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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 104171**

Prepared for Premier Technical Plastics

2120 Queensway  
Searcy Arkan 72143

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

**AC Inspection as Found**  
**Premier Technical Plastics**  
2120 Queensway  
Searcy, Arkan 72143

FolderID: 104171  
FormID: 23442560

**AC Inspection - Rev. 2**

**Location:** LR Motor Shop  
**Serial Number:** 1PC31042AA500FB4  
**Description:** 50 HP SIEMANS

<b>Hi-Speed Job Number:</b>	104171
<b>Manufacturer:</b>	Siemens
<b>Product Number:</b>	1AV3205A
<b>Serial Number:</b>	1PC31042AA500FB4
<b>HP/kW:</b>	50 (HP)
<b>RPM:</b>	3565 (RPM)
<b>Frame:</b>	155
<b>Voltage:</b>	460
<b>Current:</b>	60 (Amps)
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b># of Leads:</b>	6
<b>J-box Included:</b>	Half
<b>Coupling/Sheave:</b>	None
<b>Date Received:</b>	02/21/2025
<b>Bearing RTDs:</b>	No
<b>Stator RTDs:</b>	No
<b>Repair Stage:</b>	Final
<b>Rewind:</b>	Yes
<b>Shaft Machined Fit Repairs Required:</b>	Yes
<b>Bearing Housing Machined Fit Repairs Required:</b>	Yes
<b>Heaters:</b>	No
<b>Winding Type :</b>	Random Wound
<b>Bearing Type:</b>	Rolling Element

Priorities Found: ● 6 - High ● 6 - Good

**Overall Condition**

1. Report Date

**02/21/2025**

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Printed on 3/31/2025

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1.0

## 2. Nameplate Picture



## 3. Photos of all six sides of the machine.



## 4. Describe the Overall Condition of the Equipment as Received

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### Initial Mechanical/Electrical

5.	Does Shaft Turn Freely?	(N) No
6.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(Yes) Yes
7.	Does Shaft Have Visible Damage?	(Yes) Yes
8.	Assembled Shaft Runout	Inches
9.	Assembled Shaft End Play	inches
10.	Air Gap Variation <10%	
11.	Lead Condition	(P) Pass
12.	Lead Length	55 Inches
13.	Does it have Lugs?, If so what is the Stud Size?	(No) No
14.	Lead Numbers	1-6
15.	Frame Condition	good
16.	Fan Condition	(F) Fail



17.	Does motor have internal fan?	(No) No
18.	Broken or Missing Components	external fan melted

### Initial Electrical Inspection

19.	Insulation Resistance/Megger	Megohms
20.	Winding Resistance	
	1-2	1-3
		2-3
	Bad	
21.	Perform Surge Test	(F) Fail

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22. Number of Stator Slots	36
23. Stator Condition	shorted in slot
24. Stator Thermistors/Ohms	na
25. Stator Overloads/Ohms	na
<b>Mechanical Inspection</b>	
26. Drive End Bearing Brand	
27. Drive End Bearing Number-	6312
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?	wavy washer
33. Drive End Bearing Condition	normal wear



34. Opposite Drive End Bearing Brand	
35. Opposite Drive End Bearing Number-	6212
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?	na
41. Opposite Drive End Bearing Condition	bad

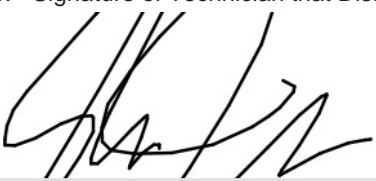


42. Drive End Seal	
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43. Opposite Drive End Seal	shaft size 2.3595 housing OD		
<b>Rotor Inspection</b>			
44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast		
45. Growler Test	(Pass) Pass		
46. Number of Rotor Bars	22		
47. Rotor Condition	good		
48. List the Parts needed for the Repair Below			
1-6312			
1-6212			
Seal is endbell shaft size 2.3595 housing size 3.148			
49. Signature of Technician that Disassembled Motor	Shin Jones		
			
<b>Mechanical Fits- Rotor</b>			
50. Shaft Runout	inches		
51. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
52. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
53. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
54. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.3625	2.3626	2.3623	
55. Drive End Bearing Shaft Fit Condition	(P) Pass		
56. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
<input type="checkbox"/> Bad			
57. Opposite Drive End Bearing Shaft Fit Condition	(F) Fail		

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58.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings			
59.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	5.1183	5.1184	5.1184
	Good		
	60.	Drive End - Endbell Bearing Fit Condition	(P) Pass
	61.	Opposite Drive End - Endbell Bearing Fit	
	0 Degrees	60 Degrees	120 Degrees
	Bad		
	62.	Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail
	63.	Bearing Cap Condition	
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	



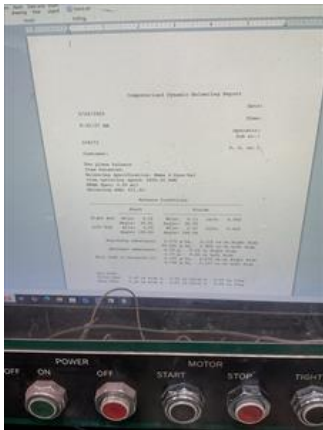
64.	End Bell Air Seal Fits	
	Drive End Air Seal	Opposite Drive End Air Seal
65.	List Machine Work Needed Below	
	<i>Ode end bell housing and air fit, ode shaft journal,</i>	
66.	Technician	
Root Cause of Failure		
67.	Failure locations	
	<i>Opposite drive end bell hosing and air fit. Opposite drive end shaft journal. Opposite drive end bearing cap. External fan.opposite drive end seal.</i>	
68.	Root cause of failure	
	<i>Blown in slot-winding</i>	
Dynamic Balance Report		



## 69. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



## 70. Initial Balance Readings

Drive End

Opposite Drive End

0.16

0.59

## 71. Final Balance Readings

Drive End

Opposite Drive End

0.11

0.07

## 72. Technician

RW

## 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

(Pass) Pass

## 79. Post Rewind Hi-Pot

micro-amps

## 80. Technician

## Mechanical Fits- Rotor - Post Repair

## 81. Shaft Runout Post Repair

inches

0.0005

82. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0.001		
83. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
84. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
85. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
86. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
2.3627	2.3627	2.3627



87. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	



88. Shaft Repair Sign-off	RW
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### Mechanical Fits- Bearing Housings - Post Repair

89. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

90. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

4.3316

4.3316

4.3316

91. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

 Pass

92. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

 Pass

93. End Bell Repair Sign-off

RW



### Assembly

94. QC Check All Parts for Cleanliness Prior to Assembly

RW



95. Photograph All Major Components prior to assembly

(Complete) Complete



96. Final Insulation Resistance Test

11,300 Megohms



97. Assembled Shaft Endplay

0 inches

98. Assembled Shaft Runout

inches

.0006

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99. Test Run Voltage		
Volts	Volts	Volts
<b>458</b>	<b>455</b>	<b>457</b>



Co sign CRW

100. Test Run Amperage		
Amps	Amps	Amps
<b>24.7</b>	<b>24.1</b>	<b>23.2</b>



101. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
<b>0.04</b>	<b>0.03</b>	<b>0.04</b>
102. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
<b>0.05</b>	<b>0.04</b>	<b>0.04</b>
103. Ambient Temperature - Fahrenheit		
104. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
105. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
106. Document Final Condition with Pictures after paint		

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107. Final Pics and QC Review

RW

A large, handwritten signature in black ink, appearing to be 'RW' followed by a checkmark-like flourish.



Co sign CRW





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7030 Ryburn Dr  
Millington, Tn 38053  
901-873-5300

## AC Random Coil Rewind Report

FolderID: 104171  
FormID: 23730597

### Premier Technical Plastics

2120 Queensway  
Searcy, Arkan 72143

LR Motor Shop

Priorities Found: 4 - Good

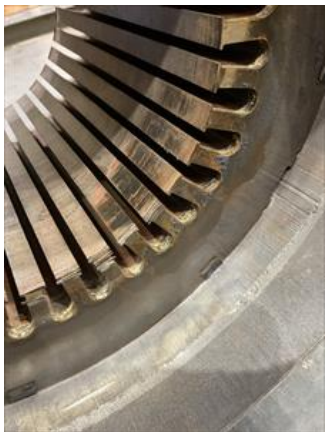
General	
1. Job Number	104171
2. Report Date	03/13/2025
3. Customer	Premier Technical Plastics
Stator Winding	
4. Core Length	8.75 "
5. Core ID	7 "
6. Back Iron Depth	1.875 "
7. Slot Depth	1 "
8. Tooth Width	0.25 "
9. Number of Vents	
10. Vent Width	
11. Before Burnout Core loss	(P) Pass
12. Flux Before Burnout	
13. Watts before burnout	
14. Watts loss per lb. before burnout	1.51 W/lbs.
15. After Burnout Core Loss	(P) Pass
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	1.029 W/lbs.
19. Core Iron Condition	
20. RTD's	(N) No
21. RTD's Reading	
22. Motor Heaters	(N) No
23. Heater Qty.	
24. Heater Voltage	
25. Heater Wattage	
26. Thermistors	(N) No
27. Number of Poles	2
28. Slots	36
29. Number of Coils	18
30. Coil Weight	
31. Lead Markings	
1-6	
32. Grouping	
6 GROUPS 3	
33. Multiple Wires	(Y) Yes

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34. Wire Size	
6# 1.120	
7# 1.000	
35. Turns per coil	10
36. Pitch 1 to:	
14-16-18	
37. Connection	
1 WYE 1 DELTA	
38. Lead Length	56 "
39. Lead Size	6
40. Number of Leads	6
41. Megger Reading After Rewind	23828 Mohms
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	0.022 Ua
46. Surge Pattern After Rewind	(P) Pass



47. Service Technician	
OPP. Conn. 3.375	
Conn end 3.5	



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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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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.
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.
15. **ASSIGNMENT.** The rights and obligations of the parties shall neither be assigned nor delegated without the prior written consent of the other party. However, any party may assign or delegate its respective rights and obligations, in whole or in part, (i) to any subsidiary, (ii) pursuant to other financing, merger or reorganization or (iii) pursuant to any sale or transfer of substantially all of the assets of the assigning party. These Standard Terms and Conditions shall bind the heirs, successors and assigns of the parties hereto.
16. **NO INDIVIDUAL LIABILITY.** Notwithstanding any other agreement to the contrary, the Buyer agrees that in no event will the Buyer hold and Hi-Speed owner, director, officer or employee personally liable for unintentional tortious conduct or conduct that constitutes the breach of any contract between Hi-Speed and the Buyer, even if the Hi-Speed owner, director, officer or employee is or could be construed to be a party to such contract.