



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

LR Motor Shop Repairs

Job Number 104447

Prepared for ARKANSAS INDUSTRIAL MACHINERY

3804 N. NONA ST
NORTH LITTLE ROCK AR 72118

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AC Inspection as Found - *LR MOTOR SHOP*

AC Inspection - Rev. 2: 3GV1311195936002

1.0

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AC Inspection as Found
ARKANSAS INDUSTRIAL MACHINERY
3804 N. NONA ST
NORTH LITTLE ROCK, AR 72118

FolderID: 104447
FormID: 24101160

AC Inspection - Rev. 2

Location: LR MOTOR SHOP
Serial Number: 3GV1311195936002
Description: 100 HP ABB

Hi-Speed Job Number:	104447
Manufacturer:	ABB
Product Number:	M3AA225SME2
Spec/ID #:	1080417524
Serial Number:	3GV1311195936002
HP/kW:	100 (HP)
RPM:	3570 (RPM)
Voltage:	460
Current:	119 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.25
Enclosure:	TEFC
# of Leads:	6
J-box Included:	None
Coupling/Sheave:	Coupling
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: 1 - High 1 - Medium 20 - Good

Overall Condition

1. Report Date

2. Nameplate Picture



3. Photos of all six sides of the machine.



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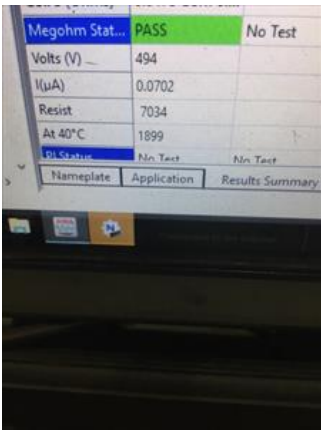


4. Describe the Overall Condition of the Equipment as Received	
5. Distance from the end of the shaft to the Coupling/Sheave	inches

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	6.	Is this a UL Listed Motor	(No) No
	7.	Is the motor water cooled or can be pressure checked before teardown	(No) No
Initial Mechanical/Electrical			
	8.	Does Shaft Turn Freely?	(Y) Yes
	9.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
	10.	Does Shaft Have Visible Damage?	(No) No
	11.	Assembled Shaft Runout	0.001 Inches
	12.	Assembled Shaft End Play	inches
	13.	Air Gap Variation <10%	
	14.	Lead Condition	(P) Pass
	15.	Lead Length	64 Inches
	16.	Does it have Lugs?, If so what is the Stud Size?	(No) No
	17.	Lead Numbers	U1-V1-W1-U2-V2-W2
	18.	Are the Leads insulated with Chico or other material	(No) No
	19.	Frame Condition	
	20.	Fan Condition	(P) Pass
	21.	Does motor have internal fan?	(No) No
	22.	Broken or Missing Components	
	Fan cover bolt brackets		
Initial Electrical Inspection			
	23.	Insulation Resistance/Megger	Megohms



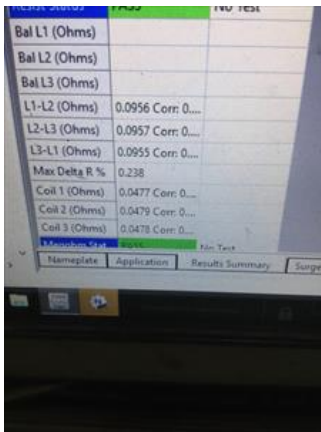
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24. Winding Resistance

1-2

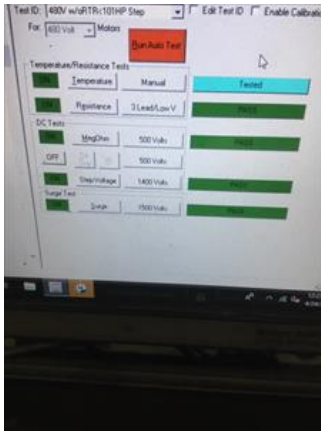
1-3

2-3



25. Perform Surge Test

(P) Pass



26. Number of Stator Slots

48

27. Stator Condition

28. Stator Thermistors/Ohms

29. Stator Overloads/Ohms

Mechanical Inspection

30. Drive End Bearing Brand

NSK

31. Drive End Bearing Number-

6212-c4

32. Drive End Bearing Qty.

1

33. Drive End Bearing Type

(Ball) Ball Bearing

34. Drive End Lubrication Type

(Grease) Grease Lubricated

35. Drive End Bearing Insulation or Grounding Device?

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

Spacer

37. Drive End Bearing Condition

 **Chemical burn**



38. Opposite Drive End Bearing Brand	NSK
39. Opposite Drive End Bearing Number-	6212-c4
40. Opposite Drive End Bearing Qty.	1
41. Opposite Drive End Bearing Type	(Ball) Ball Bearing
42. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
43. Opposite Drive End Bearing Insulation or Grounding Device?	
44. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
45. Opposite Drive End Bearing Condition	

 **Contamination**



46. Drive End Seal
47. Opposite Drive End Seal

Rotor Inspection

48. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
49. Growler Test	(Pass) Pass
50. Number of Rotor Bars	40
51. Rotor Condition	
52. List the Parts needed for the Repair Below	
6212 C2 x2	

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53. Signature of Technician that Disassembled Motor

Cw



Mechanical Fits- Rotor

54. Shaft Runout inches

55. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

56. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

57. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

58. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.3627-2.3627-2.3627

59. Drive End Bearing Shaft Fit Condition

(P) Pass

60. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.3625-2.3624-2.3625

61. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass

62. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

63. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

4.3308-4.3308-4.3308

64. Drive End - Endbell Bearing Fit Condition

(P) Pass

65. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

4.3329-4.3308-4.3317

66. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail

67. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

68. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

69. List Machine Work Needed Below

ODE end bell bearing fit

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Co sign: DM

Root Cause of Failure

71. Failure locations

Bearings and ODE end bell bearing fit

72. Root cause of failure

Contamination and wear

Dynamic Balance Report

73. Rotor Weight and Balance Grade

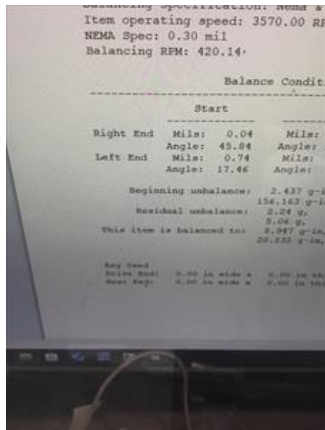
Rotor Weight

Balance Grade

74. Initial Balance Readings

Drive End

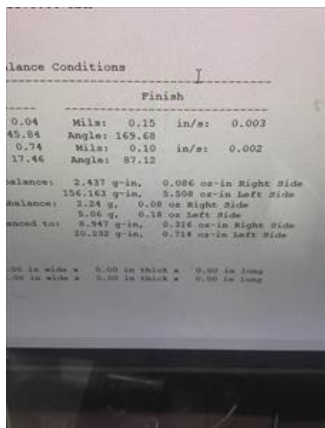
Opposite Drive End



75. Final Balance Readings

Drive End

Opposite Drive End



76. Technician

Cw


Mechanical Fits- Bearing Housings - Post Repair

77. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

78. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

4.331**4.331****4.331**

79. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

80. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

81. End Bell Repair Sign-off

Gary

Assembly

82. QC Check All Parts for Cleanliness Prior to Assembly

Cw



83. Photograph All Major Components prior to assembly



84. Final Insulation Resistance Test

Megohms



85. Assembled Shaft Endplay	inches	
86. Assembled Shaft Runout	inches	
87. Test Run Voltage		
Volts	Volts	Volts




88. Test Run Amperage		
Amps	Amps	Amps
Witnessed by TRH		



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



95. Final Pics and QC Review	Cw
<div>  </div> <div> <div></div> <div>Co sign: TRH</div> </div>	



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1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
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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.
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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

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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.
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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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