



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

LR Motor Shop Repairs

**Job Number 104033**

Prepared for Kiswire (12060)

5100 industrial dr. S.  
white hall ar 71602

# Table of Contents

AC Inspection as Found - *LR MOTOR SHOP*

AC Inspection - Rev. 2: *Q2-K18T0332NPI26*

**1.0**

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*Printed on 5/19/2025*

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

## AC Inspection as Found

Kiswire (12060)  
5100 industrial dr. S.  
white hall, ar 71602

FolderID: 104033  
FormID: 23095705

### AC Inspection - Rev. 2

**Location:** LR MOTOR SHOP  
**Serial Number:** Q2-K18T0332NPI26  
**Description:** 18.65 KW SIEMANS FAN  
ASSEMBLY

<b>Hi-Speed Job Number:</b>	104033
<b>Manufacturer:</b>	Siemens
<b>Serial Number:</b>	Q2-K18T0332NPI26
<b>HP/kW:</b>	18.65 (HP)
<b>Frame:</b>	NA
<b>Voltage:</b>	460
<b>Current:</b>	30 (Amps)
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b>Service Factor:</b>	1.15
<b>Enclosure:</b>	TEFC
<b># of Leads:</b>	3
<b>J-box Included:</b>	Complete
<b>Coupling/Sheave:</b>	Sheave
<b>Bearing RTDs:</b>	No
<b>Stator RTDs:</b>	No
<b>Repair Stage:</b>	Final
<b>Rewind:</b>	No
<b>Shaft Machined Fit Repairs Required:</b>	No
<b>Bearing Housing Machined Fit Repairs Required:</b>	No
<b>Heaters:</b>	No
<b>Winding Type :</b>	Random Wound
<b>Bearing Type:</b>	Rolling Element

Priorities Found: 1 - High 1 - Medium 16 - Good

### Overall Condition

1. Report Date

01/31/2025

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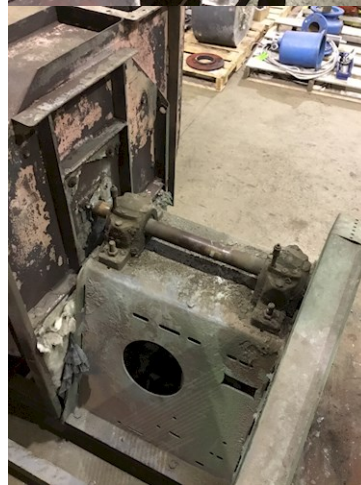
SHELDON CO. CH. 13  
NEW YORK, N.Y.  
MADE IN U.S.A.  
SHELDON CO. CH. 13

## The image contains two photographs of a large industrial machine, possibly a metalworking lathe or mill. The top photograph shows the machine from a side-on perspective, highlighting a large, light-colored electric motor mounted on a heavy metal frame. A large, dark, curved component, likely a flywheel or part of the drive mechanism, is visible on the left. The machine is situated in a workshop or factory setting, with various tools and equipment visible in the background. The bottom photograph provides a closer, more detailed view of the machine's structure, showing the motor, the frame, and a large, dark, curved component. The machine appears to be made of heavy-duty metal, with a robust and industrial design.



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1.4



Machined new shaft  
GM

Repaired damaged blower  
GM

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



Motor sheave



Fan sheave

6. Is this a UL Listed Motor	(No) No
7. Is the motor water cooled or can be pressure checked before teardown	(No) No
<b>Initial Mechanical/Electrical</b>	
8. Does Shaft Turn Freely?	(Y) Yes
9. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
10. Does Shaft Have Visible Damage?	(No) No
11. Assembled Shaft Runout	Inches
12. Assembled Shaft End Play	inches
13. Air Gap Variation <10%	
14. Lead Condition	(P) Pass
15. Lead Length	14 Inches
16. Does it have Lugs?, If so what is the Stud Size?	
Yes	
17. Lead Numbers	1-3
18. Are the Leads insulated with Chico or other material	(No) No
19. Frame Condition	pass

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20. Fan Condition	(P) Pass
21. Does motor have internal fan?	(No) No
22. Broken or Missing Components	all baffle bolts for fan and a belt cover bolt

### Initial Electrical Inspection

23. Insulation Resistance/Megger

Megohms

Coil 2 (Ohms)	0.425	Corr: 0.4...	
Coil 3 (Ohms)	0.425	Corr: 0.4...	
Megohm Stat...	PASS		No Test
Volts (V)	498		
I(μA)	0.0638		
Resist	7807		
At 40°C	2108		
PI Status	No Test		No Test
Nameplate	Application	Results Sum	

24. Winding Resistance

1-2

1-3

2-3

Test Time	12:58:07 PM	12:48:18 PM
IR Temp Com...	Thermoplastic	None
Resist Status	PASS	No Test
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.284	Corr: 0.2...
L2-L3 (Ohms)	0.284	Corr: 0.2...
L3-L1 (Ohms)	0.284	Corr: 0.2...
Max Delta R %	0.005	
Coil 1 (Ohms)	0.425	Corr: 0.4...
Coil 2 (Ohms)	0.425	Corr: 0.4...
Coil 3 (Ohms)	0.425	Corr: 0.4...
Megohm Stat...	PASS	No Test
Nameplate	Application	Results Summary

25. Perform Surge Test

(P) Pass

Tools Help			
104033	2		
Data	Tests Trending		
Test ID	480V w/RTTR-101HP Step	Edit Test ID	Enable Calibration
For	480 Volt Motors	Run Auto Test	
Temperature/Resistance Tests			
ON	Temperature	Manual	Tested
ON	Resistance	3 Lead/Low V	PASS
DC Tests			
ON	MegOhm	500 Volts	PASS
OFF	500 Volts		
ON	Step Voltage	1400 Volts	PASS
Surge Test			
ON	Surge	1500 Volts	PASS

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26. Number of Stator Slots	48
27. Stator Condition	pass
28. Stator Thermistors/Ohms	
29. Stator Overloads/Ohms	

### Mechanical Inspection

30. Drive End Bearing Brand	ORS
-----------------------------	-----



31. Drive End Bearing Number-	6310
32. Drive End Bearing Qty.	1
33. Drive End Bearing Type	(Ball) Ball Bearing
34. Drive End Lubrication Type	(Grease) Grease Lubricated
35. Drive End Bearing Insulation or Grounding Device?	
36. Drive End Wavy Washer/Snap-Ring Other Retention Device?	
37. Drive End Bearing Condition	

Signs of frosting



38. Opposite Drive End Bearing Brand	ORS
--------------------------------------	-----



39. Opposite Drive End Bearing Number-	<b>6310</b>
40. Opposite Drive End Bearing Qty.	<b>1</b>
41. Opposite Drive End Bearing Type	<b>(Ball) Ball Bearing</b>
42. Opposite Drive End Lubrication Type	<b>(Grease) Grease Lubricated</b>
43. Opposite Drive End Bearing Insulation or Grounding Device?	
44. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	
<input type="checkbox"/> <i>Wavy washer</i>	
45. Opposite Drive End Bearing Condition	
<input type="checkbox"/> <i>Signs of frosting</i>	



46. Drive End Seal	
47. Opposite Drive End Seal	
<b>Rotor Inspection</b>	
48. Rotor Type/Material	<b>(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast</b>
49. Growler Test	<b>(Pass) Pass</b>
50. Number of Rotor Bars	<b>40</b>
51. Rotor Condition	<b>pass</b>
52. List the Parts needed for the Repair Below	
<i>6310x2</i> <i>SKF- SE/512/610 X2 Pillar block bearings</i> <i>Aegis ring</i>	

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53. Signature of Technician that Disassembled Motor

Cw



#### Mechanical Fits- Rotor

54. Shaft Runout inches

55. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

56. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

57. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

58. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.9690-1.9690-1.9689

59. Drive End Bearing Shaft Fit Condition

(P) Pass

60. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.9688-1.9688-1.9688

61. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass

62. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

#### Mechanical Fits- Bearing Housings

63. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

4.3314-4.3315-4.3315

64. Drive End - Endbell Bearing Fit Condition

(P) Pass

65. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

4.3317-4.3318-4.4418

66. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass

67. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Pass

68. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

69. List Machine Work Needed Below

*Aegis ring installment*

70. Technician

Crw



Co sign: RRW

### Root Cause of Failure

71. Failure locations

*Bearings, and fan shaft and shives*

72. Root cause of failure

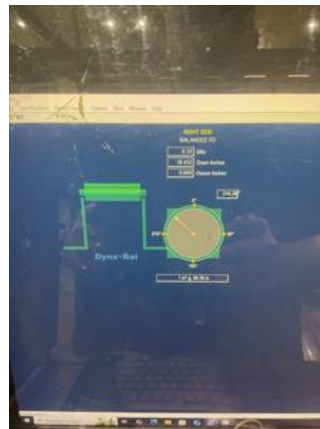
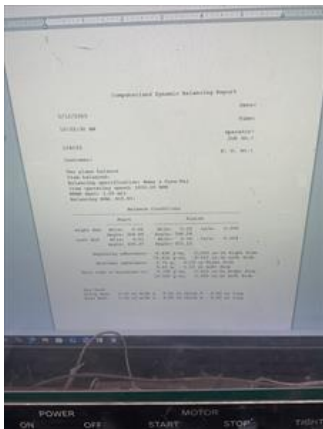
*Wear and electrical discharge*

### Dynamic Balance Report

73. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



Motor

Fan started at 16.9 mills

74. Initial Balance Readings

Drive End

Opposite Drive End

0.02

0.81

75. Final Balance Readings

Drive End

Opposite Drive End

0.02

0.20

76. Technician

RW



Assembly

77. QC Check All Parts for Cleanliness Prior to Assembly

RW

*[Handwritten signature]*

78. Photograph All Major Components prior to assembly

(Complete) Complete







79. Final Insulation Resistance Test

**2,100 Megohms**

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80. Assembled Shaft Endplay	0 inches	
81. Assembled Shaft Runout	0 inches	
82. Test Run Voltage		
Volts	Volts	Volts
455	455	455



Co sign CRW



Unit

83. Test Run Amperage

Amps

11.1

Amps

11.2

Amps

10.8



Motor

Unit

84. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

85. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

86. Ambient Temperature - Fahrenheit

87. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

88. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

89. Document Final Condition with Pictures after paint



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90. Final Pics and QC Review

RW

Co sign: CRW



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