



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

Motor Shop Repairs

Job Number 99088

Prepared for 3M-Main Plant (10001)

310 Walter Road
Little Rock AR 72216

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AC Recondition Repair Report

1.0

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AC Recondition Repair Report

FolderID: 99088
FormID: 12318494

3M-Main Plant (10001)
310 Walter Road
Little Rock, AR 72216

Performed By: Motor Shop LR 3

Priorities Found: ● 4 - High ● 8 - Good

General

1. Job Number	99088
2. Report Date	12/9/2021
3. Customer	3M

Name Plate Information

4. Manufacturer	TECO Westinghouse
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5. Model	EP2506
6. Serial Number	PC.AC173035-1
7. Horsepower	250
8. KW	
9. Volts	460
10. Amps	289
11. RPM	1188
12. Frame	449T
13. Enclosure	TEFC
14. Cycles	60

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15. Phase	3
16. Service Factor	1.15
17. Motor Mount Position	
Initial Inspection	
18. Number of Leads	
19. Lead Length	
20. Lead Size	
21. Lead Condition	
22. Lead Markings	
23. Lug Size, Condition, and Type	
24. Winding RTD's	
25. Winding Rtd's Condition	
26. Shaft Run Out	
27. Does Shaft Turn Freely	
28. Does Shaft Have Visible Damage	
29. Bearing Rtd's	
30. Bearing Rtd's Condition	
31. Contamination	
32. Frame Condition	
33. Fan Condition	
34. Broken or missing components	
Initial Electric Test	
35. Resistance to Ground	
36. Winding Resistance 1-2	
37. Winding Resistance 2-3	
38. Winding Resistance 1-3	
39. Resistive Imbalance	
40. Hi-Pot	
41. Surge Test	
42. Stator Condition	
43. Failure Location	
Initial Rotor Inspection	
44. Rotor Type	squirrel cage laminate



45. Air Gap <10% Variation

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46. Number of Rotor Bars	58
47. Number of Broken Rotor Bars	0
48. Growler Test	(P) Pass
49. Rotor Condition	(P) Pass



Mechanical Inspection

50. Bearing Manufacture	NtN
51. Bearing DE Size	6320



52. Bearing DE Type	regular ball bearing
53. DE Bearing Qty.	1
54. Bearing ODE Size	6316
55. Bearing ODE Type	regular ball bearing
56. ODE Bearing Qty.	1
57. Insulated Bearing	no
58. Lubrication Type	grease

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60. Bearing Retainers	(Y) Yes
61. Shaft Grinding Device	(NA) Not Applicable
62. DE Seal	(NA) Not Applicable
63. DE Seal Type/Size	
64. ODE Seal	
65. ODE Seal Type/Size	
Root Cause of Failure	
66. Component Failure	ODE bearing
67. Cause of Failure	<i>ODE bearing suffered catastrophic failure from contaminated grease.</i>
68. Comments	<i>Fan assembly melted. Both housing fits bad. Ode shaft fit bad.</i>
69. Service Technician	Terrence. Holland
	
Machine Fit Inspection Report	
70. Shaft Run Out	
71. Initial Shaft Run Out	
72. Final Shaft Run Out	



74. DE Initial Shaft Bearing Fit Size 1	3.9376 "
75. DE Initial Shaft Bearing Fit Size 2	3.9374 "
76. DE Initial Shaft Bearing Fit Size 3	3.9375 "
77. DE Finial Shaft Bearing Fit Size 1	
78. DE Finial Shaft Bearing Fit Size 2	
79. DE Finial Shaft Bearing Fit Size 3	
80. ODE Bearing Shaft Fit	(F) Fail
Bearing race was welded to shaft and had to be cut off.	



81. ODE Initial Shaft Bearing Fit Size 1	
82. ODE Initial Shaft Bearing Fit Size 2	
83. ODE Initial Shaft Bearing Fit Size 3	
84. ODE Finial Shaft Bearing Fit Size 1	3.15 "
Welded and turned bearing fit	




85. ODE Finial Shaft Bearing Fit Size 2	3.15 "
86. ODE Finial Shaft Bearing Fit Size 3	3.15 "
87. DE Air Seal Shaft Fit	
88. DE Initial Air Seal Shaft Size	
89. DE Final Air Seal Shaft Size	
90. ODE Air Seal Shaft Fit	
91. ODE Initial Air Seal Shaft Size	
92. ODE Final Air Seal Shaft Size	
93. DE Endbell Fit	(F) Fail



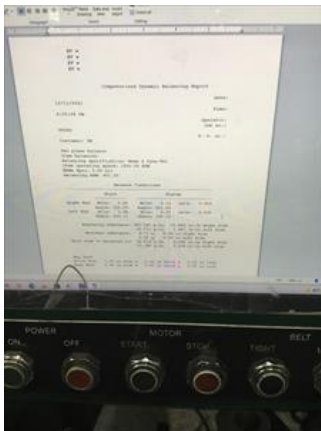
94. DE Initial Endbell Fit Size 1	8.468 "
95. DE Initial Endbell Fit Size 2	8.467000000000001 "
96. DE Initial Endbell Fit Size 3	8.467000000000001 "
97. DE Final Endbell Fit Size 1	8.465199999999999 "
98. DE Finial Endbell Fit Size 2	8.465199999999999 "
99. DE Final Endbell Fit Size 3	8.465199999999999 "
100. DE Endbell Fit Insulated	(NA) Not Applicable
101. DE Endbell Air Seal Fit	
102. Initial Endbell Air Seal Fit Size	
103. Finial Endbell Air Seal Fit Size	
104. ODE Endbell Fit	(F) Fail
Complete bearing failure caused damage to housing fit.	
105. ODE Initial Endbell Fit Size 1	6.697 "

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106. ODE Initial Endbell Fit Size 2	6.697 "
107. ODE Initial Endbell Fit Size 3	6.696 "
108. ODE Final Endbell Fit Size 1	6.6935 "
109. ODE Final Endbell Fit Size 2	6.6935 "
110. ODE Final Endbell Fit Size 3	6.6935 "
111. ODE Endbell Fit Insulated	(NA) Not Applicable
112. ODE Endbell Air Seal Fit	
113. ODE Initial Endbell Seal Fit Size	
114. ODE Final Endbell Seal Fit Size	
● 115. Foot Flatness	(P) Pass
● 116. Foot Condition	(P) Pass
● 117. Flange Condition	(NA) Not Applicable
118. Service Technician	Terrence Hollad
	

Balancing Report

119. Balance Type



120. Balance Operating Speed	401.33 RPM
121. Start Left End	1.36 Mills
122. Start Right End	2.28 Mills
123. Balancing Specification	
124. Finish Left End	0.37 Mills
125. Finish Right End	0.15 Mills
126. Service Technician	RW
	

Assembly and Final Test

127. Meggar Testing Reading
128. Surge Test
129. Hi-Pot

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130. Winding Resistance 1-2	
131. Winding Resistance 2-3	
132. Winding Resistance 1-3	
133. Test Run Voltage Phase A	455 Volts



134. Test Run Amps A	87.90000000000001 Amps
135. Test Run Voltage Phase B	455 Volts



136. Test Run Amps B	83.3 Amps
137. Test Run Voltage Phase C	457 Volts



138. Test Run Amps C	85.40000000000001 Amps
139. DE Horizontal Vibration Reading	0.02 In/Sec

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140. DE Vertical Vibration Reading	0.02 In/Sec
141. DE Axial Vibration Reading	0.03 In/Sec
142. ODE Horizontal Vibration Reading	0.02 In/Sec
143. ODE Vertical Vibration Reading	0.02 In/Sec
144. ODE Axial Vibration Reading	0.03 In/Sec
145. Ambient Temp at start of Test Run	
146. Temp at 5 minutes	
147. Temp at 10 minutes	
148. Temp at 15 minutes	
149. Temp at 20 minutes	
150. Temp at 25 minutes	
151. Temp at 30 minutes	
152. Temp at 35 minutes	
153. Temp at 40 minutes	
154. Temp at 45 minutes	
155. Temp at 50 minutes	
156. Temp at 55 minutes	
157. Temp at 60 minutes	
158. Motor Paint	(P) Pass



159. Service Technician	RW
	



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1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
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3. **SCOPE OF GOODS AND/OR SERVICES.** The goods and/or services provided by Hi-Speed pursuant to any quotation shall be limited exclusively to those goods and/or services expressly identified therein. Hi-Speed does not assume any responsibility and/or liability for the failure to provide any other goods and/or services not identified in any quotation. Modifications, additions or deletions to or from the scope referenced in any quotation shall only be effective if evidenced in writing and signed by Hi-Speed. The sale of any of all goods and/or services affected by such modification, addition or deletion shall be subject to these same Standard Terms and Conditions whether or not referenced therein.
4. **BILLING AND PAYMENT TERMS.** Hi-Speed shall invoice Buyer for all goods and/or services as same are rendered at the address listed on the quotation. Payments for all goods and/or services shall be due thirty (30) days from the date of the current invoice or as otherwise set forth in the quotation. Late payments are subject to a late fee of 5% of the total invoice amount. Recurring late payments may lead to a deposit requirement on future services or sale of goods. Buyer shall be liable to Hi-Speed for any and all fees and expenses incurred by Hi-Speed to collect any invoices or to enforce these Standard Terms and Conditions, including but not limited to, attorney's fees.
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.
6. **DELIVERY SITE AND TIME FOR PERFORMANCE.** Hi-Speed and Buyer agree that time is of the essence for the purchase order and that Buyer shall fully cooperate with Hi-Speed in order to allow Hi-Speed full access to prosecute its work diligently and in an orderly manner. Buyer shall assist Hi-Speed in every way possible to avoid delaying, disrupting or interfering with the progress of Hi-Speed's work at the project site. In the event Hi-Speed's work is delayed, hindered, suspended, disrupted, re-sequenced or interfered with or rendered less efficient or more costly or adversely affected in any way as a result of acts or omissions of Buyer or other contractors or employees of Buyer or by any other reason beyond Hi-Speed's control and without the fault of Hi-Speed, then, in such event, Buyer shall be liable to Hi-Speed for any damages, additional costs, expenses, labor, materials, man hours, acceleration costs, overtime, additional jobsite overhead, extended home office overhead, and any and all other direct and indirect expenses of whatsoever nature or kind, caused in whole or in part, as a result of any of the above-referenced occurrences. Hi-Speed's project records will be the basis for computing the additional costs and damages of Hi-Speed's labor, materials, expenses and overhead related to such changes. BUYER WARRANTS THAT THE SITE FOR DELIVERY OR INSTALLATION OF ANY GOODS AND/OR FOR THE PERFORMANCE OF ANY SERVICES SHALL BE READY AND ADEQUATE FOR HI-SPEED'S DELIVERY OF GOODS AND/OR PERFORMANCE OF SERVICES AND THAT HI-SPEED SHALL HAVE FULL ACCESS THERETO, FREE OF ALL OBSTRUCTIONS. BUYER SHALL ASSUME ALL EXTRA COSTS ASSOCIATED WITH HI-SPEED'S INABILITY TO INSTALL ANY GOODS OR PERFORM ANY SERVICES AS A RESULT OF BUYER'S FAILURE TO COMPLY WITH THIS PROVISION. HI-SPEED MAY NOT INSPECT THE SITE PRIOR TO DELIVERY AND/OR INSTALLATION OF GOODS AND/OR PERFORMANCE OF SERVICES AND MAKES NO WARRANTY AS TO THE SUFFICIENCY OF THE SITE FOR THE DELIVERY AND/OR INSTALLATION OF GOODS AND/OR THE PERFORMANCE OF SERVICES AT SUCH SITE.
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8. **WARRANTIES.** Hi-Speed warrants that all goods shall conform in all material aspects to the goods identified in the quotation to Buyer and/or purchase order, and Hi-Speed makes to Buyer the manufacturer's express warranty for any goods sold to Buyer, which is offered by the manufacturer at the time of acceptance of any quotation by Buyer. This warranty is conditioned upon the installation, operation, and maintenance of the goods in accordance with the manufacturer's recommendations and/or standard industry practice and the goods at all times being operated or used under normal operating conditions for which they were designed. Hi-Speed, at its sole option, will repair or

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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.
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