



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

LR Motor Shop Repairs

**Job Number 100836**

Prepared for Georges Inc

1810 S. St. Louis Street  
Batesville AR 72501

# Table of Contents



Hi-Speed Industrial Service  
7030 Ryburn Dr  
Millington, Tn 38053  
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## AC Recondition As Found

Georges Inc  
1810 S. St. Louis Street  
Batesville, AR 72501

FolderID: 100836  
FormID: 15814466

### AC Recondition - Rev. 2

Location: Shop  
Serial Number: 1MAF34079-013 NP  
Description: 40HP AQUA JET AERATOR  
1200RPM 364LPZ

Hi-Speed Job Number:	100836
Manufacturer:	Reliance
Product Number:	2404001
Serial Number:	1MAF34079-013 NP
HP/kW:	40 (HP)
RPM:	1185 (RPM)
Frame:	364LPZ
Voltage:	460
Current:	47.7
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	Propeller
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



3. Photos of all six sides of the machine.

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4. Describe the Overall Condition of the Equipment as Received

*Dirty/serviceable.*

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

#### Initial Mechanical/Electrical

6. Does Shaft Turn Freely?

(Yes) Yes

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7. Does Shaft Have Visible Damage?

(No) No



8. Assembled Shaft Runout	0.005 Inches
9. Assembled Shaft End Play	
10. Air Gap Variation <10%	
11. Lead Condition	(P) Pass



12. Lead Length	9 Inches
13. Frame Condition	pass
14. Fan Condition	(P) Pass



15. Broken or Missing Components

none

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## Initial Electrical Inspection

16. Insulation Resistance/Megger

Megohms



17. Winding Resistance

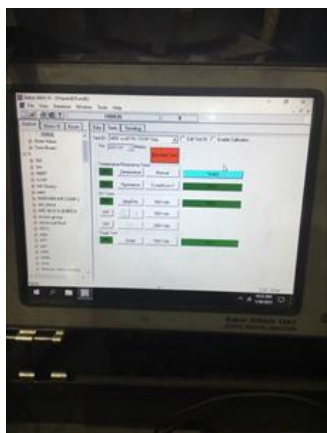
1-2

1-3

2-3

18. Perform Surge Test

(P) Pass



19. Number of Stator Slots

20. Stator Condition

pass

## Mechanical Inspection

21. Drive End Bearing Number-

6215 C3 DBL Wide DBL row.



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22. Drive End Bearing Qty.	1
23. Drive End Bearing Type	(Ball) Ball Bearing
24. Drive End Lubrication Type	(Grease) Grease Lubricated
25. Drive End Bearing Insulation or Grounding Device?	none
26. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
27. Drive End Bearing Condition	replace



28. Opposite Drive End Bearing Number-	6313 C3
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29. Opposite Drive End Bearing Qty.	1
30. Opposite Drive End Bearing Type	(Ball) Ball Bearing
31. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated

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32. Opposite Drive End Bearing Insulation or Grounding Device?	<b>none</b>
33. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>wavy washer</b>



34. Opposite Drive End Bearing Condition	<b>replace</b>
35. Drive End Seal	
36. Opposite Drive End Seal	

### Rotor Inspection

37. Rotor Type/Material	<b>(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast</b>
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38. Growler Test	<b>(Pass) Pass</b>
39. Number of Rotor Bars	
40. Rotor Condition	<b>pass</b>
41. List the Parts needed for the Repair Below	
42. Signature of Technician that Disassembled Motor	<b>Terrence Holland</b>

### Mechanical Fits- Rotor

43. Shaft Runout	0.005 inches		
44. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	

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45. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
46. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
47. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.9533	2.9534	2.9533	
48. Drive End Bearing Shaft Fit Condition			(P) Pass
49. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.5593	2.5593	2.5594	
50. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
51. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
<b>Mechanical Fits- Bearing Housings</b>			
52. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.1187	5.1188	5.1188	
53. Drive End - Endbell Bearing Fit Condition			(P) Pass
54. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.5123	5.5123	5.5125	
55. Opposite Drive End - Endbell Bearing Fit Condition			(P) Pass
56. Bearing Cap Condition			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
	pass		



57. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
58. List Machine Work Needed Below		
None		

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59. Technician

Terrence Holland


**Dynamic Balance Report**

60. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

61. Initial Balance Readings

Drive End

Opposite Drive End

62. Final Balance Readings

Drive End

Opposite Drive End

63. Technician

**Rewind**

64. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

65. Core Hot Spot Test

Pre-Burnout

Post-Burnout

66. Post Rewind Electrical Test- Insulation Resistance

67. Post Rewind Polarization Index

68. Post Rewind Winding Resistance

1-2

1-3

2-3

69. Post Rewind Surge Test

70. Post Rewind Hi-Pot

71. Technician

**Root Cause of Failure**

72. Failure locations

73. Root cause of failure

**Mechanical Fits- Rotor - Post Repair**

74. Shaft Runout Post Repair

75. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

76. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

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

0 Degrees

60 Degrees

120 Degrees

78. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

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

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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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