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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 102953

Prepared for CoorsTek Inc.

3315 Boone Road
Benton AR 72015

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

AC Inspection as Found

CoorsTek Inc.
3315 Boone Road
Benton, AR 72015

FolderID: 102953
FormID: 20411787

AC Inspection - Rev. 2

Location: LR MOTORSHOP

Serial Number: 2082-021

Description: 5HP 1750RPM PUMP

Hi-Speed Job Number: 102953

Manufacturer: Other

Product Number: 80LX63.7

Spec/ID #: NA

Serial Number: 2082-021

HP/kW: 5 (HP)

RPM: 1750 (RPM)

Frame: NA

Voltage: 460

Current: 36.6 (Amps)

Phase: Three

Hz: 60 (Hz)

Enclosure: Submersible

of Leads: 6

J-box Included: None

Coupling/Sheave: Propeller

Date Received: 05/17/2024

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: Yes

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: ● 3 - High ● 9 - Good

Overall Condition

1. Report Date

06/03/2024

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2. Nameplate Picture



3. Photos of all six sides of the machine.





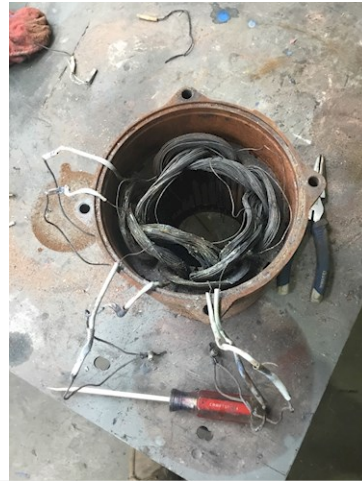
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1.2



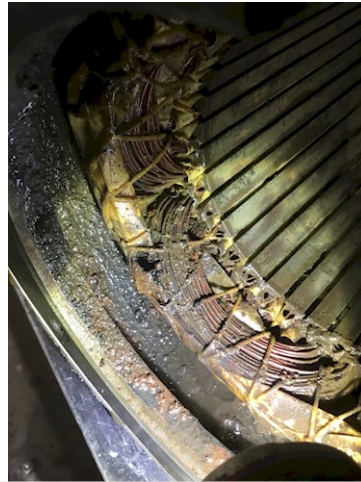


4. Describe the Overall Condition of the Equipment as Received		
<i>Dirty</i>		
5. Distance from the end of the shaft to the Coupling/Sheave	inches	
<i>Na</i>		
Initial Mechanical/Electrical		
6. Does Shaft Turn Freely?	(Y) Yes	
7. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No	
8. Does Shaft Have Visible Damage?	(No) No	
9. Assembled Shaft Runout	Inches	
<i>Na</i>		
10. Assembled Shaft End Play	inches	
<i>Na</i>		
11. Air Gap Variation <10%		
<i>Na</i>		
12. Lead Condition	(P) Pass	
13. Lead Length	92 Inches	
14. Does it have Lugs?, If so what is the Stud Size?	(No) No	
15. Lead Numbers	1-6	
16. Frame Condition	pass	
17. Fan Condition	(N) NA	
18. Broken or Missing Components	na	
Initial Electrical Inspection		
19. Insulation Resistance/Megger	Megohms	
<i>Na</i>		
20. Winding Resistance		
1-2	1-3	2-3
<i>Na</i>		

21. Perform Surge Test

(NA) Not Applicable

Windings shorted



22. Number of Stator Slots

36

23. Stator Condition

needs cleaned

24. Stator Thermistors/Ohms

na

25. Stator Overloads/Ohms

1/0.2

Mechanical Inspection

26. Drive End Bearing Brand

NSK



27. Drive End Bearing Number-

OD-6208
ID-5307

28. Drive End Bearing Qty.

1

29. Drive End Bearing Type

(Other) Other

Double wide double ball

30. Drive End Lubrication Type

(Oil) Oil Lubricated

31. Drive End Bearing Insulation or Grounding Device?

na

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

na

33. Drive End Bearing Condition

Signs of contamination



34. Opposite Drive End Bearing Brand	tpi
35. Opposite Drive End Bearing Number-	6205
36. Opposite Drive End Bearing Qty.	1
37. Opposite Drive End Bearing Type	(Ball) Ball Bearing
38. Opposite Drive End Lubrication Type	(Oil) Oil Lubricated
39. Opposite Drive End Bearing Insulation or Grounding Device?	na
40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
41. Opposite Drive End Bearing Condition	

Signs of contamination



42. Drive End Seal	Double sided mechanical seal
43. Opposite Drive End Seal	na

Na

Rotor Inspection

44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
45. Growler Test	(Pass) Pass
46. Number of Rotor Bars	44
47. Rotor Condition	pass

48. List the Parts needed for the Repair Below

Double sided mechanical seal

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49. Signature of Technician that Disassembled Motor

Cw



Mechanical Fits- Rotor

50. Shaft Runout inches

 Pass

51. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

 Pass

52. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

 Na

53. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees


 Na

54. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

 55. Drive End Bearing Shaft Fit Condition (P) Pass

56. Opposite Drive End Bearing Shaft Fit

0 Degrees


60 Degrees

120 Degrees

0.9846

0.9846

0.9837

 57. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

58. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

 Na

Mechanical Fits- Bearing Housings

59. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

 60. Drive End - Endbell Bearing Fit Condition (P) Pass

61. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

2.048

2.0479

2.0479


 62. Opposite Drive End - Endbell Bearing Fit Condition (P) Pass

63. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

 Pass

64. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
Na		
65. List Machine Work Needed Below		
Needs new wear wring		
66. Technician	Cw	
		
Root Cause of Failure		
67. Failure locations		
Windings, bearings, and wear ring		
68. Root cause of failure		
Wear and coil to coil short		
Dynamic Balance Report		
69. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
70. Initial Balance Readings		
Drive End	Opposite Drive End	
71. Final Balance Readings		
Drive End	Opposite Drive End	
72. Technician		
Rewind		
73. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	
74. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	
75. Post Rewind Electrical Test- Insulation Resistance	Megohms	
76. Post Rewind Polarization Index	Polarization Index	
77. Post Rewind Winding Resistance		
1-2	1-3	2-3
78. Post Rewind Surge Test		
79. Post Rewind Hi-Pot	micro-amps	
80. Technician		
Assembly		
81. QC Check All Parts for Cleanliness Prior to Assembly		

82. Photograph All Major Components prior to assembly



Held at 10 psi for 5 min

83. Final Insulation Resistance Test	Megohms
84. Assembled Shaft Endplay	inches
85. Assembled Shaft Runout	inches
86. Test Run Voltage	
Volts	Volts



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87. Test Run Amperage

Amps

Amps

Amps

Witnessed by TH



88. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

89. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

90. Ambient Temperature - Fahrenheit

91. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

92. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

93. Document Final Condition with Pictures after paint





94. Final Pics and QC Review

Cw

TRH



Co sign: TRH



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

AC Random Coil Rewind Report

FolderID: 102953
FormID: 22007836

CoorsTek Inc.
3315 Boone Road
Benton, AR 72015

LR MOTORSHOP

Priorities Found: ● 1 - High ● 1 - Good

General

1. Job Number	102953
2. Report Date	
3. Customer	Coortek
Winding ex Dr end 1.5 Ode1.5	

Stator Winding

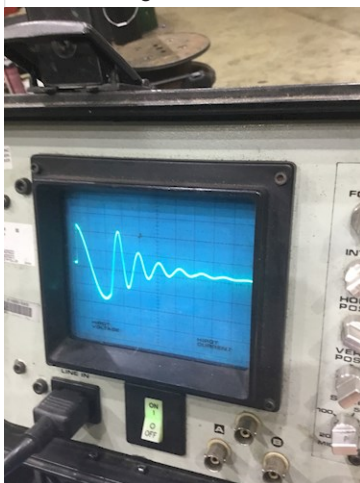
4. Core Length	4.25 "
5. Core ID	3.75 "
6. Back Iron Depth	0.5 "
7. Slot Depth	0.5 "
8. Tooth Width	0.189 "
9. Number of Vents	0
10. Vent Width	0 "
● 11. Before Burnout Core loss	(P) Pass
12. Flux Before Burnout	
13. Watts before burnout	
14. Watts loss per lb. before burnout	1.9 W/lbs.
15. After Burnout Core Loss	
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	
19. Core Iron Condition	
20. RTD's	
21. RTD's Reading	
22. Motor Heaters	
23. Heater Qty.	
24. Heater Voltage	
25. Heater Wattage	
26. Thermistors	
27. Number of Poles	4
28. Slots	36
29. Number of Coils	24
30. Coil Weight	
31. Lead Markings	
1-6	

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32. Grouping 12of2	
33. Multiple Wires	(N) No
34. Wire Size 1#20	
35. Turns per coil 29-58	
36. Pitch 1 to: 7&9	
37. Connection Wye/Delta @460	
38. Lead Length	9 "
39. Lead Size	16
40. Number of Leads	6
41. Megger Reading After Rewind	Mohms
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	Ua



46. Surge Pattern After Rewind



47. Service Technician

RHR

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Handwritten signature and initials.

6LBS#20
6"Hi Temp Glass Lead Wire #16
1 -Overlead



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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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14. **NONWAIVER.** No course of dealing or failure of either party to strictly enforce any term, right, or condition of these Standard Terms and Conditions will be construed as a waiver of such term, right or condition. Any waiver by Hi-Speed will only be in writing and will waive no succeeding breach of a term, right or condition.
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