



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

LR Motor Shop Repairs

**Job Number 105016**

Prepared for Process & Power

1625 East 145th Street  
Little Rock AR 72206

# Table of Contents



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

## AC Inspection as Found

**Process & Power**  
 1625 East 145th Street  
 Little Rock, AR 72206

FolderID: 105016  
 FormID: 25442743

### AC Inspection - Rev. 2

**Location:** MOTOR SHOP LR

**Serial Number:** 47786950001

**Description:** 125HP INGEROLL-RAND

**Hi-Speed Job Number:** 105016

**Manufacturer:** Ingersoll-Rand

**Product Number:** M: TE1BFOZO

**Serial Number:** 47786950001

**HP/kW:** 125 (HP)

**RPM:** 1790 (RPM)

**Frame:** 208S/M

**Voltage:** 460

**Current:** 245 (Amps)

**Phase:** Three

**Hz:** 60 (Hz)

**Service Factor:** 1.21

**Enclosure:** TEFC

**# of Leads:** 6

**J-box Included:** Half

**Coupling/Sheave:** None

**Bearing RTDs:** No

**Stator RTDs:** No

**Repair Stage:** Final

**Rewind:** Yes

**Shaft Machined Fit Repairs  
 Required:** Yes

**Bearing Housing Machined  
 Fit Repairs Required:** Yes

**Heaters:** No

**Winding Type :** Random Wound

**Bearing Type:** Rolling Element

Priorities Found: ● 5 - High ● 5 - Good

### Overall Condition

1. Report Date

08/08/2025

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2. Nameplate Picture



3. Photos of all six sides of the machine.



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4. Describe the Overall Condition of the Equipment as Received	
<i>Serviceable</i>	
5. Is this a UL Listed Motor	(NO) NO
6. Is the motor water cooled or can be pressure checked before teardown	(NO) NO
<b>Initial Mechanical/Electrical</b>	
● 7. Does Shaft Turn Freely?	(Y) Yes
8. Does the shaft require T.I.R in Lathe to identify additional repairs?	(NO) NO
9. Does Shaft Have Visible Damage?	(No) No
● 10. Assembled Shaft Runout	0.0004 Inches
11. Assembled Shaft End Play	inches
12. Air Gap Variation <10%	
● 13. Lead Condition	(P) Pass



14. Lead Length	90 Inches
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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	broken bolt in ode end bell

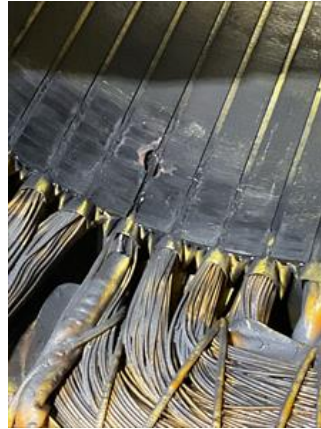
**Initial Electrical Inspection**

22. Insulation Resistance/Megger	0 Megohms
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23. Winding Resistance	1-2	1-3	2-3
 Fail			
 24. Perform Surge Test			(F) Fail
25. Number of Stator Slots			48
26. Stator Condition			rewind
 Core repair			



27. Stator Thermistors/Ohms			na
28. Stator Overloads/Ohms			na
<b>Mechanical Inspection</b>			
29. Drive End Bearing Brand			SKF

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30. Drive End Bearing Number-

6319 M/C4



31. Drive End Bearing Qty.	1
32. Drive End Bearing Type	(Ball) Ball 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?	na
36. Drive End Bearing Condition	contaminated grease



37. Opposite Drive End Bearing Brand	NSK
38. Opposite Drive End Bearing Number-	6316 C3



39. Opposite Drive End Bearing Qty.	1
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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?	Snap ring
44. Opposite Drive End Bearing Condition	water contamination in grease



45. Drive End Seal	na
46. Opposite Drive End Seal	na
<b>Rotor Inspection</b>	
47. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
48. Growler Test	(Pass) Pass
49. Number of Rotor Bars	40
50. Rotor Condition	pass



51. List the Parts needed for the Repair Below 1-6319 C4 2-6316 C3 New shaft	
52. Signature of Technician that Disassembled Motor	RW

**Mechanical Fits- Rotor**

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53. Shaft Runout			<b>inches</b>
54. Rotor Runout			
Drive End Bearing Fit	Rotor Body		Opposite Drive End Bearing
55. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees		120 Degrees
56. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees		120 Degrees
57. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees		120 Degrees

Bad



58. Drive End Bearing Shaft Fit Condition			<b>(F) Fail</b>
59. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees		120 Degrees
<b>3.1499</b>	<b>3.1499</b>		<b>3.1499</b>
60. Opposite Drive End Bearing Shaft Fit Condition			<b>(P) Pass</b>



61. Shaft Air Seal Fits		
Drive End Air Seal		Opposite Drive End Air Seal

Pass

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## Mechanical Fits- Bearing Housings

62. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

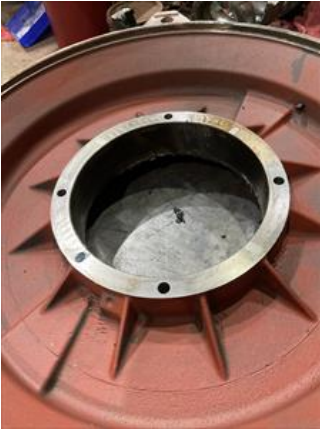
**7.875**

**7.875**

**7.875**

63. Drive End - Endbell Bearing Fit Condition

**(P) Pass**



64. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

**6.694**

**6.694**

**6.694**



65. Opposite Drive End - Endbell Bearing Fit Condition

**(F) Fail**

66. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

**pass**

**pass**

67. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

**Pass**

68. List Machine Work Needed Below

*New shaft*

69. Technician

**RW**

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Co sign: TRH

### Root Cause of Failure

70. Failure locations

*De shaft bearing fit went down and the rotor drug the iron shorting winding*



71. Root cause of failure

*Grease contamination*

### 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. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

77. Core Hot Spot Test

Pre-Burnout

Post-Burnout

78. Post Rewind Electrical Test- Insulation Resistance

79. Post Rewind Polarization Index

80. Post Rewind Winding Resistance

1-2

1-3

2-3

81. Post Rewind Surge Test

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82.	THERMAL DETECTION EQUIPMENT FINAL TESTING - RTD'S/KLIXONS/THERMISTORS		
83.	Post Rewind Hi-Pot		
84.	Technician		
<b>Mechanical Fits- Rotor - Post Repair</b>			
85.	Shaft Runout Post Repair		
86.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
87.	Coupling Fit Closest to Bearing Housing Post Repair		
	0 Degrees	90 Degrees	120 Degrees
88.	Coupling Fit Closest to the end of the Shaft Post Repair		
	0 Degrees	60 Degrees	120 Degrees
89.	Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
90.	Opposite Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
91.	Shaft Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
92.	Shaft Repair Sign-off		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>			
93.	Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
94.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
95.	Bearing Cap Condition Post Repair		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
96.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
97.	End Bell Repair Sign-off		
<b>Assembly</b>			
98.	QC Check All Parts for Cleanliness Prior to Assembly		
99.	Photograph All Major Components prior to assembly		
100.	Was a Insulated bearing or end bell tested?		
101.	Final Insulation Resistance Test		
102.	Assembled Shaft Endplay		
103.	Assembled Shaft Runout		
104.	Test Run Voltage		
	Volts	Volts	Volts

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105. Test Run Amperage			
Amps	Amps	Amps	
106. Motor RPM			
107. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
108. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
109. Ambient Temperature - Fahrenheit			
110. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
111. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
112. Document Final Condition with Pictures after paint			
113. Final Pics and QC Review			

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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, earth quake, 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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