacement of those parts. Hi-Speed warrants that all services will conform in all material respects to the description of services identified in the quotation and will be performed in a good and workmanlike manner in accordance with industry practices and standards. Should the services be reasonably rejected or not conform with the foregoing warranties, Hi-Speed shall, at its sole cost, re-perform the defective or nonconforming services. Notwithstanding the foregoing, these warranties do not extend to goods or services to the extent that such goods have been subject to misuse, neglect or abuse not caused by Hi-Speed or have been used in violation of the approved written instructions furnished to Buyer. THE FOREGOING REPRESENTS THE SOLE AND EXCLUSIVE WARRANTY GIVEN BY HI-SPEED WITH RESPECT TO ALL GOODS SOLD AND IS IN LIEU OF ALL OTHER WARRANTIES EITHER EXPRESS OR IMPLIED. HI-SPEED EXPRESSLY DISCLAIMS ALL OTHER WARRANTIES INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR USE OR PURPOSE. BUYER WAIVES ANY CLAIM THAT THESE EXCLUSIONS OR LIMITATIONS DEPRIVE IT OF AN ADEQUATE REMEDY AT EQUITY OR LAW OR CAUSE THIS AGREEMENT TO FAIL IN ITS ESSENTIAL PURPOSE. BUYER SHALL BE ENTITLED TO NO OTHER REMEDY OTHER THAN AS SET FORTH HEREIN, REGARDLESS OF THE CLAIM OR CAUSE OF ACTION, WHETHER BASED IN CONTRACT, TORT, NEGLIGENCE, GOODS LIABILITY, STRICT LIABILITY OR OTHERWISE.

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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.