



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

LR Motor Shop Repairs

Job Number 104195

Prepared for Tyson Foods (10914)

1238 Market Street
Clarksville AR 72830

Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *IEC60034*

1.0

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Hi-Speed Industrial Service
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AC Inspection as Found

Tyson Foods (10914)

1238 Market Street
Clarksville, AR 72830

FolderID: 104195
FormID: 23516220

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: IEC60034

Description: 5 HP STERLING

Hi-Speed Job Number: 104195

Manufacturer: Sterling

Product Number: XI0054PCI-E

Serial Number: IEC60034

HP/kW: 5 (HP)

RPM: 1760 (RPM)

Frame: 184TC

Voltage: 230 / 460

Current: 13.4/6.7 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.0

Enclosure: TEFC

of Leads: 9

J-box Included: Complete

Coupling/Sheave: None

Date Received: 02/25/2025

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: No

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 ● 18 - Good

Overall Condition

1. Report Date

03/03/2025

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1.0

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

Dirty

Initial Mechanical/Electrical

5. Does Shaft Turn Freely?	(Y) Yes
6. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
7. Does Shaft Have Visible Damage?	(No) No
8. Assembled Shaft Runout	0.001 Inches
9. Assembled Shaft End Play	inches
10. Air Gap Variation <10%	
11. Lead Condition	(P) Pass
12. Lead Length	8 Inches
13. Does it have Lugs?, If so what is the Stud Size?	(No) No
14. Lead Numbers	1-9
15. Frame Condition	
16. Fan Condition	(P) Pass
17. Does motor have internal fan?	(No) No
18. Broken or Missing Components	

Initial Electrical Inspection

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Megohms

20. Winding Resistance		
1-2	1-3	2-3

21. Perform Surge Test

(P) Pass

Tests | Trending

22.	Number of Stator Slots
23.	Stator Condition
24.	Stator Thermistors/Ohms
25.	Stator Overloads/Ohms
	<i>0.3 ohms</i>

1.4

Mechanical Inspection

26. Drive End Bearing Brand

 Koyo



27. Drive End Bearing Number- 6306

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?

32. Drive End Wavy Washer/Snap-Ring Other Retention Device?

33. Drive End Bearing Condition

 Signs of contamination



34. Opposite Drive End Bearing Brand

 Koyo



35. Opposite Drive End Bearing Number-	6206
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?	
40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	2 wavy washers
41. Opposite Drive End Bearing Condition	
<div> <div></div> <div>Signs of wear</div> </div>	



42. Drive End Seal	slinger and lip seal
<div> <div></div> <div>Lip seal- 30-37-4 mm</div> </div>	
43. Opposite Drive End Seal	
<div> <div></div> <div>Slinger</div> </div>	
Rotor Inspection	
44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
45. Growler Test	(Pass) Pass
46. Number of Rotor Bars	
47. Rotor Condition	
48. List the Parts needed for the Repair Below	
<div> <div>6306-2RS</div> <div>6206-2RS</div> </div>	

49. Signature of Technician that Disassembled Motor

Cw



Mechanical Fits- Rotor

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

1.1815-1.1814-1.1815

55. Drive End Bearing Shaft Fit Condition

(P) Pass

56. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.1815-1.1815-1.1815

57. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass

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

2.8350-2.8349-2.8350

60. Drive End - Endbell Bearing Fit Condition

(P) Pass

61. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

2.4421-2.4426-2.4423

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

ODE end bell bearing fit

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66. Technician

Cw


Root Cause of Failure

67. Failure locations

Bearings

68. Root cause of failure

*Wear and contamination***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

Mechanical Fits- Bearing Housings - Post Repair

73. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

74. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

75. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

76. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

77. End Bell Repair Sign-off

Assembly

78. QC Check All Parts for Cleanliness Prior to Assembly

79. Photograph All Major Components prior to assembly

80. Final Insulation Resistance Test

81. Assembled Shaft Endplay

82. Assembled Shaft Runout

83. Test Run Voltage

Volts

Volts

Volts

84. Test Run Amperage

Amps

Amps

Amps

85. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
86. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
87. Ambient Temperature - Fahrenheit			
88. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
89. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
90. Document Final Condition with Pictures after paint			
91. Final Pics and QC Review			



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