



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

LR Motor Shop Repairs

Job Number 102773

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: 10263/01

1.0

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Printed on 6/5/2024

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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: 102773
FormID: 20055216

AC Inspection - Rev. 2

Location: LR MOTORSHOP

Serial Number: 10263/01

Description:50KW BRUSATORI

Hi-Speed Job Number: 102773

Manufacturer: Other

Product Number: TYPE: VL160L

Spec/ID #: VL160L3W00002

Serial Number: 10263/01

HP/kW: 50 (kW)

RPM: 2400 (RPM)

Voltage: Other

Phase: Three

Hz: 60 (Hz)

Service Factor: 1

Enclosure: TEFC

of Leads: 3

J-box Included: Complete

Coupling/Sheave: None

Date Received: 04/15/2024

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final


Rewind: No


**Shaft Machined Fit Repairs
Required:** Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found:  **4 - High**

 **8 - Good**

Overall Condition

1. Report Date

04/15/2024

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[illegible]

The top photograph shows a large, dark, rectangular industrial motor resting on a wooden pallet. A black control box with a single terminal is connected to the motor by a thick black cable. In the background, a blue wall features a 'Shortcuts' sign, a 'Keys' sign, and a circular diagram. The bottom photograph shows the same motor being lifted by a yellow crane in a workshop. Two workers in hard hats and safety gear are visible in the background. The motor is positioned on a large metal table, and a blue box is visible in the foreground.



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4. Describe the Overall Condition of the Equipment as Received

Bearings are rough

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?	(Yes) Yes



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1.5

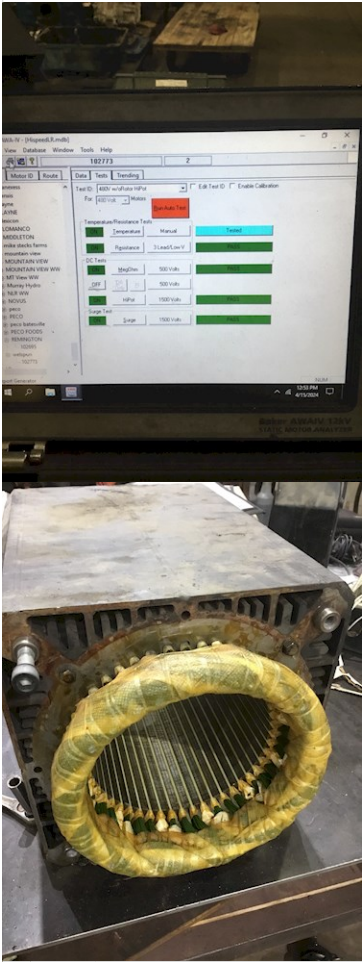


<div><div></div></div>	8. Assembled Shaft Runout	0.001 Inches
	9. Assembled Shaft End Play	inches
<div><div></div></div>	Na	
	10. Air Gap Variation <10%	
<div><div></div></div>	Na	
<div><div></div></div>	11. Lead Condition	(P) Pass
	12. Lead Length	12 Inches
<div><div></div></div>	13. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
<div><div></div></div>	CU25-8	
	14. Lead Numbers	U1 V1 W1
	15. Frame Condition	good
<div><div></div></div>	16. Fan Condition	(P) Pass
	17. Broken or Missing Components	
<div><div></div></div>	Broken fan plug	
Initial Electrical Inspection		
	18. Insulation Resistance/Megger	2000 Megohms
	19. Winding Resistance	
	1-2	1-3
	.2	.2

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20. Perform Surge Test

(P) Pass



21. Number of Stator Slots	48
22. Stator Condition	good
23. Stator Thermistors/Ohms	
Na	
24. Stator Overloads/Ohms	0.1
Mechanical Inspection	
25. Drive End Bearing Brand	koyo
26. Drive End Bearing Number-	6211 2zc3



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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?	no
31. Drive End Wavy Washer/Snap-Ring Other Retention Device?	no
32. Drive End Bearing Condition	worn
33. Opposite Drive End Bearing Brand	koyo
34. Opposite Drive End Bearing Number-	6211 2zc3



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?	no
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
40. Opposite Drive End Bearing Condition	worn
41. Drive End Seal	




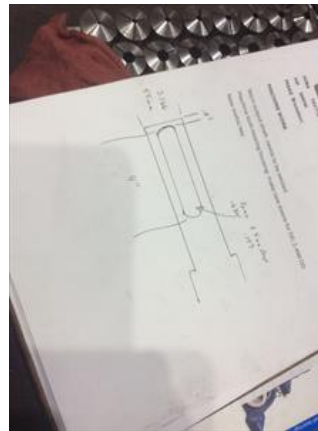
42. Opposite Drive End Seal	Na
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Rotor Inspection

43. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
44. Growler Test	(Pass) Pass
45. Number of Rotor Bars	36

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46. Rotor Condition	good		
47. List the Parts needed for the Repair Below	6211 2zc3		
48. Signature of Technician that Disassembled Motor	Trevor Hall		
			
Mechanical Fits- Rotor			
49. Shaft Runout	0.001 inches		
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	
2.1552	2.1662	2.1662	
Welded drive end and cut new key way. Shaft runout after welding .0005			



Dia.- 2.166, 2.166, 2.166

Gary

52. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
2.1667	2.1667	2.1666
53. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.1661	2.1662	2.1662
54. Drive End Bearing Shaft Fit Condition	(P) Pass	
55. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.1655	2.1655	2.1656
Minimum		
56. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	

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57. Shaft Air Seal Fits			
Drive End Air Seal		Opposite Drive End Air Seal	
<div><div></div><div>Na</div></div>			
Mechanical Fits- Bearing Housings			
58. Drive End - Endbell Bearing Fit			
0 Degrees		60 Degrees	120 Degrees
3.9372		3.9376	3.9373



Sleeved finish dia. -3.9375, 3.9375, 3.9375

Gary

<div> <div></div> <div>59. Drive End - Endbell Bearing Fit Condition</div> </div> <div> <div></div> <div>Egg shaped</div> </div>	(F) Fail
--	----------



60. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
3.9371	3.937	3.9366



Sleeved finish dia.- 3.9374, 3.9374, 3.9374

Gary

<div> <div></div> <div>61. Opposite Drive End - Endbell Bearing Fit Condition</div> </div> <div> <div></div> <div>Egg shaped</div> </div>	(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

pass

pass

64. List Machine Work Needed Below

Output shaft, opposite drive endbell,

65. Technician

Trevor Hall

Root Cause of Failure

66. Failure locations

Bearings, output shaft. I had to cut off drive end sleeve and bearing.

67. Root cause of failure

Normal wear.

Dynamic Balance Report


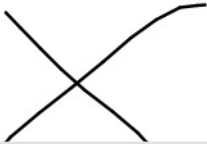
68. Rotor Weight and Balance Grade

Rotor Weight

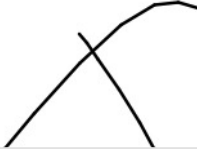

Balance Grade



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69. Initial Balance Readings		
Drive End	Opposite Drive End	
.99	2.43	
70. Final Balance Readings		
Drive End	Opposite Drive End	
.30	.33	
71. Technician		David Maclin
		
Mechanical Fits- Rotor - Post Repair		
72. Shaft Runout Post Repair		0 inches
73. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0		
74. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
0		
75. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
0		
76. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
0		
77. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
0		
78. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
ok	ok	
79. Shaft Repair Sign-off		Gary Moore
		
Mechanical Fits- Bearing Housings - Post Repair		
80. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
0		
81. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
0		
82. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
ok	na	

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83. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
ok	ok	
84. End Bell Repair Sign-off		Gary Moore
		
Assembly		
85. QC Check All Parts for Cleanliness Prior to Assembly		David Maclin
		
86. Photograph All Major Components prior to assembly		







87.	Final Insulation Resistance Test		2000 Megohms
88.	Assembled Shaft Endplay		0 inches
<div><div></div></div> 89.	Assembled Shaft Runout		0 inches
90.	Test Run Voltage		
	Volts	Volts	Volts
	460	460	462
<div><div></div></div>	Witnessed by Chris Wiley		



91. Test Run Amperage		
Amps	Amps	Amps

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	41.6	40.2	42.1	
92. Drive End Vibration Readings - Inches Per Second				
Horizontal		Vertical		Axial
0.0622		0.0259		0.0355
93. Opposite Drive End Vibration Readings - Inches Per Second				
Horizontal		Vertical		Axial
0.0418		0.0322		0.0116
94. Ambient Temperature - Fahrenheit				0
95. Drive End Bearing Temps - Fahrenheit				
5 Minutes		10 Minutes		15 Minutes
0		0		0
96. Opposite Drive End Bearing Temps - Fahrenheit				
5 Minutes		10 Minutes		15 Minutes
0		0		0
97. Document Final Condition with Pictures after paint				looks new
98. Final Pics and QC Review				David Maclin
				
 Witnessed by 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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