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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 104829

Prepared for Huber Specialty Hydrates, LLC (11913)

4750 Alcoa Road
Bauxite AR 72011

Table of Contents



Hi-Speed Industrial Service
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AC Inspection as Found
Huber Specialty Hydrates, LLC (11913)
4750 Alcoa Road
Bauxite, AR 72011

FolderID: 104829
FormID: 25005057

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: 200 HP

Hi-Speed Job Number: 104829

Manufacturer: Reliance

HP/kW: 200 (HP)

RPM: 1800 (RPM)

Frame: 449TC

Voltage: 460

Current: 224 172 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1

Enclosure: TEFC

of Leads: 6

J-box Included: None

Coupling/Sheave: None

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:  **9 - Good**

Overall Condition

- | | |
|----------------------|------------|
| 1. Report Date | 07/16/2025 |
| 2. Nameplate Picture | |

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3. Photos of all six sides of the machine.



4. Describe the Overall Condition of the Equipment as Received

Dirty but serviceable

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?

(N) No

8. Does the shaft require T.I.R in Lathe to identify additional repairs?

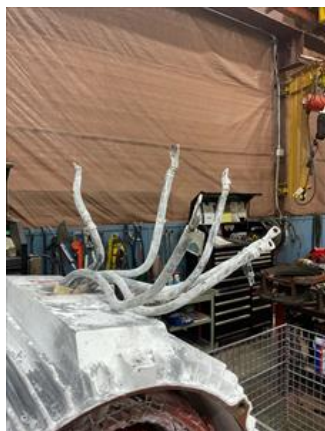
(NO) NO

9. Does Shaft Have Visible Damage?

(No) No

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10.	Assembled Shaft Runout	Inches
Na		
11.	Assembled Shaft End Play	inches
Na		
12.	Air Gap Variation <10%	
Na		
13.	Lead Condition	(P) Pass
14.	Lead Length	24 Inches
15.	Does it have Lugs?, If so what is the Stud Size?	(YES) YES



16.	Lead Numbers	1-6
17.	Are the Leads insulated with Chico or other material	(NO) NO
18.	Frame Condition	pass
19.	Fan Condition	(P) Pass

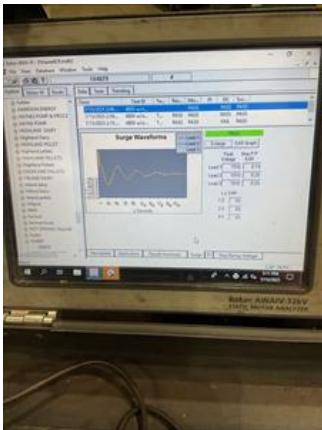
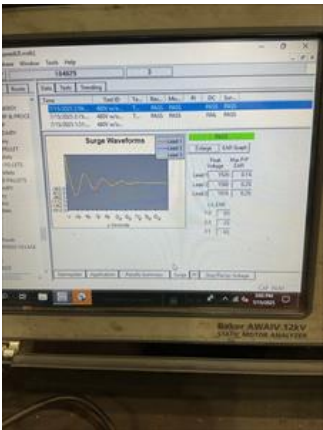


20.	Does motor have internal fan?	(NO) NO
21.	Broken or Missing Components	none
Initial Electrical Inspection		
22.	Insulation Resistance/Megger	1424 Megohms
23.	Winding Resistance	
1-2	1-3	2-3
0.0312	0.0308	0.0309

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24. Perform Surge Test

(P) Pass



High speed

Low speed

25. Number of Stator Slots	72
26. Stator Condition	wash and dry



27. Stator Thermistors/Ohms	A
28. Stator Overloads/Ohms	Na

Mechanical Inspection	
29. Drive End Bearing Brand	Fag

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30. Drive End Bearing Number-

NU222R



31. Drive End Bearing Qty.	1
32. Drive End Bearing Type	(Roller) Roller Bearing
33. Drive End Lubrication Type	(Grease) Grease Lubricated
34. Drive End Bearing Insulation or Grounding Device?	Na
35. Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
36. Drive End Bearing Condition	normal wear
37. Opposite Drive End Bearing Brand	FAG
38. Opposite Drive End Bearing Number-	6318ZZ C3



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?	Na
43. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	spacer nut
44. Opposite Drive End Bearing Condition	normal wear
45. Drive End Seal	Na
46. Opposite Drive End Seal	Na

Rotor Inspection

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47. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
48. Growler Test	(Pass) Pass
49. Number of Rotor Bars	
50. Rotor Condition	
Slid on shaft	



51. List the Parts needed for the Repair Below	
1-NU222R Roller Bearing 2-6318 2ZZ C3 BEARING	
52. Signature of Technician that Disassembled Motor	RW
	

Mechanical Fits- Rotor

53. Shaft Runout	inches		
 Check in lathe			
54. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
 Na			
55. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
 Na			
56. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
 Na			
57. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
4.3319	4.3319	4.3319	

58. Drive End Bearing Shaft Fit Condition

(P) Pass



59. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.5438

3.5438

3.5438

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

Mechanical Fits- Bearing Housings

62. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

9.4499

9.4499

9.4499

63. Drive End - Endbell Bearing Fit Condition

(P) Pass

64. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

7.4811

7.4811

7.4811

65. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass

66. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Pass

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67. End Bell Air Seal Fits	
Drive End Air Seal	Opposite Drive End Air Seal
P	
68. List Machine Work Needed Below	
<i>Push shaft back in rotor and weld</i>	
69. Technician	RW
	
Co sign CRW	



Root Cause of Failure

70. Failure locations
Rotor
71. Root cause of failure
Rotor slide on the shaft

Dynamic Balance Report

72. Rotor Weight and Balance Grade
- | | |
|--------------|---------------|
| Rotor Weight | Balance Grade |
|--------------|---------------|
73. Initial Balance Readings
- | | |
|-----------|--------------------|
| Drive End | Opposite Drive End |
|-----------|--------------------|
74. Final Balance Readings
- | | |
|-----------|--------------------|
| Drive End | Opposite Drive End |
|-----------|--------------------|
75. Technician

Rewind

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

Assembly

77. QC Check All Parts for Cleanliness Prior to Assembly
78. Photograph All Major Components prior to assembly
79. Was a Insulated bearing or end bell tested?

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80.	Final Insulation Resistance Test		
81.	Assembled Shaft Endplay		
82.	Assembled Shaft Runout		
83.	Test Run Voltage		
	Volts	Volts	Volts
84.	Test Run Amperage		
	Amps	Amps	Amps
85.	Motor RPM		
86.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
87.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
88.	Ambient Temperature - Fahrenheit		
89.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
90.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
91.	Document Final Condition with Pictures after paint		
92.	Final Pics and QC Review		



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