



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

LR Motor Shop Repairs

Job Number 103882

Prepared for ARKANSAS INDUSTRIAL MACHINERY

3804 N. NONA ST
NORTH LITTLE ROCK AR 72118

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AC Inspection as Found - *Shop*

AC Inspection - Rev. 2: C2302170952

1.0

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

FolderID: 103882
FormID: 22617634

AC Inspection - Rev. 2

Location: Shop

Serial Number: C2302170952

Description: HP/KW: 40

Hi-Speed Job Number: 103882

Manufacturer: Baldor

Spec/ID #: 10F371Y652G1

Serial Number: C2302170952

HP/kW: 40 (HP)

RPM: 3530 (RPM)

Frame: 324CS

Voltage: 230 / 460

Current: 90/45 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.00

Enclosure: TEFC

of Leads: 9

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: No

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: 1 - Medium 17 - Good

Overall Condition

1. Report Date

12/23/2024

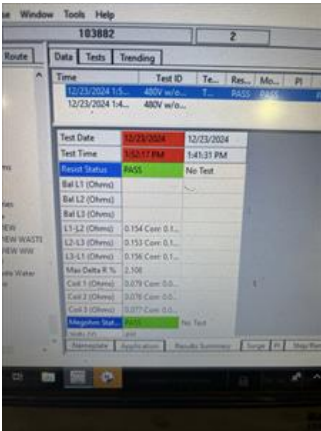
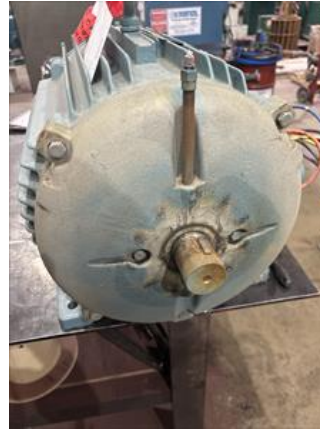
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2. Nameplate Picture



3. Photos of all six sides of the machine.





4.	Describe the Overall Condition of the Equipment as Received	
5.	Distance from the end of the shaft to the Coupling/Sheave	0.25 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
11.	Air Gap Variation <10%	

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12. Lead Condition	(P) Pass
13. Lead Length	12 Inches
14. Does it have Lugs?, If so what is the Stud Size?	(No) No
15. Lead Numbers	1-9
16. Frame Condition	good
17. Fan Condition	(P) Pass
18. Broken or Missing Components	no
19. Does motor have internal fan?	
Initial Electrical Inspection	
20. Insulation Resistance/Megger	Megohms

Test Date	12/23/2024	12/23/2024
Test Time	1:50:17 PM	1:41:31 PM
L1-L2 (Ohms)	0.154 Corr: 0.1...	
L2-L3 (Ohms)	0.153 Corr: 0.1...	
L3-L1 (Ohms)	0.156 Corr: 0.1...	
Max Delta R %	2.108	
Coil 1 (Ohms)	0.079 Corr: 0.0...	
Coil 2 (Ohms)	0.076 Corr: 0.0...	
Coil 3 (Ohms)	0.077 Corr: 0.0...	
Megohm Status	PASS	No Test

21. Winding Resistance		
1-2	1-3	2-3

Test Date	12/23/2024	12/23/2024
Test Time	1:50:17 PM	1:41:31 PM
Test Status	PASS	No Test

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22. Perform Surge Test

(P) Pass



23. Number of Stator Slots	36
24. Stator Condition	pass
25. Stator Thermistors/Ohms	
26. Stator Overloads/Ohms	
Mechanical Inspection	
27. Drive End Bearing Brand	
28. Drive End Bearing Number-	6312
29. Drive End Bearing Qty.	1
30. Drive End Bearing Type	(Ball) Ball Bearing
31. Drive End Lubrication Type	(Grease) Grease Lubricated
32. Drive End Bearing Insulation or Grounding Device?	
33. Drive End Wavy Washer/Snap-Ring Other Retention Device?	
34. Drive End Bearing Condition	
35. Opposite Drive End Bearing Brand	
36. Opposite Drive End Bearing Number-	6309
37. Opposite Drive End Bearing Qty.	1
38. Opposite Drive End Bearing Type	(Ball) Ball Bearing
39. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
40. Opposite Drive End Bearing Insulation or Grounding Device?	none
41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
42. Opposite Drive End Bearing Condition	
43. Drive End Seal	lip seal in bearing cap
44. Opposite Drive End Seal	lip seal in bearing cap
Rotor Inspection	
45. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
46. Growler Test	(Pass) Pass
47. Number of Rotor Bars	28
48. Rotor Condition	good
49. List the Parts needed for the Repair Below	
6312 and 6309 bearings.	

50. Signature of Technician that Disassembled Motor

Shon Jones


Mechanical Fits- Rotor

51. Shaft Runout inches

52. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

53. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

54. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

55. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.3628

2.3628

2.3626

56. Drive End Bearing Shaft Fit Condition

(P) Pass

57. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.7717

1.7719

1.7717

58. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass

59. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

60. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

5.1185

5.1183

5.1185

61. Drive End - Endbell Bearing Fit Condition

(P) Pass

62. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

3.9376

3.9373

3.9375

63. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass

64. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

65. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

66. List Machine Work Needed Below

67. Technician

Root Cause of Failure

68. Failure locations

69. Root cause of failure

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Dynamic Balance Report

70. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

71. Initial Balance Readings

Drive End

Opposite Drive End



72. Final Balance Readings

Drive End

Opposite Drive End



73. Technician

Cw

Assembly

74. QC Check All Parts for Cleanliness Prior to Assembly

Cw

75. Photograph All Major Components prior to assembly

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76. Final Insulation Resistance Test

30.13 Megohms



77. Assembled Shaft Endplay	inches
78. Assembled Shaft Runout	inches
0.001	
79. Test Run Voltage	
Volts	Volts

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80. Test Run Amperage

Amps

Amps

Amps

Witnessed by: RRW



81. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.02-0.03-0.03

82. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.04-0.03-0.02

83. Ambient Temperature - Fahrenheit

84. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

85. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

86. Document Final Condition with Pictures after paint



87. Final Pics and QC Review

Cw

Co sign: RRW



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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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