



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

LR Motor Shop Repairs

Job Number 104890

Prepared for Reynolds Metals company

1333 highway 270
Malvern AR 72104

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

AC Inspection as Found

Reynolds Metals company

1333 highway 270

Malvern, AR 72104

FolderID: 104890

FormID: 25126974

AC Inspection - Rev. 2

Location: LR MOTOR SHOP

Serial Number: 51-378-624-007-9

Description: 125 HP SIEMENS

Hi-Speed Job Number: 104890

Manufacturer: Siemens

Product Number: TYPE-RGZCH

Serial Number: 51-378-624-007-9

HP/kW: 125 (HP)

RPM: 1775 (RPM)

Frame: 444T

Voltage: 460

Current: 143 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

of Leads: 3

J-box Included: None

Coupling/Sheave: None

Date Received: 07/14/2025

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: Yes

Shaft Machined Fit Repairs
Required: No

Bearing Housing Machined
Fit Repairs Required: Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 1 - High ● 12 - Good

Overall Condition

1. Report Date

07/16/2025

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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	
	<i>Used</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
Initial Mechanical/Electrical		
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 Inches
11.	Assembled Shaft End Play	inches
12.	Air Gap Variation <10%	
13.	Lead Condition	
14.	Lead Length	24 Inches
15.	Does it have Lugs?, If so what is the Stud Size?	(YES) YES
	1/2 eyelet	
16.	Lead Numbers	1-3
17.	Are the Leads insulated with Chico or other material	(YES) YES
18.	Frame Condition	good
19.	Fan Condition	(P) Pass
20.	Does motor have internal fan?	(NO) NO
21.	Broken or Missing Components	

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Initial Electrical Inspection

22. Insulation Resistance/Megger	2310 Megohms	
23. Winding Resistance		
1-2	1-3	2-3
.35	.35	.35
24. Perform Surge Test	(P) Pass	
25. Number of Stator Slots	60	
26. Stator Condition	good	
27. Stator Thermistors/Ohms		
28. Stator Overloads/Ohms		

Mechanical Inspection

29. Drive End Bearing Brand	SKF
30. Drive End Bearing Number-	6318zz
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?	none
35. Drive End Wavy Washer/Snap-Ring Other Retention Device?	bearing cap
36. Drive End Bearing Condition	



37. Opposite Drive End Bearing Brand	SKF
38. Opposite Drive End Bearing Number-	6313
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?	none
43. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	bearing cap

44. Opposite Drive End Bearing Condition

 Metal fatigue - caused by false breneling



45. Drive End Seal

46. Opposite Drive End Seal none

Rotor Inspection

47. Rotor Type/Material (Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast

48. Growler Test (Pass) Pass

49. Number of Rotor Bars 47

50. Rotor Condition good

51. List the Parts needed for the Repair Below

52. Signature of Technician that Disassembled Motor

Mechanical Fits- Rotor

53. Shaft Runout 0 inches

54. Rotor Runout


Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0	0	0

55. Coupling Fit Closest to Bearing Housing

0 Degrees	90 Degrees	120 Degrees
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56. Coupling Fit Closest to the end of the Shaft

0 Degrees	60 Degrees	120 Degrees
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 57. Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
3.54	3.54	3.54

 58. Drive End Bearing Shaft Fit Condition (P) Pass

59. Opposite Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
2.55	2.55	2.55


 60. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

61. Shaft Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal
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Mechanical Fits- Bearing Housings

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62.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	7.49	7.49	7.49
63.	Drive End - Endbell Bearing Fit Condition		(F) Fail
64.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	5.51	5.51	5.51
65.	Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
66.	Bearing Cap Condition		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	good	good	
67.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
68.	List Machine Work Needed Below <i>DE bearing housing</i>		
69.	Technician 		
Root Cause of Failure			
70.	Failure locations <i>Bearings</i> <i>Insulation system</i>		
71.	Root cause of failure <i>False breneeling in ode bearing</i> <i>Insulation system of winding brittle/aged recommend rewind or no warranty on winding.</i>		
Dynamic Balance Report			
72.	Rotor Weight and Balance Grade		
	Rotor Weight	Balance Grade	

73. Initial Balance Readings

Drive End

.36

Opposite Drive End

.77



Rotor

Rotor ad fan

74. Final Balance Readings

Drive End

.29

Opposite Drive End

.17



With fan .36

Rotor



75. Technician

Terrence Holland

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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

Megohms

79. Post Rewind Polarization Index

Polarization Index

80. Post Rewind Winding Resistance

1-2

1-3

2-3

81. Post Rewind Surge Test

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

83. Post Rewind Hi-Pot

micro-amps

84. Technician

Mechanical Fits- Bearing Housings - Post Repair

85. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

86. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

87. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

88. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

89. End Bell Repair Sign-off

Assembly

90. QC Check All Parts for Cleanliness Prior to Assembly

RW



91. Photograph All Major Components prior to assembly

(Complete) Complete



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92. Was a Insulated bearing or end bell tested?	(NA) Not Applicable
93. Final Insulation Resistance Test	4,549 Megohms



94. Assembled Shaft Endplay	0.0001 inches	
95. Assembled Shaft Runout	0.0001 inches	
96. Test Run Voltage		
Volts	Volts	Volts
463	460	466



Co sign CRW

97. Test Run Amperage			
Amps	Amps	Amps	
37.7	34.5	35.1	



98. Motor RPM			1798
99. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
0.04	0.070000000000000001	0.02	
100. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
0.02	0.04	0.01	
101. Ambient Temperature - Fahrenheit			
102. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
103. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
104. Document Final Condition with Pictures after paint			



105. Final Pics and QC Review

RW

Co sign TRH



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

AC Random Coil Rewind Report

FolderID: 104890
FormID: 25178079

Reynolds Metals company

1333 highway 270
Malvern, AR 72104

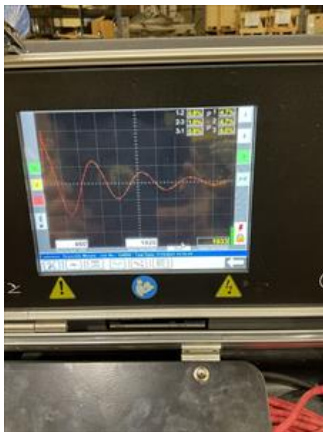
LR MOTOR SHOP

Priorities Found: ● 5 - Good

General	
1. Job Number	104890
2. Report Date	07/18/2025
3. Customer	Renyolds Metals
Stator Winding	
4. Core Length	9 "
5. Core ID	12.5 "
6. Back Iron Depth	1.5 "
7. Slot Depth	1.75 "
8. Tooth Width	0.3125 "
9. Number of Vents	
10. Vent Width	"
● 11. Before Burnout Core loss	(P) Pass
12. Flux Before Burnout	
13. Watts before burnout	Watts
14. Watts loss per lb. before burnout	1.17 W/lbs.
● 15. After Burnout Core Loss	(P) Pass
16. Flux After burnout	
17. Watts After Burnout	Watts
18. Watts loss per lb After Burnout	1.139 W/lbs.
● 19. Core Iron Condition	(P) Pass
20. RTD's	
21. RTD's Reading	Ohm's
● 22. Motor Heaters	(N) No
23. Heater Qty.	
24. Heater Voltage	Volts
25. Heater Wattage	Watts
26. Thermistors	
27. Number of Poles	4
28. Slots	60
29. Number of Coils	60
30. Coil Weight	Lbs.
31. Lead Markings	
1-3	
32. Grouping	
12g of 5c	
33. Multiple Wires	

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34. Wire Size	
3 #16	
4 #17	
35. Turns per coil	16
36. Pitch 1 to:	12
37. Connection	
4 delta	
38. Lead Length	18 "
39. Lead Size	1/0
40. Number of Leads	3
41. Megger Reading After Rewind	1845 Mohms
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	0.55 Ua
46. Surge Pattern After Rewind	(P) Pass



47. Service Technician

190 lbs total copper wire
 100 lbs #16 awg
 90lbs #17 awg
 1/0 exar lead wire 25' 600v
 1 can dry release spray
 1 can clear insulating varnish
 3 - 1/0 lug 3/8 eyelet



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