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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 100544

Prepared for Arauco-Malvern MDF (10298)

1275 Willamette Rd
Malvern AR 72104

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

AC Recondition As Found

Arauco-Malvern MDF (10298)

1275 Willamette Rd
Malvern, AR 72104

FolderID: 100544
FormID: 15048830

AC Recondition - Rev. 2

Location: LR MOTORSHOP

Serial Number: NO NP

Description: 60HP US MOTORS 1800RPM
364TS

Hi-Speed Job Number: 100544

Manufacturer: US Motors/Nidec

HP/kW: 60 (HP)

RPM: 1770 (RPM)

Frame: 364TS

Voltage: 230 / 460

Current: 142/71

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

J-box Included: Complete

Coupling/Sheave: None

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 6 - High ● 2 - Good

Overall Condition

1. Report Date
2. Nameplate Picture

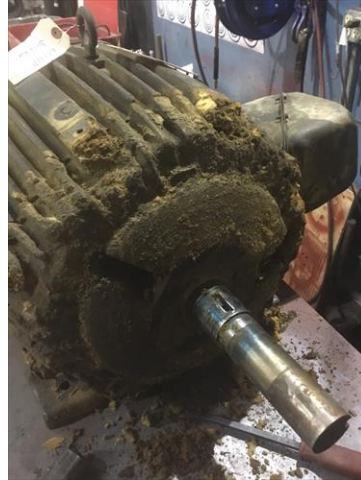


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Printed on 1/4/2023

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1.0



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3. Photos of all six sides of the machine.
4. Describe the Overall Condition of the Equipment as Received

Initial Mechanical/Electrical

● 5. Does Shaft Turn Freely?	(Yes) Yes
6. Does Shaft Have Visible Damage?	(No) No
7. Assembled Shaft Runout	
8. Assembled Shaft End Play	
9. Air Gap Variation <10%	
● 10. Lead Condition	(P) Pass
11. Lead Length	12 Inches
12. Frame Condition	wash
● 13. Fan Condition	(F) Fail



14. Broken or Missing Components

Initial Electrical Inspection

15. Insulation Resistance/Megger	Megohms
16. Winding Resistance	
1-2	1-3
	2-3
● 17. Perform Surge Test	(F) Fail

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18. Stator Condition

Rewind due to over heating



19. Number of Stator Slots

Mechanical Inspection

20. Drive End Bearing Number-

6313 2RS



21. Drive End Bearing Qty.

1

22. Drive End Bearing Type

(Ball) Ball Bearing

23. Drive End Lubrication Type

(Grease) Grease Lubricated

24. Drive End Bearing Insulation or Grounding Device?

na

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

No

26. Drive End Bearing Condition



27. Opposite Drive End Bearing Number-

6212 2RS



28. Opposite Drive End Bearing Qty.

1

29. Opposite Drive End Bearing Type

(Ball) Ball Bearing

30. Opposite Drive End Lubrication Type

(Grease) Grease Lubricated

31. Opposite Drive End Bearing Insulation or Grounding Device?

Na

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

Wavy washer

33. Opposite Drive End Bearing Condition

frosted



34. Drive End Seal

35. Opposite Drive End Seal

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Rotor Inspection

36. Rotor Type/Material

(Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast



37. Growler Test (Pass) Pass

38. Number of Rotor Bars 56

39. Rotor Condition Pass

40. List the Parts needed for the Repair Below

1-6313 2RS 2-6212 2RS BOTH END BELLS NEED RESLEEVED NEEDS NEW SHAFT ALSO NEEDS NEW FAN Rewind

41. Signature of Technician that Disassembled Motor RW

RW

Mechanical Fits- Rotor

42. Shaft Runout

43. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

44. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

45. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

46. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.5589

2.5589

2.5589

47. Drive End Bearing Shaft Fit Condition

(F) Fail

Bad shaft bearing fit



48. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.3619

2.3618

2.3619

49. Opposite Drive End Bearing Shaft Fit Condition

(F) Fail

Shaft bearing fit bad



50. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

51. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

5.5115

5.512

5.5123

52. Drive End - Endbell Bearing Fit Condition

(F) Fail

Resleeve



53. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

4.3389

4.335

4.342

54. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail

Resleeve

55. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Na

Na

56. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

57. List Machine Work Needed Below

Both end bells need resleeved both shaft bearing fit bad needs new shaft fan needs replaced rewind

58. Technician

RW



Dynamic Balance Report

59. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



60. Initial Balance Readings

Drive End

Opposite Drive End

3.79

6.00

61. Final Balance Readings

Drive End

Opposite Drive End

.21

.26

62. Technician

RW

Rewind

63. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

64. Core Hot Spot Test

Pre-Burnout

Post-Burnout

65. Post Rewind Electrical Test- Insulation Resistance

66. Post Rewind Polarization Index

67. Post Rewind Winding Resistance

1-2

1-3

2-3

68. Post Rewind Surge Test

69. Post Rewind Hi-Pot

70. Technician

Root Cause of Failure

71. Failure locations

Both end bells and both shaft bearing fit bad and rewind excessive over heating needs new fan fan in pieces

72. Root cause of failure

Mechanical Fits- Rotor - Post Repair

73. Shaft Runout Post Repair

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74. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
75. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
76. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
77. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
78. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
79. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
80. Shaft Repair Sign-off		Gary
		



Mechanical Fits- Bearing Housings - Post Repair

81. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
5.512	5.5119	5.5118



82.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
83.	Bearing Cap Condition Post Repair		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
84.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
85.	End Bell Repair Sign-off		
Assembly			

86. Photograph All Major Components prior to assembly



87. Final Insulation Resistance Test

88. Assembled Shaft Endplay

89. Assembled Shaft Runout

90. Test Run Voltage

Volts

455

Volts

455

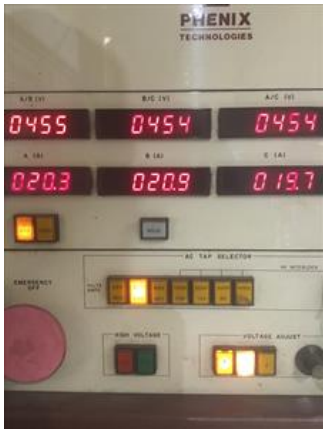
Volts

455



91. Test Run Amperage

Amps	Amps	Amps
20.3	20.9	19.7



92. Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
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93. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
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94. Ambient Temperature - Fahrenheit

95. Drive End Bearing Temps - Fahrenheit

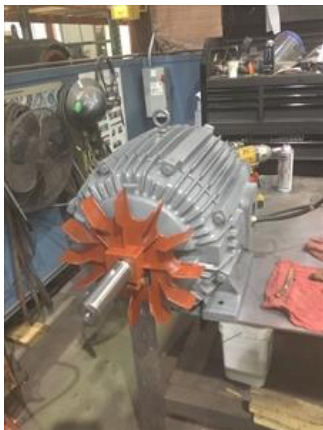
5 Minutes	10 Minutes	15 Minutes
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96. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes
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97. Final Test Run Sign-off

98. Document Final Condition with Pictures after paint



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99. Final Pics and QC Review

RW

RW



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

AC Random Coil Rewind Report

FolderID: 100544
FormID: 15443015

Arauco-Malvern MDF (10298)
1275 Willamette Rd
Malvern, AR 72104

Priorities Found: ● 1 - Good

General	
1. Job Number	100544
2. Report Date	12/02/2022
3. Customer	Aruco
Stator Winding	
4. Core Length	7.125 "
5. Core ID	9.875 "
6. Back Iron Depth	1.375 "
7. Slot Depth	1.125 "
8. Tooth Width	0.5 "
9. Number of Vents	
10. Vent Width	
11. Before Burnout Core loss	
12. Flux Before Burnout	
13. Watts before burnout	
14. Watts loss per lb. before burnout	
15. After Burnout Core Loss	
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	
19. Core Iron Condition	
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	68 Lbs.
31. Lead Markings	
32. Grouping	
12 of 4	
● 33. Multiple Wires	(Y) Yes

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34. Wire Size	
2#16	
4#17	
2#18	
35. Turns per coil	8
36. Pitch 1 to:	11
37. Connection	
2 Wye	
38. Lead Length	16 "
39. Lead Size	4
40. Number of Leads	3
41. Megger Reading After Rewind	
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	
46. Surge Pattern After Rewind	
47. Service Technician	Trent
	



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