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LR Motor Shop Repairs

**Job Number 100445**

Prepared for Georg Fischer Sloane (10754-GFS)

7777 Sloane Drive  
Little Rock AR 72206

# Table of Contents



Hi-Speed Industrial Service  
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## AC Recondition As Found

Georg Fischer Sloane (10754-GFS)

7777 Sloane Drive  
Little Rock, AR 72206

FolderID: 100445  
FormID: 14821274

### AC Recondition - Rev. 2

Location: MOTOR SHOP LR

Serial Number: WAA111159

Description: 600HP MARATHON 1800RPM  
5011L

Hi-Speed Job Number: 100445

Manufacturer: Marathon

Product Number: SE 5011LHFS16542AA W

Serial Number: WAA111159

HP/kW: 600 (HP)

RPM: 1785 (RPM)

Frame: 5011L

Voltage: 460

Current: 655

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.0

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: ● 2 - High

● 6 - 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

*Bearings feel rough*

#### 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

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1.7

11. Lead Length	15 Inches
12. Frame Condition	pass
Back endbell cracked	
13. Fan Condition	(P) Pass
14. Broken or Missing Components	back endbell- fan shroud
<b>Initial Electrical Inspection</b>	
15. Insulation Resistance/Megger	2000 Megohms
16. Winding Resistance	
1-2	1-3 2-3
17. Perform Surge Test	(P) Pass
18. Stator Condition	
<b>Mechanical Inspection</b>	
19. Drive End Bearing Number-	6324



20. Drive End Bearing Qty.	1
21. Drive End Bearing Type	(Ball) Ball Bearing
22. Drive End Lubrication Type	(Grease) Grease Lubricated
23. Drive End Bearing Insulation or Grounding Device?	
24. Drive End Wavy Washer/Snap-Ring Other Retention Device?	
25. Drive End Bearing Condition	fail
Fluted	
26. Opposite Drive End Bearing Number-	6318



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27. Opposite Drive End Bearing Qty.	1
28. Opposite Drive End Bearing Type	(Ball) Ball Bearing
29. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
30. Opposite Drive End Bearing Insulation or Grounding Device?	
31. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer after bearing cap, before bearing
32. Opposite Drive End Bearing Condition	fail
Fluting	
33. Drive End Seal	
34. Opposite Drive End Seal	
<b>Rotor Inspection</b>	
35. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
36. Growler Test	(Pass) Pass
37. Number of Rotor Bars	56
38. Rotor Condition	



39.	List the Parts needed for the Repair Below		
	1-6324 bearing 1-6318 ceramic bearing 2 aegis rings		
40.	Signature of Technician that Disassembled Motor		
Mechanical Fits- Rotor			
41.	Shaft Runout		0.001 inches
42.	Rotor Runout		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
43.	Coupling Fit Closest to Bearing Housing		
	0 Degrees	90 Degrees	120 Degrees
44.	Coupling Fit Closest to the end of the Shaft		
	0 Degrees	60 Degrees	120 Degrees
45.	Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	4.7256	4.7255	4.7255

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●	46.	Drive End Bearing Shaft Fit Condition	(P) Pass	
	47.	Opposite Drive End Bearing Shaft Fit		
		0 Degrees	60 Degrees	120 Degrees
		3.5439	3.5439	3.5439
●	48.	Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	
	49.	Shaft Air Seal Fits		
		Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings				
	50.	Drive End - Endbell Bearing Fit		
		0 Degrees	60 Degrees	120 Degrees
		10.238	10.2382	10.2382
		10.2385	10.2385	10.2383
●	51.	Drive End - Endbell Bearing Fit Condition	(F) Fail	



52.	Opposite Drive End - Endbell Bearing Fit			
	0 Degrees	60 Degrees	120 Degrees	
	7.4821	7.4821	7.482	
	Extreme pitting, housing needs sleeved			



53.	Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail		
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54. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
pass	pass	



55. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
56. List Machine Work Needed Below <i>Sleeve both endbells</i>		
57. Technician		
<b>Dynamic Balance Report</b>		
58. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
59. Initial Balance Readings		
Drive End	Opposite Drive End	
60. Final Balance Readings		
Drive End	Opposite Drive End	
61. Technician		
<b>Rewind</b>		
62. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	
63. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	
64. Post Rewind Electrical Test- Insulation Resistance		
65. Post Rewind Polarization Index		
66. Post Rewind Winding Resistance		
1-2	1-3	2-3
67. Post Rewind Surge Test		
68. Post Rewind Hi-Pot		
69. Technician		
<b>Root Cause of Failure</b>		

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70.	Failure locations <i>Bearings and endbells</i>		
71.	Root cause of failure <i>Fluting and normal wear</i>		
Mechanical Fits- Rotor - Post Repair			
72.	Shaft Runout Post Repair		
73.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
74.	Coupling Fit Closest to Bearing Housing Post Repair		
	0 Degrees	90 Degrees	120 Degrees
75.	Coupling Fit Closest to the end of the Shaft Post Repair		
	0 Degrees	60 Degrees	120 Degrees
76.	Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
77.	Opposite Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
78.	Shaft Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
79.	Shaft Repair Sign-off		
Mechanical Fits- Bearing Housings - Post Repair			
80.	Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
81.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	7.481	7.4809	7.4811



82. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	

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83. End Bell Air Seal Fits Post Repair	
Drive End Air Seal	Opposite Drive End Air Seal
84. End Bell Repair Sign-off	
Assembly	
85. Photograph All Major Components prior to assembly	



86.	Final Insulation Resistance Test		
87.	Assembled Shaft Endplay		
88.	Assembled Shaft Runout		
89.	Test Run Voltage		
	Volts	Volts	Volts
90.	Test Run Amperage		
	Amps	Amps	Amps
91.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
92.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
93.	Ambient Temperature - Fahrenheit		

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94. Drive End Bearing Temps - Fahrenheit			
5 Minutes		10 Minutes	
		15 Minutes	
95. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes		10 Minutes	
		15 Minutes	
96. Final Test Run Sign-off			
97. Document Final Condition with Pictures after paint			



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98. Final Pics and QC Review



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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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11. **GOVERNING LAW AND JURISDICTION.** Any controversy arising out of any quotation, the purchase order, the goods sold or delivered, repair or replacement thereof, or any services provided pursuant to any quotation or any purchase order, or these Standard Terms and Conditions shall be governed by the laws of the state of Tennessee without regard to any choice of law provisions and any cause of action related in any manner thereto shall be brought only in the state or federal courts of Shelby County, Tennessee.
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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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