



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

LR Motor Shop Repairs

**Job Number 102982**

Prepared for Welspun Tubular (11685)

9301 Frazier Pike  
Little Rock AR 72206

# Table of Contents

AC Inspection as Found - *LR MOTORSHOP*

AC Inspection - Rev. 2: 27330

**1.0**

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*Printed on 6/17/2024*

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

## AC Inspection as Found

Welspun Tubular (11685)

9301 Frazier Pike  
Little Rock, AR 72206

FolderID: 102982  
FormID: 20452938

### AC Inspection - Rev. 2

Location: LR MOTORSHOP

Serial Number: 27330

Description: 25HP AJAY EVAL

Hi-Speed Job Number: 102982

Manufacturer: Other

Spec/ID #: 43PH25

Serial Number: 27330

HP/kW: 25 (HP)

RPM: 3450 (RPM)

Frame: AJAY

Voltage: 480

Current: 33 (Amps)

Phase: Three

Hz: 60 (Hz)

Enclosure: TEFC

# of Leads: 6

J-box Included: Half

Coupling/Sheave: Propeller

Date Received: 05/21/2024

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: ● 3 - High ● 7 - Good

### Overall Condition

1. Report Date

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## 2. Nameplate Picture



3. Photos of all six sides of the machine.



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4. Describe the Overall Condition of the Equipment as Received

*Heavily covered in debris/ acceptable*

5. Distance from the end of the shaft to the Coupling/Sheave

**inches**



### Initial Mechanical/Electrical

6.	Does Shaft Turn Freely?	(Y) Yes
7.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
8.	Does Shaft Have Visible Damage?	(No) No
9.	Assembled Shaft Runout	Inches
10.	Assembled Shaft End Play	inches

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11. Air Gap Variation <10%	
12. Lead Condition	(P) Pass
13. Lead Length	6 Inches
14. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
7/16	
15. Lead Numbers	u1 v 1 w 1 u2 v2 w2
16. Frame Condition	acceptable
17. Fan Condition	(P) Pass
Acceptable	



18. Broken or Missing Components	
<b>Initial Electrical Inspection</b>	
19. Insulation Resistance/Megger	Megohms

Test ID	Test	Results	Comments
1000002	480V w/o...	T...	PASS PASS
5/28/2024 10:5...	480V w/o...	T...	PASS PASS
5/28/2024 10:4...	480V w/o...	T...	PASS PASS
5/28/2024	5/28/2024	5/28/2024	5/28/2024
Test Time	8:22:59 AM	10:54:40 AM	10:46:17
Temp Status	Tested	Tested	No Test
Temp (C)	21.1	23.9	
IR Temp Conn...	Thermoplastic	Thermoplastic	None
Pass Status	PASS	PASS	No Test
Ref L1 (Ohms)			
Ref L2 (Ohms)			
Ref L3 (Ohms)			
L1-L2 (Ohms)	70.275 Corr: 0.2...	0.1199 Corr: 0...	
L2-L3 (Ohms)	0.279 Corr: 0.2...	0.1187 Corr: 0...	
L3-L1 (Ohms)	0.275 Corr: 0.2...	0.1201 Corr: 0...	
Max Delta R %	0.594	1.161	
Cold T (Ohms)	0.411 Corr: 0.4...	0.1803 Corr: 0...	
Cold T (Ohms)	0.416 Corr: 0.4...	0.1767 Corr: 0...	
Homeplate	Application	Results/Summary	Surge

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## 20. Winding Resistance

1-2

1-3

2-3

Test ID	Test Name	Test Date	Test Time	Test Result	Test Status
W1	Winding Resistance	5/28/2024	10:54:46 AM	PASS	PASS
W2	Winding Resistance	5/28/2024	10:54:46 AM	PASS	PASS
W3	Winding Resistance	5/28/2024	10:54:46 AM	PASS	PASS
W4	Winding Resistance	5/28/2024	10:54:46 AM	PASS	PASS
W5	Winding Resistance	5/28/2024	10:54:46 AM	PASS	PASS
W6	Winding Resistance	5/28/2024	10:54:46 AM	PASS	PASS
W7	Winding Resistance	5/28/2024	10:54:46 AM	PASS	PASS
W8	Winding Resistance	5/28/2024	10:54:46 AM	PASS	PASS
W9	Winding Resistance	5/28/2024	10:54:46 AM	PASS	PASS
W10	Winding Resistance	5/28/2024	10:54:46 AM	PASS	PASS

## 21. Perform Surge Test

(P) Pass

Test ID	Test Name	Test Date	Test Time	Test Result	Test Status
S1	Surge Test	5/28/2024	10:54:46 AM	PASS	PASS
S2	Surge Test	5/28/2024	10:54:46 AM	PASS	PASS
S3	Surge Test	5/28/2024	10:54:46 AM	PASS	PASS
S4	Surge Test	5/28/2024	10:54:46 AM	PASS	PASS
S5	Surge Test	5/28/2024	10:54:46 AM	PASS	PASS
S6	Surge Test	5/28/2024	10:54:46 AM	PASS	PASS
S7	Surge Test	5/28/2024	10:54:46 AM	PASS	PASS
S8	Surge Test	5/28/2024	10:54:46 AM	PASS	PASS
S9	Surge Test	5/28/2024	10:54:46 AM	PASS	PASS
S10	Surge Test	5/28/2024	10:54:46 AM	PASS	PASS

## 22. Number of Stator Slots

36

## 23. Stator Condition

acceptable

## 24. Stator Thermistors/Ohms

## 25. Stator Overloads/Ohms

## Mechanical Inspection

## 26. Drive End Bearing Brand

FAG

## 27. Drive End Bearing Number-

6310-2rsr-L038-C3

## 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?

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

snap ring

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33. Drive End Bearing Condition

no defect



34. Opposite Drive End Bearing Brand

FAG

35. Opposite Drive End Bearing Number-

6308-2RSR-L038-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?

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

41. Opposite Drive End Bearing Condition

no defect



42. Drive End Seal

1 seal present

43. Opposite Drive End Seal

## Rotor Inspection



44. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast



45.	Growler Test	(Pass) Pass	
46.	Number of Rotor Bars	28	
47.	Rotor Condition	acceptable	
48.	List the Parts needed for the Repair Below		
49.	Signature of Technician that Disassembled Motor		
Mechanical Fits- Rotor			
50.	Shaft Runout	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
	1.9688	1.9688	1.9687
	55.	Drive End Bearing Shaft Fit Condition	(P) Pass
	56.	Opposite Drive End Bearing Shaft Fit	
		0 Degrees	60 Degrees
		1.575	1.575
	57.	Opposite Drive End Bearing Shaft Fit Condition	(P) Pass

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58. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Bored the seal housing .200" Deaper to accommodate the extra length of new seal. Also turned the impeller collar down to fit inside the seal spring for the additional length of the new seal.  
 Gary



Mechanical Fits- Bearing Housings

59. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

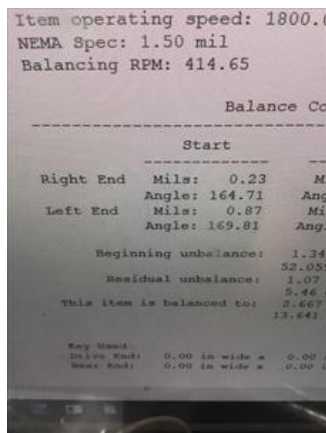
120 Degrees

Bad, excessive wear.



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60.	Drive End - Endbell Bearing Fit Condition	(F) Fail
61.	Opposite Drive End - Endbell Bearing Fit	
	0 Degrees                      60 Degrees                      120 Degrees	
	3.5416                      3.5417                      3.5416	
62.	Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail
	<i>Fit measures too tight.</i>	
63.	Bearing Cap Condition	
	Drive End Bearing Cap                      Opposite Drive End Bearing Cap	
	an                      an	
64.	End Bell Air Seal Fits	
	Drive End Air Seal                      Opposite Drive End Air Seal	
65.	List Machine Work Needed Below	
	<i>Both housing fits, and DE shaft seal surface and shaft seal worn.</i>	
66.	Technician	Terrence Holland
		
<b>Root Cause of Failure</b>		
67.	Failure locations	
	<i>Housing fits, shaft seal surface.</i>	
68.	Root cause of failure	
	<i>Machined housing fits &amp; shaft seal surface. Also shaft seal worn.</i>	
<b>Dynamic Balance Report</b>		
69.	Rotor Weight and Balance Grade	
	Rotor Weight                      Balance Grade	
	<i>Na</i>	
70.	Initial Balance Readings	
	Drive End                      Opposite Drive End	



## 71. Final Balance Readings

Drive End

Opposite Drive End



## 72. Technician

Cw

**Mechanical Fits- Bearing Housings - Post Repair**

## 73. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

## 74. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

## 75. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

## 76. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

## 77. End Bell Repair Sign-off

**Assembly**

## 78. QC Check All Parts for Cleanliness Prior to Assembly

79. Photograph All Major Components prior to assembly



80. Final Insulation Resistance Test	Megohms
Pass	
81. Assembled Shaft Endplay	inches
Na	
82. Assembled Shaft Runout	inches
Na	

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## 83. Test Run Voltage

Volts

Volts

Volts



## 84. Test Run Amperage

Amps

Amps

Amps

Witnessed by Trevor hall



## 85. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.03

0.04

0.04

## 86. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.05

0.04

0.04

## 87. Ambient Temperature - Fahrenheit

Na

## 88. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

## 89. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

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90. Document Final Condition with Pictures after paint



91. Final Pics and QC Review

Cw



Co sign: Trevor Hall



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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.
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