



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

LR Motor Shop Repairs

Job Number 104933

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: *A1908092041*

1.0

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Printed on 8/8/2025

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

FolderID: 104933
FormID: 25219783

AC Inspection - Rev. 2

Location: LR MOTOR SHOP

Serial Number: A1908092041

Description: 200 HP BALDOR
PREVENTATIVE MAINTENANCE

Hi-Speed Job Number: 104933

Manufacturer: ABB

Spec/ID #: B640139

Serial Number: A1908092041

HP/kW: 200 (HP)

RPM: 1790 (RPM)

Frame: 447TSC

Voltage: 460

Current: 224

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: DP

of Leads: 6

J-box Included: Half

Coupling/Sheave: None

Date Received: 07/23/2025

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**  **11 - Good**

Overall Condition

1. Report Date

07/23/2025

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1.0

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	
	<i>Serviceable</i>	
5.	Is this a UL Listed Motor	(NO) NO
6.	Is the motor water cooled or can be pressure checked before teardown	(NO) NO
Initial Mechanical/Electrical		
☒	7. Does Shaft Turn Freely?	(Y) Yes
	8. Does the shaft require T.I.R in Lathe to identify additional repairs?	(NO) NO

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9. Does Shaft Have Visible Damage?

(No) No



10. Assembled Shaft Runout	0.003 Inches
11. Assembled Shaft End Play	0 inches
12. Air Gap Variation <10%	
13. Lead Condition	(P) Pass



14. Lead Length	12 Inches
15. Does it have Lugs?, If so what is the Stud Size?	(YES) YES
16. Lead Numbers	T1-T6
Connection: (1-6) (2-4) (3-5)	



17. Are the Leads insulated with Chico or other material

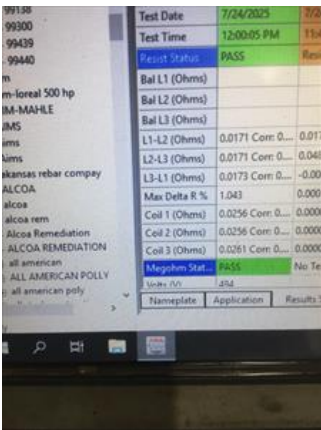
(NO) NO

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18. Frame Condition	pass
19. Fan Condition	
20. Does motor have internal fan?	(NO) NO
21. Broken or Missing Components	none
Initial Electrical Inspection	
22. Insulation Resistance/Megger	7.25 Gigohms



23. Winding Resistance		
1-2	1-3	2-3
.0171	.0173	.0171



24. Perform Surge Test	(P) Pass
------------------------	----------



AIMS	0.2283	
AIMS	0.761	
AIMS	2.759	
At 40°C		
Surge Status	PASS	PASS
Peak Volt(V) L1	1510	1500
Peak Volt(V) L2	1530	1510
Peak Volt(V) L3	1510	1530
Max P-P EAG	0.2/0.2/0.2	0.2/0.2/0.5
EAT 1-2/2-3	1/5/1	1/1/0

25. Number of Stator Slots	72
26. Stator Condition	pass
27. Stator Thermistors/Ohms	
28. Stator Overloads/Ohms	
Mechanical Inspection	
29. Drive End Bearing Brand	nachi



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30. Drive End Bearing Number-

6318/c3



31. Drive End Bearing Qty.	1
32. Drive End Bearing Type	(Ball) Ball Bearing
33. Drive End Lubrication Type	(Grease) Grease Lubricated
34. Drive End Bearing Insulation or Grounding Device?	none
35. Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
36. Drive End Bearing Condition	replace
Contaminated grease.	
37. Opposite Drive End Bearing Brand	nachi



38. Opposite Drive End Bearing Number-

6318c3

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39. Opposite Drive End Bearing Qty.	1
40. Opposite Drive End Bearing Type	(Ball) Ball Bearing
41. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
42. Opposite Drive End Bearing Insulation or Grounding Device?	
43. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer



44. Opposite Drive End Bearing Condition	replace
 Contaminated grease	
45. Drive End Seal	
46. Opposite Drive End Seal	

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Rotor Inspection

47. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
48. Growler Test	(Pass) Pass
49. Number of Rotor Bars	58
50. Rotor Condition	pass
51. List the Parts needed for the Repair Below 2) 6318 2Z/C3 bearings 1) 318 sleeve for ODE housing fit	
52. Signature of Technician that Disassembled Motor	Terrence Holland
	

Mechanical Fits- Rotor

53. Shaft Runout	0.003 inches	
54. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
55. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
56. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
57. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
3.5437	3.5437	3.5437
58. Drive End Bearing Shaft Fit Condition	(P) Pass	
59. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
3.5436	3.5436	3.5435
60. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	
61. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
pass	pass	

Mechanical Fits- Bearing Housings

62. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
7.4813	7.4812	7.4813
63. Drive End - Endbell Bearing Fit Condition	(P) Pass	
64. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees

Fail

65. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail

Excessive wear. Lip worn in housing.



66. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass

pass

67. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

pass

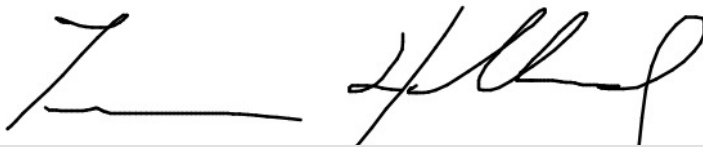
pass

68. List Machine Work Needed Below

Sleeve ODE housing fit.

69. Technician

Terrence Holland



Root Cause of Failure

70. Failure locations

ODE housing fit

71. Root cause of failure

Contaminated grease, and fluting in the bearings.

Dynamic Balance Report

72. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

73. Initial Balance Readings

Drive End

Opposite Drive End

1.3

0.8

74. Final Balance Readings

Drive End

Opposite Drive End

0.1

0.2

75. Technician

Trevor Hall


Rewind76. THERMAL DETECTION EQUIPMENT FINAL TESTING -
RTD'S/KLIXONS/THERMISTORS**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

7.4813

7.4813

7.4812



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







83. Photograph All Major Components prior to assembly	(Complete) Complete	
84. Was a Insulated bearing or end bell tested?	(P) Pass	
85. Final Insulation Resistance Test	1000 Megohms	
86. Assembled Shaft Endplay	inches	
87. Assembled Shaft Runout	0.001 inches	
88. Test Run Voltage		
Volts	Volts	Volts
464	462	467



89. Test Run Amperage		
Amps	Amps	Amps
77	71	72



90.	Motor RPM			1799
91.	Drive End Vibration Readings - Inches Per Second			
	Horizontal	Vertical	Axial	
	0.01	0.008	0.008	
92.	Opposite Drive End Vibration Readings - Inches Per Second			
	Horizontal	Vertical	Axial	
	0.01	0.01	0.008999999999999999	
93.	Ambient Temperature - Fahrenheit			77.8
94.	Drive End Bearing Temps - Fahrenheit			
	5 Minutes	10 Minutes	15 Minutes	
	80.59999999999999	82.8		
95.	Opposite Drive End Bearing Temps - Fahrenheit			
	5 Minutes	10 Minutes	15 Minutes	
	80.2	82		
96.	Document Final Condition with Pictures after paint			Ready
97.	Final Pics and QC Review			Trevor Hall
				
	Co-sign: TRH			







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