



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

LR Motor Shop Repairs

Job Number 100326

Prepared for Hiland Dairy (10126)

6901 I-30
Little Rock AR 72209

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

AC Recondition As Found

Hiland Dairy (10126)

6901 I-30

Little Rock, AR 72209

FolderID: 100326
FormID: 14618454

AC Recondition - Rev. 2

Location: MOTOR SHOP LR

Serial Number: 680B400G79

Description: 200HP WESTINGHOUSE 1800RPM
445T

Hi-Speed Job Number: 100326

Manufacturer: TECO Westinghouse

Product Number: TUDP

Serial Number: 680B400G79

HP/kW: 200 (HP)

RPM: 1775 (RPM)

Frame: 445T

Voltage: 460

Current: 224

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: ODP

J-box Included: None

Coupling/Sheave: Coupling

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 5 - High ● 3 - Good

Overall Condition

1. Report Date

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Printed on 11/7/2022

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1.0

2. Nameplate Picture



3. Photos of all six sides of the machine.
4. Describe the Overall Condition of the Equipment as Received
5. Distance from the end of the shaft to the Coupling/Sheave

Initial Mechanical/Electrical

- | | |
|---|-----------|
| <input checked="" type="radio"/> 6. Does Shaft Turn Freely? | (Yes) Yes |
|---|-----------|

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7. Does Shaft Have Visible Damage?

(No) No



8. Assembled Shaft Runout	0.001 Inches
9. Assembled Shaft End Play	
10. Air Gap Variation <10%	
11. Lead Condition	(P) Pass



12. Lead Length	18 Inches
13. Frame Condition	pass
14. Fan Condition	(N) NA
15. Broken or Missing Components	
Initial Electrical Inspection	
16. Insulation Resistance/Megger	0 Megohms
17. Winding Resistance	
1-2	1-3 2-3

18. Perform Surge Test

(F) Fail

Rewind



19. Stator Condition

dirty and grounded and shorted



Mechanical Inspection

20. Drive End Bearing Number-

NU319



21. Drive End Bearing Qty.

1

22. Drive End Bearing Type

(Roller) Roller Bearing

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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?

na

26. Drive End Bearing Condition

pass

27. Opposite Drive End Bearing Number-

6313ZZ



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?

snap ring

33. Opposite Drive End Bearing Condition

pass

34. Drive End Seal

na

35. Opposite Drive End Seal

na

Rotor Inspection

36. Rotor Type/Material

(Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast

37. Growler Test

(Pass) Pass

38. Number of Rotor Bars

58



40. List the Parts needed for the Repair Below

41. Signature of Technician that Disassembled Motor

RW

Mechanical Fits- Rotor42. Shaft Runout **0.001 inches**

43. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0**0.003****0.001**

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



3.7418**3.7418****3.7418**

● 47. Drive End Bearing Shaft Fit Condition

(P) Pass

48. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.5589	2.5589	2.5589	
49. Opposite Drive End Bearing Shaft Fit Condition			(F) Fail
Recommend rebuild shaft bearing fit			



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
7.8756		7.8756	7.8756
	52. Drive End - Endbell Bearing Fit Condition		(F) Fail
	Resleeve		



53. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.5131	5.5131	5.5131	

54. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail

Resleeve



55. Bearing Cap Condition

Drive End Bearing Cap
pass

Opposite Drive End Bearing Cap
pass



56. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

57. List Machine Work Needed Below

Ode shaft bearing fit bad. De and Ode end bell bearing fit bad

58. Technician

RW

RW

Dynamic Balance Report

59. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

60. Initial Balance Readings

Drive End

Opposite Drive End

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61. Final Balance Readings			
Drive End	Opposite Drive End		
62. Technician			
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			
<i>Rotor drag iron causing windings to blow</i>			
72. Root cause of failure			
Mechanical Fits- Rotor - Post Repair			
73. Shaft Runout Post Repair			
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

2.5596

2.5596

2.5596



79. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

80. Shaft Repair Sign-off

Mechanical Fits- Bearing Housings - Post Repair

81. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

82. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

5.5127

5.5127

5.5127



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

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87.	Final Insulation Resistance Test		
88.	Assembled Shaft Endplay		
89.	Assembled Shaft Runout		
90.	Test Run Voltage		
	Volts	Volts	Volts
91.	Test Run Amperage		
	Amps	Amps	Amps
92.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
93.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
94.	Ambient Temperature - Fahrenheit		
95.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
96.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
97.	Final Test Run Sign-off		
98.	Document Final Condition with Pictures after paint		



99. Final Pics and QC Review



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

AC Random Coil Rewind Report

FolderID: 100326
FormID: 14894792

Hiland Dairy (10126)
6901 I-30
Little Rock, AR 72209

Priorities Found: ● 1 - Good

General

1. Job Number	100326
2. Report Date	10/24/2022
3. Customer	Hiland Dairy

Stator Winding

4. Core Length	9.25 "
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5. Core ID	12.25 "
6. Back Iron Depth	1.875 "
7. Slot Depth	1.25 "
8. Tooth Width	0.265 "
9. Number of Vents	0
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	

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23. Heater Qty.	
24. Heater Voltage	
25. Heater Wattage	
26. Thermistors	
27. Number of Poles	4
28. Slots	72
29. Number of Coils	72
30. Coil Weight	1 Lbs.
31. Lead Markings	
32. Grouping 12 of 6	
33. Multiple Wires	(Y) Yes
34. Wire Size 2#15, 4#16, 3#17	
35. Turns per coil	5
36. Pitch 1 to:	16
37. Connection 1&2 Circuit	
38. Lead Length	18 "
39. Lead Size	4
40. Number of Leads	12
41. Megger Reading After Rewind	Mohms
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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