



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

LR Motor Shop Repairs

**Job Number 104048**

Prepared for George's

1810 S. ST LOUIS STREET  
Batesville AR 72501

# Table of Contents

AC Inspection as Found - *LR MOTOR SHOP*

AC Inspection - Rev. 2: *5-9190B*

**1.0**

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*Table of Contents*



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

## AC Inspection as Found

George's  
1810 S. ST LOUIS STREET  
Batesville, AR 72501

FolderID: 104048  
FormID: 23130639

### AC Inspection - Rev. 2

Location: LR MOTOR SHOP

Serial Number: 5-9190B

Description: 3.0 KW DERTEC W GEARBOX

Hi-Speed Job Number: 104048

Manufacturer: Dertec

Product Number: FP2SS100L2-4B14A

Serial Number: 5-9190B

HP/kW: 3.0 (HP)

RPM: 1750 (RPM)

Voltage: 480

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

# of Leads: 6

J-box Included: Complete

Coupling/Sheave: None

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: ● 1 - High ● 12 - Good

### Overall Condition

1. Report Date

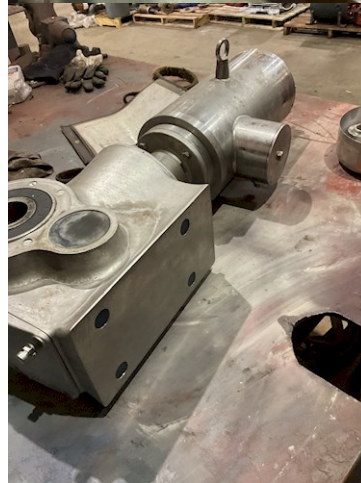
02/12/2025

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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  
*Serviceable*

**Initial Mechanical/Electrical**

<input checked="" type="radio"/>	5. Does Shaft Turn Freely?	(Y) Yes
<input checked="" type="radio"/>	6. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
<input type="radio"/>	7. Does Shaft Have Visible Damage?	(No) No
<input checked="" type="radio"/>	8. Assembled Shaft Runout	0 Inches
<input type="radio"/>	9. Assembled Shaft End Play	0 inches
<input type="radio"/>	10. Air Gap Variation <10%	na

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11. Lead Condition	(P) Pass
12. Lead Length	10 Inches
13. Does it have Lugs?, If so what is the Stud Size?	(No) No
14. Lead Numbers	1-6
15. Frame Condition	pass
16. Fan Condition	(P) Pass



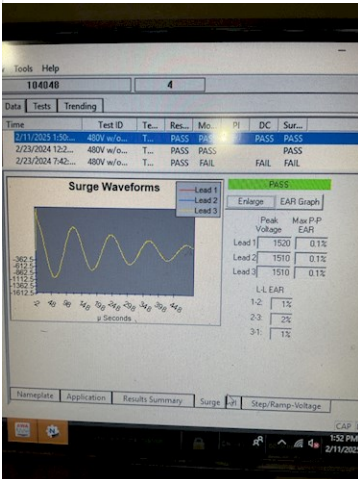
17. Broken or Missing Components	
Na	

18. Does motor have internal fan?	(No) No
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### Initial Electrical Inspection

19. Insulation Resistance/Megger	7973 Megohms	
20. Winding Resistance		
1-2	1-3	2-3
.862	.863	.859

21. Perform Surge Test	(P) Pass
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22. Number of Stator Slots	36
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23. Stator Condition

wash and dry



24. Stator Thermistors/Ohms

na

25. Stator Overloads/Ohms

Na

### Mechanical Inspection

26. Drive End Bearing Brand

NACHI

27. Drive End Bearing Number-

6306 2RS



28. Drive End Bearing Qty.

1

29. Drive End Bearing Type

(Ball) Ball Bearing

30. Drive End Lubrication Type

(Grease) Grease Lubricated

31. Drive End Bearing Insulation or Grounding Device?

na

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

Snap ring

33. Drive End Bearing Condition

 *The start of frosting*



34. Opposite Drive End Bearing Brand

**FAG**

35. Opposite Drive End Bearing Number-

**6306 2 RS**



36. Opposite Drive End Bearing Qty.

**1**

37. Opposite Drive End Bearing Type

**(Ball) Ball Bearing**

38. Opposite Drive End Lubrication Type

**(Grease) Grease 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

 *The start of frosting*





42. Drive End Seal	yes
43. Opposite Drive End Seal	yes

Rotor Inspection

44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
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45. Growler Test	(Pass) Pass
46. Number of Rotor Bars	32
47. Rotor Condition	pass



48. List the Parts needed for the Repair Below	
2-6306 2RS Bearings	

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49. Signature of Technician that Disassembled Motor

RW



### Mechanical Fits- Rotor

50. Shaft Runout **0.001 inches**

51. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

**0.002**

**0.002**

**0.002**

52. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

 **Pass**

53. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

 **Pass**

54. Drive End Bearing Shaft Fit

0 Degrees


60 Degrees

120 Degrees

**1.1814**

**1.1814**

**1.1814**

 55. Drive End Bearing Shaft Fit Condition

**(P) Pass**



56. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

**1.1815**

**1.1815**

**1.1815**

57. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass



58. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Pass

**Mechanical Fits- Bearing Housings**

59. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

2.8352

2.8352

2.8352

60. Drive End - Endbell Bearing Fit Condition

(P) Pass

61. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

2.8353

2.8353

2.8353

62. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass

63. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Na

64. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Pass

65. List Machine Work Needed Below

*In put shaft seal surface on gearbox*

66. Technician

RW

Co sign CW

**Root Cause of Failure**

67. Failure locations

*Water in con. Box and gearbox seal*

68. Root cause of failure

*Wear on shaft from seals also need an aegis ring shaft size 1.458*

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**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

**Mechanical Fits- Rotor - Post Repair**

73. Shaft Runout Post Repair

inches

74. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

75. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

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

0 Degrees

60 Degrees

120 Degrees

77. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

78. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

79. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

80. Shaft Repair Sign-off

**Assembly**

81. QC Check All Parts for Cleanliness Prior to Assembly

Trevor Hall



82. Photograph All Major Components prior to assembly







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1.11







83. Final Insulation Resistance Test	2000 Megohms	
84. Assembled Shaft Endplay	0.0005 inches	
85. Assembled Shaft Runout	0.0005 inches	
86. Test Run Voltage		
Volts	Volts	Volts
240	238	240



# 87. Test Run Amperage

Amps	Amps	Amps
4.1	3.7	3.7



# 88. Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
0.01	0.01	0.02

# 89. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
0.02	0.02	0.02

# 90. Ambient Temperature - Fahrenheit

# 91. Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes
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# 92. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes
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# 93. Document Final Condition with Pictures after paint

# 94. Final Pics and QC Review

Trevor Hall

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