



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

LR Motor Shop Repairs

Job Number 103893

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: 103893
FormID: 22642395

AC Inspection - Rev. 2

Location: LITTLE ROCK MOTOR SHOP

Serial Number:

Description: 25 HP

Hi-Speed Job Number: 103893

Manufacturer: GE

HP/kW: 25 (HP)

RPM: 1765 (RPM)

Frame: 284T

Voltage: 460

Current: 30 (Amps)

Phase: Three

Enclosure: TEFC

of Leads: 3

J-box Included: Complete

Coupling/Sheave: Coupling

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: Yes

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: ● 1 - High ● 12 - Good

Overall Condition

1. Report Date
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

Serviceable

5. Distance from the end of the shaft to the Coupling/Sheave

inches

Flush

Initial Mechanical/Electrical

| | |
|--|--------------|
| 6. Does Shaft Turn Freely? | (Y) Yes |
| 7. Does the shaft require T.I.R in Lathe to identify additional repairs? | (No) No |
| 8. Does Shaft Have Visible Damage? | (No) No |
| 9. Assembled Shaft Runout | 0.002 Inches |
| 10. Assembled Shaft End Play | inches |
| 11. Air Gap Variation <10% | |
| 12. Lead Condition | (P) Pass |
| 13. Lead Length | 6 Inches |
| 14. Does it have Lugs?, If so what is the Stud Size? | (No) No |
| 15. Lead Numbers | 1-3 |
| 16. Frame Condition | pass |
| 17. Fan Condition | (P) Pass |



18. Broken or Missing Components

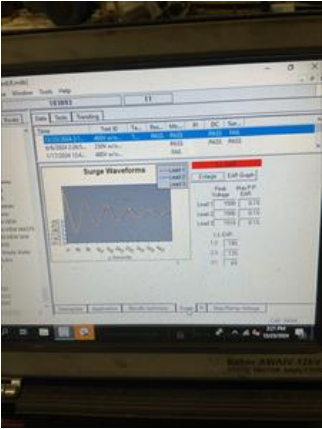


None

Initial Electrical Inspection

19. Insulation Resistance/Megger

7564 Megohms

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| | | |
|---|------|----------|
| 20. Winding Resistance | | |
| 1-2 | 1-3 | 2-3 |
| .448 | .448 | .448 |
| 21. Perform Surge Test | | (F) Fail |
|  | | |
| 22. Number of Stator Slots | | 48 |
| 23. Stator Condition | | rewind |
| <div>   </div> | | |
| 24. Stator Thermistors/Ohms | Na | |
| 25. Stator Overloads/Ohms | Na | |
| Mechanical Inspection | | |
| 26. Drive End Bearing Brand | | NTN |

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27. Drive End Bearing Number-

6310C3



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? na

33. Drive End Bearing Condition


Normal wear



34. Opposite Drive End Bearing Brand KOYO

35. Opposite Drive End Bearing Number- 6207C3



| | |
|--|----------------------------|
| 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 | |
| <div>  Normal wear </div> | |



| | |
|-----------------------------|--|
| 42. Drive End Seal | na |
| 43. Opposite Drive End Seal | na |
| Rotor Inspection | |
| 44. Rotor Type/Material | (Squirrel Aluminum) Squirrel Cage Aluminum Die Cast |
| 45. Growler Test | (Pass) Pass |
| 46. Number of Rotor Bars | 40 |



48. List the Parts needed for the Repair Below

1-6310 Bearing 2-6207 Bearing

49. Signature of Technician that Disassembled Motor

RW

Mechanical Fits- Rotor50. Shaft Runout **0 inches**

51. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0**0****0**

52. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

Na

53. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

Na

54. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.9686**1.9686****1.9686**

55. Drive End Bearing Shaft Fit Condition

(P) Pass



56. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.3781

1.3781

1.3781

57. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass



58. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

pass


Mechanical Fits- Bearing Housings

| | | |
|-------------------------------------|------------|-------------|
| 59. Drive End - Endbell Bearing Fit | | |
| 0 Degrees | 60 Degrees | 120 Degrees |
| 4.3314 | 4.3314 | 4.3314 |



| | | |
|--|------------|-------------|
| 60. Drive End - Endbell Bearing Fit Condition | (P) Pass | |
| 61. Opposite Drive End - Endbell Bearing Fit | | |
| 0 Degrees | 60 Degrees | 120 Degrees |
| 2.8352 | 2.8352 | 2.8352 |
| 62. Opposite Drive End - Endbell Bearing Fit Condition | (P) Pass | |



| | | |
|---|--------------------------------|----|
| 63. Bearing Cap Condition | | |
| Drive End Bearing Cap | Opposite Drive End Bearing Cap | |
| pass | pass | |
| 64. End Bell Air Seal Fits | | |
| Drive End Air Seal | Opposite Drive End Air Seal | |
| pass | | |
| 65. List Machine Work Needed Below | | |
| None | | |
| 66. Technician | | RW |
|  | | |
| Co sign TRH | | |

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Root Cause of Failure

67. Failure locations

Winding

68. Root cause of failure

Insulation breaking down

Dynamic Balance Report

69. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

70. Initial Balance Readings

Drive End

Opposite Drive End

71. Final Balance Readings

Drive End

Opposite Drive End



72. Technician

Cw

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

79. Post Rewind Hi-Pot

micro-amps

80. Technician

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Assembly

81. QC Check All Parts for Cleanliness Prior to Assembly

Cw



82. Photograph All Major Components prior to assembly

(Complete) Complete



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| | | |
|---|--------------|-------|
| 83. Final Insulation Resistance Test | Megohms | |
| 84. Assembled Shaft Endplay | inches | |
| 85. Assembled Shaft Runout | 0.002 inches | |
| 86. Test Run Voltage | | |
| Volts | Volts | Volts |
| <div> <div></div> <div>Witnessed by TH</div> </div> | | |



| | | |
|-----------------------|------|------|
| 87. Test Run Amperage | | |
| Amps | Amps | Amps |



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| | | |
|---|-------------|-------------|
| 88. Drive End Vibration Readings - Inches Per Second | | |
| Horizontal | Vertical | Axial |
| 0.05 | 0.02 | 0.03 |
| 89. Opposite Drive End Vibration Readings - Inches Per Second | | |
| Horizontal | Vertical | Axial |
| 0.04 | 0.03 | 0.03 |
| 90. Ambient Temperature - Fahrenheit | | |
| 91. Drive End Bearing Temps - Fahrenheit | | |
| 5 Minutes | 10 Minutes | 15 Minutes |
| 92. Opposite Drive End Bearing Temps - Fahrenheit | | |
| 5 Minutes | 10 Minutes | 15 Minutes |
| 93. Document Final Condition with Pictures after paint | | |



94. Final Pics and QC Review

Cw

[Handwritten signature]

Co sign TRH



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

AC Random Coil Rewind Report

FolderID: 103893
FormID: 22841026

Reynolds Metals company

1333 highway 270

Malvern, AR 72104

LITTLE ROCK MOTOR SHOP

Priorities Found: ● 5 - Good

| General | |
|---|--------------|
| 1. Job Number | 103893 |
| 2. Report Date | |
| 3. Customer | Reynold |
| Stator Winding | |
| 4. Core Length | 5.5 " |
| 5. Core ID | 7.75 " |
| 6. Back Iron Depth | 1.125 " |
| 7. Slot Depth | 0.875 " |
| 8. Tooth Width | 0.258 " |
| 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 | 2.356 W/lbs. |
| ● 15. After Burnout Core Loss | (P) Pass |
| 16. Flux After burnout | |
| 17. Watts After Burnout | 1.62 Watts |
| 18. Watts loss per lb After Burnout | W/lbs. |
| ● 19. Core Iron Condition | (P) Pass |
| 20. RTD's | |
| 21. RTD's Reading | |
| 22. Motor Heaters | |
| 23. Heater Qty. | |
| 24. Heater Voltage | |
| 25. Heater Wattage | |
| 26. Thermistors | |
| 27. Number of Poles | 4 |
| 28. Slots | 48 |
| 29. Number of Coils | 48 |
| 30. Coil Weight | Lbs. |
| 31. Lead Markings | |
| 32. Grouping | |
| 12 of 4 | |
| ● 33. Multiple Wires | (Y) Yes |

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| | |
|--------------------|-------------------------------|
| 34. Wire Size | 1#18&1#19 |
| 35. Turns per coil | 6-18-26-36 6-8-10-12 Pitch |
| 36. Pitch 1 to: | 6-8-10-12 |
| 37. Connection | 2 Delta |



| | |
|---------------------------------|------------|
| 38. Lead Length | 12 " |
| 39. Lead Size | 10 |
| 40. Number of Leads | 3 |
| 41. Megger Reading After Rewind | 7973 Mohms |
| 42. Coil Machine Slot | |
| 43. Coil Machine Tip | |
| 44. Coil Machine Pitch | |
| 45. Hi Pot Reading After Rewind | 0.0682 Ua |
| 46. Surge Pattern After Rewind | (P) Pass |



| |
|------------------------|
| 47. Service Technician |
|------------------------|

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Idle End 2.75
Dr End 2.75
30lbs #20 awg copper wire
10' #10 exar 600v lead wire





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