



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

Motor Shop Repairs

**Job Number 99987**

Prepared for Almatris Inc/RCP Bauxite (10014)

4701 Alcoa Road  
Bauxite AR 72011

# Table of Contents



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

## AC Recondition As Found

Almatis Inc/RCP Bauxite (10014)

4701 Alcoa Road  
Bauxite, AR 72011

FolderID: 99987  
FormID: 13964342

### AC Recondition - Rev. 2

Location: LR Motor Shop

Serial Number: 7424608-07/11-09

Description: 50HP MARATHON 1800RPM 326T

Hi-Speed Job Number: 99987

Manufacturer: Marathon

Product Number: EVH326TTF6526KZL

Serial Number: 7424608-07/11-09

HP/kW: 50 (HP)

RPM: 1775 (RPM)

Frame: 326T

Voltage: 460

Current: 60

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

J-box Included: Complete

Coupling/Sheave: None

Date Received: 06/30/2022

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 1 - High ● 8 - Good

### Overall Condition

1. Report Date
2. Nameplate Picture



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3. Describe the Overall Condition of the Equipment as Received  
*Good*

#### Initial Mechanical/Electrical

|                                    |           |
|------------------------------------|-----------|
| 4. Does Shaft Turn Freely?         | (Yes) Yes |
| 5. Does Shaft Have Visible Damage? | (No) No   |



|                             |              |
|-----------------------------|--------------|
| 6. Assembled Shaft Runout   | 0.001 Inches |
| 7. Assembled Shaft End Play | 0 inches     |
| 8. Air Gap Variation <10%   |              |

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9. Lead Condition

(P) Pass



10. Lead Length

13 Inches

11. Frame Condition

good



12. Fan Condition

(P) Pass



13. Broken or Missing Components

#### Initial Electrical Inspection

14. Insulation Resistance/Megger

15. Winding Resistance

1-2

1-3

2-3

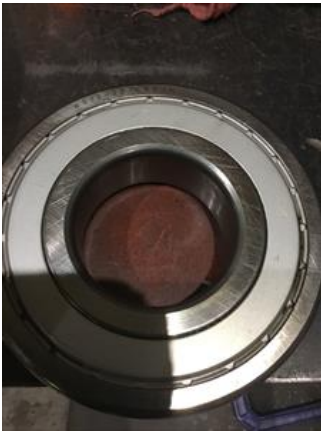
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## 17. Stator Condition

**Mechanical Inspection**

|   |                            |
|---|----------------------------|
| 18. Drive End Bearing Number-                               | 6312-2Z/C3                 |
| 19. Drive End Bearing Qty.                                  | 1                          |
| 20. Drive End Bearing Type                                  | (Ball) Ball Bearing        |
| 21. Drive End Lubrication Type                              | (Grease) Grease Lubricated |
| 22. Drive End Bearing Insulation or Grounding Device?       | none                       |
| 23. Drive End Wavy Washer/Snap-Ring Other Retention Device? | none                       |
| 24. Drive End Bearing Condition                             |                            |



25. Opposite Drive End Bearing Number-

6311/2Z



|  |                            |
|--|----------------------------|
| 26. Opposite Drive End Bearing Qty.                                  | 1                          |
| 27. Opposite Drive End Bearing Type                                  | (Ball) Ball Bearing        |
| 28. Opposite Drive End Lubrication Type                              | (Grease) Grease Lubricated |
| 29. Opposite Drive End Bearing Insulation or Grounding Device?       | none                       |
| 30. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? | yes                        |



31. Opposite Drive End Bearing Condition



32. Drive End Seal

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33. Opposite Drive End Seal

none

### Rotor Inspection

34. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast



35. Growler Test

(Pass) Pass

36. Number of Rotor Bars

37. Rotor Condition

good

38. List the Parts needed for the Repair Below

*Recondition/bearings*

39. Signature of Technician that Disassembled Motor

Terrence. Holland

*Terrence Holland*

### Mechanical Fits- Rotor

40. Shaft Runout

0.001 inches

41. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

42. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

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|  |                                |             |          |
|--|--------------------------------|-------------|----------|
| 43. Coupling Fit Closest to the end of the Shaft       |                                |             |          |
| 0 Degrees  | 60 Degrees                     | 120 Degrees |          |
|  |                                |             |          |
| 44. Drive End Bearing Shaft Fit                        |                                |             |          |
| 0 Degrees  | 60 Degrees                     | 120 Degrees |          |
| 2.3624   | 2.3624                         | 2.3623      |          |
| 45. Drive End Bearing Shaft Fit Condition              |                                |             | (P) Pass |
| 46. Opposite Drive End Bearing Shaft Fit               |                                |             |          |
| 0 Degrees  | 60 Degrees                     | 120 Degrees |          |
| 2.1657   | 2.1658                         | 2.1657      |          |
| 47. Opposite Drive End Bearing Shaft Fit Condition     |                                |             | (P) Pass |
| 48. Shaft Air Seal Fits                                |                                |             |          |
| Drive End Air Seal                                     | Opposite Drive End Air Seal    |             |          |
| <b>Mechanical Fits- Bearing Housings</b>               |                                |             |          |
| 49. Drive End - Endbell Bearing Fit                    |                                |             |          |
| 0 Degrees  | 60 Degrees                     | 120 Degrees |          |
| 5.119  | 5.1191                         | 5.119       |          |
| 50. Drive End - Endbell Bearing Fit Condition          |                                |             | (P) Pass |
| 51. Opposite Drive End - Endbell Bearing Fit           |                                |             |          |
| 0 Degrees  | 60 Degrees                     | 120 Degrees |          |
| 4.7253   | 4.7253                         | 4.7253      |          |
| 52. Opposite Drive End - Endbell Bearing Fit Condition |                                |             | (P) Pass |
| 53. Bearing Cap Condition                              |                                |             |          |
| Drive End Bearing Cap                                  | Opposite Drive End Bearing Cap |             |          |



|                                    |                             |  |
|------------------------------------|-----------------------------|--|
| 54. End Bell Air Seal Fits         |                             |  |
| Drive End Air Seal                 | Opposite Drive End Air Seal |  |
| 55. List Machine Work Needed Below |                             |  |
| None                               |                             |  |

56. Technician

Terrence Holland


**Dynamic Balance Report**

57. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

58. Initial Balance Readings

Drive End

Opposite Drive End

59. Final Balance Readings

Drive End

Opposite Drive End

60. Technician

**Rewind**

61. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

62. Core Hot Spot Test

Pre-Burnout

Post-Burnout

63. Post Rewind Electrical Test- Insulation Resistance

64. Post Rewind Polarization Index

65. Post Rewind Winding Resistance

1-2

1-3

2-3

66. Post Rewind Surge Test

67. Post Rewind Hi-Pot

68. Technician

**Root Cause of Failure**

69. Failure locations

70. Root cause of failure

*Bearing grease contaminated***Mechanical Fits- Rotor - Post Repair**

71. Shaft Runout Post Repair

72. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

73. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

74. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

|   |                                |             |
|---|--------------------------------|-------------|
| 75. Drive End Bearing Shaft Fit Post Repair                   |                                |             |
| 0 Degrees   | 60 Degrees                     | 120 Degrees |
| 76. Opposite Drive End Bearing Shaft Fit Post Repair          |                                |             |
| 0 Degrees   | 60 Degrees                     | 120 Degrees |
| 77. Shaft Air Seal Fits Post Repair                           |                                |             |
| Drive End Air Seal  | Opposite Drive End Air Seal    |             |
| 78. Shaft Repair Sign-off                                     |                                |             |
| <b>Mechanical Fits- Bearing Housings - Post Repair</b>        |                                |             |
| 79. Drive End - Endbell Bearing Fit Post Repair               |                                |             |
| 0 Degrees   | 60 Degrees                     | 120 Degrees |
| 80. Opposite Drive End - Endbell Bearing Fit Post Repair      |                                |             |
| 0 Degrees   | 60 Degrees                     | 120 Degrees |
| 81. Bearing Cap Condition Post Repair                         |                                |             |
| Drive End Bearing Cap   | Opposite Drive End Bearing Cap |             |
| 82. End Bell Air Seal Fits Post Repair                        |                                |             |
| Drive End Air Seal  | Opposite Drive End Air Seal    |             |
| 83. End Bell Repair Sign-off                                  |                                |             |
| <b>Assembly</b>   |                                |             |
| 84. Photograph All Major Components prior to assembly         |                                |             |
| 85. Final Insulation Resistance Test                          |                                |             |
| 86. Assembled Shaft Endplay                                   |                                |             |
| 87. Assembled Shaft Runout                                    |                                |             |
| 88. Test Run Voltage  |                                |             |
| Volts   | Volts                          | Volts       |
| 89. Test Run Amperage   |                                |             |
| Amps  | Amps                           | Amps        |
| 90. Drive End Vibration Readings - Inches Per Second          |                                |             |
| Horizontal  | Vertical                       | Axial       |
| 91. Opposite Drive End Vibration Readings - Inches Per Second |                                |             |
| Horizontal  | Vertical                       | Axial       |
| 92. Ambient Temperature - Fahrenheit                          |                                |             |
| 93. Drive End Bearing Temps - Fahrenheit                      |                                |             |
| 5 Minutes   | 10 Minutes                     | 15 Minutes  |
| 94. Opposite Drive End Bearing Temps - Fahrenheit             |                                |             |
| 5 Minutes   | 10 Minutes                     | 15 Minutes  |
| 95. Final Test Run Sign-off                                   |                                |             |

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96. Document Final Condition with Pictures after paint



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#### 97. Final Pics and QC Review



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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.
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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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