



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

LR Motor Shop Repairs

Job Number 104011

Prepared for DELTA PLASTICS OF THE SOUTH

3104 SOUTH MAIN STREET
STUTT GART AR 72160

Table of Contents

AC Inspection as Found - *LR MOTOR SHOP*

AC Inspection - Rev. 2: *N-D01400498020001/2013*

1.0

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

AC Inspection as Found
DELTA PLASTICS OF THE SOUTH
3104 SOUTH MAIN STREET
STUTT GART, AR 72160

FolderID: 104011
FormID: 23063428

AC Inspection - Rev. 2

Location: LR MOTOR SHOP
Serial Number: N-D01400498020001/2013
Description: 536 HP SIEMANS

Hi-Speed Job Number:	104011
Manufacturer:	Siemens
Product Number:	1LA8355-4PB90-Z
Serial Number:	N-D01400498020001/2013
HP/kW:	536 (HP)
RPM:	1790 (RPM)
Frame:	1LA8 355-4PB90-Z
Voltage:	460
Current:	610 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.0
Enclosure:	TEFC
# of Leads:	12
J-box Included:	Half
Coupling/Sheave:	None
Date Received:	01/30/2025
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	No
Shaft Machined Fit Repairs Required:	Yes
Bearing Housing Machined Fit Repairs Required:	No
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **5 - High** **6 - Good**

Overall Condition

1. Report Date	01/29/2025
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2. Nameplate Picture



3. Photos of all six sides of the machine.







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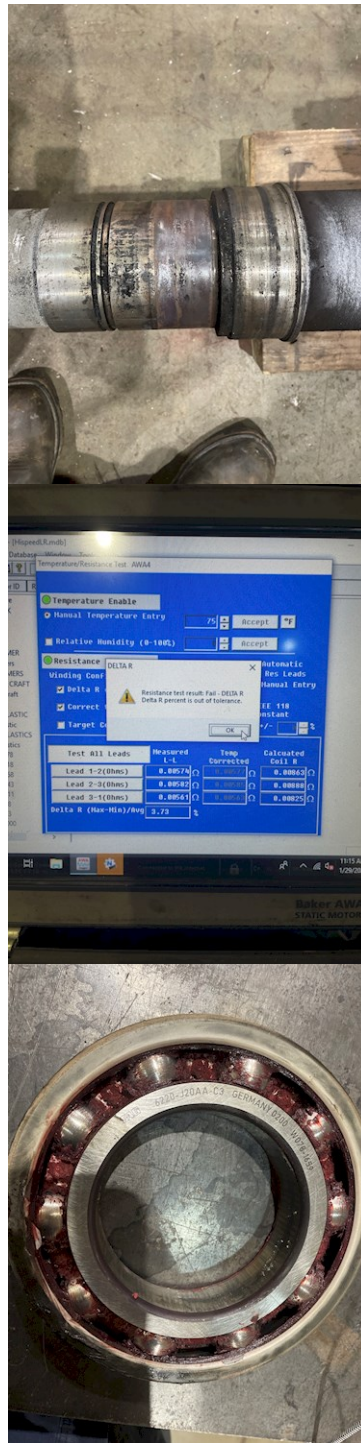


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1.8

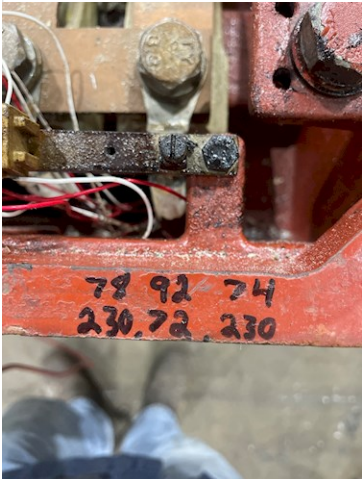
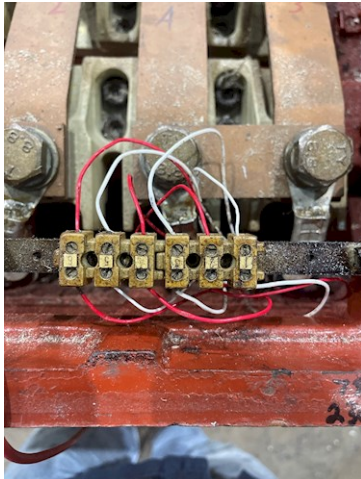


4. Describe the Overall Condition of the Equipment as Received
- Drive end bearing failed due to lack of lubrication.
Internal fan moved back on the shaft about 1/2 inch and started to rub the endbell.
There are aluminum shavings in the windings.
The aegis ring was glued on and came off of the bearing cap.*


Initial Mechanical/Electrical

<input checked="" type="radio"/>	5. Does Shaft Turn Freely?	(N) No
<input checked="" type="radio"/>	6. Does the shaft require T.I.R in Lathe to identify additional repairs?	(Yes) Yes
<input type="radio"/>	7. Does Shaft Have Visible Damage?	(No) No


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8.	Assembled Shaft Runout	Inches
Na		
9.	Assembled Shaft End Play	inches
Na		
10.	Air Gap Variation <10%	
Na		
11.	Lead Condition	(P) Pass
12.	Lead Length	30 Inches
13.	Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
Same as wire		
14.	Lead Numbers	U1,V1,W1 U2,V2,W2
15.	Frame Condition	Pass
16.	Fan Condition	(F) Fail
Internal fail, external pass		
17.	Broken or Missing Components	
Internal fan rubbed endbell		
Initial Electrical Inspection		
18.	Insulation Resistance/Megger	2000 Megohms
19.	Winding Resistance	
1-2	1-3	2-3
.0574	.0582	.0561
3.7% difference		
20.	Perform Surge Test	(P) Pass
21.	Number of Stator Slots	72
22.	Stator Condition	Tests good but has debris in windings
23.	Stator Thermistors/Ohms	thermistors
<div>   </div>		
24.	Stator Overloads/Ohms	na
Mechanical Inspection		
25.	Drive End Bearing Brand	koyo
26.	Drive End Bearing Number-	NU322R
27.	Drive End Bearing Qty.	1
28.	Drive End Bearing Type	(Roller) Roller Bearing
29.	Drive End Lubrication Type	(Grease) Grease Lubricated
30.	Drive End Bearing Insulation or Grounding Device?	Yes but came off

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31. Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring		
32. Drive End Bearing Condition	Fail		
<div> <div></div> Lack of lubrication </div>			
33. Opposite Drive End Bearing Brand	FAG		
34. Opposite Drive End Bearing Number-	6220-J20AA-C3		
<div> <div></div> Ceramic coated outer race </div>			
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?	ceramic coated		
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring		
40. Opposite Drive End Bearing Condition	worn		
41. Drive End Seal	none		
42. Opposite Drive End Seal	none		
Rotor Inspection			
43. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast		
44. Growler Test	(Pass) Pass		
45. Number of Rotor Bars	52		
46. Rotor Condition	Pass		
47. List the Parts needed for the Repair Below Nu322r 6220-j20aa-c3 Internal fan or fix the one it came with Possibly rewind due to contamination Aegis ring			
48. Signature of Technician that Disassembled Motor	Trevor Hall		
<div>  </div>			
<div> <div></div> Co sign. TRH </div>			
Mechanical Fits- Rotor			
49. Shaft Runout	0.001 inches		
<div> <div></div> Both ends </div>			
50. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
0.1			
51. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
3.9377	3.9378	3.9377	
52. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
3.937	3.9372	3.9368	
53. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
4.3312	4.3311	4.3309	
<div> <div></div> Undersized </div>			

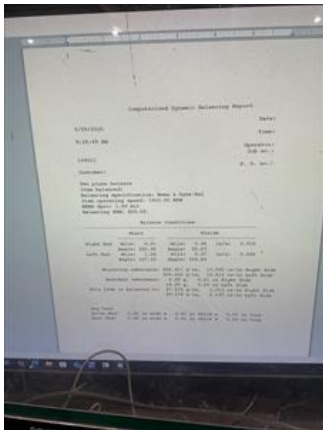
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54.	Drive End Bearing Shaft Fit Condition	(F) Fail	
	Undersized		
55.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	3.9377	3.9377	3.9376
56.	Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	
57.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
	good	good	
Mechanical Fits- Bearing Housings			
58.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	9.449199999999999	9.449199999999999	9.449199999999999
59.	Drive End - Endbell Bearing Fit Condition	(P) Pass	
60.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	7.087	7.0866	7.0868
61.	Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass	
62.	Bearing Cap Condition		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	fail	pass	
	Drive end rubbed		
63.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
	fail	pass	
	Rubbed drive end		
64.	List Machine Work Needed Below		
	Both drive end bearing caps were rubbed by the shaft. Drive end bearing shaft fit is undersized.		
65.	Technician	Trevor Hall	
			
Root Cause of Failure			
66.	Failure locations		
	Bearings Internal fan Aegis ring Possibly windings due to contamination		
67.	Root cause of failure		
	Fan moved on shaft, aegis ring fell off, lack of lubrication on the drive end.		
Dynamic Balance Report			

68. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



69. Initial Balance Readings

Drive End

Opposite Drive End

6.01**1.26**

70. Final Balance Readings

Drive End

Opposite Drive End

0.46**0.37**

71. Technician

RW
Mechanical Fits- Rotor - Post Repair

72. Shaft Runout Post Repair

0.0005 inches

73. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0.001**0.001****0.002**

74. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

75. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

76. Drive End Bearing Shaft Fit Post Repair

0 Degrees	60 Degrees	120 Degrees
4.332	4.332	4.332



Sleeved bearing inner bearing cap. Clearance- .030"

77. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees	60 Degrees	120 Degrees
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78. Shaft Air Seal Fits Post Repair

Drive End Air Seal	Opposite Drive End Air Seal
--------------------	-----------------------------

- Internal fan shaft surface welded and turned to 4.8315.
- Internal Fan bored to 4.8285.
- Snap ring installed to prevent fan from moving on the shaft.



79. Shaft Repair Sign-off

Gary

Assembly

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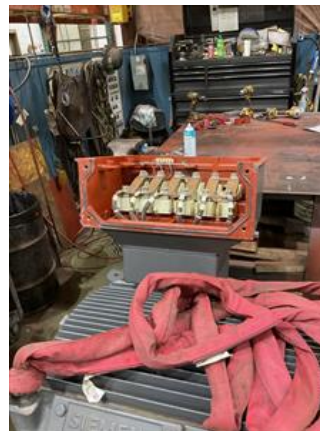
80. QC Check All Parts for Cleanliness Prior to Assembly

RW

[Handwritten signature]

81. Photograph All Major Components prior to assembly

(Complete) Complete





82. Final Insulation Resistance Test

16,940 Megohms



83. Assembled Shaft Endplay

0 inches

84. Assembled Shaft Runout

0 inches

85. Test Run Voltage

Volts	Volts	Volts
456	455	459



Co sign DM

86. Test Run Amperage

AmpsAmpsAmps

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87. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.04	0.04	0.05
88. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.05	0.070000000000000001	0.01
89. Ambient Temperature - Fahrenheit		
90. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
91. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
92. Document Final Condition with Pictures after paint		



93. Final Pics and QC Review

RW



Co sign DM



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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.
6. **DELIVERY SITE AND TIME FOR PERFORMANCE.** Hi-Speed and Buyer agree that time is of the essence for the purchase order and that Buyer shall fully cooperate with Hi-Speed in order to allow Hi-Speed full access to prosecute its work diligently and in an orderly manner. Buyer shall assist Hi-Speed in every way possible to avoid delaying, disrupting or interfering with the progress of Hi-Speed's work at the project site. In the event Hi-Speed's work is delayed, hindered, suspended, disrupted, re-sequenced or interfered with or rendered less efficient or more costly or adversely affected in any way as a result of acts or omissions of Buyer or other contractors or employees of Buyer or by any other reason beyond Hi-Speed's control and without the fault of Hi-Speed, then, in such event, Buyer shall be liable to Hi-Speed for any damages, additional costs, expenses, labor, materials, man hours, acceleration costs, overtime, additional jobsite overhead, extended home office overhead, and any and all other direct and indirect expenses of whatsoever nature or kind, caused in whole or in part, as a result of any of the above-referenced occurrences. Hi-Speed's project records will be the basis for computing the additional costs and damages of Hi-Speed's labor, materials, expenses and overhead related to such changes. BUYER WARRANTS THAT THE SITE FOR DELIVERY OR INSTALLATION OF ANY GOODS AND/OR FOR THE PERFORMANCE OF ANY SERVICES SHALL BE READY AND ADEQUATE FOR HI-SPEED'S DELIVERY OF GOODS AND/OR PERFORMANCE OF SERVICES AND THAT HI-SPEED SHALL HAVE FULL ACCESS THERETO, FREE OF ALL OBSTRUCTIONS. BUYER SHALL ASSUME ALL EXTRA COSTS ASSOCIATED WITH HI-SPEED'S INABILITY TO INSTALL ANY GOODS OR PERFORM ANY SERVICES AS A RESULT OF BUYER'S FAILURE TO COMPLY WITH THIS PROVISION. HI-SPEED MAY NOT INSPECT THE SITE PRIOR TO DELIVERY AND/OR INSTALLATION OF GOODS AND/OR PERFORMANCE OF SERVICES AND MAKES NO WARRANTY AS TO THE SUFFICIENCY OF THE SITE FOR THE DELIVERY AND/OR INSTALLATION OF GOODS AND/OR THE PERFORMANCE OF SERVICES AT SUCH SITE.
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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.
12. **ABANDONED EQUIPMENT.** Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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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