



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

LR Motor Shop Repairs

Job Number 100458

Prepared for International Paper - Conway Graphics

730 Enterprise Ave
Conway AR 72032

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

DC Repair Report

International Paper - Conway Graphics
730 Enterprise Ave
Conway, AR 72032

FolderID: 100458
FormID: 14840320

DC Repair Report Rev. 2

Location: Shop
Job Number: 100458
Serial Number: BB50R451018
Status: In For Repair
Description: 40HP GE DC 1750RPM AD328AT

Hi-Speed Job Number: 100458
Manufacturer: GE
Product Number : BB50R451018
HP/KW: 40 (HP)
RPM: 1750
Frame: AD328AT
Armature Voltage: 500 (Volts)
Field Voltage: 300 (Volts)
Field Current : 2 (Amps)
J-Box Included: No
Bearing RTDS: No
Winding RTDS: No
Mounting Orientation : Horizontal

Priorities Found: ● 3 - High ● 7 - Good

Overall Condition

- Describe the Overall Condition of the Equipment as Received
Serviceable



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2. Nameplate Picture



3. Distance From the End of the Shaft to the end of the Face of the Sheave/Coupling

0.125

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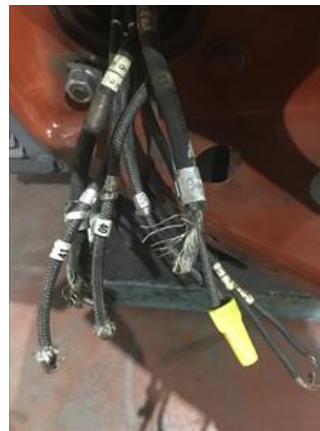


Initial Mechanical/Electrical

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



- | | |
|-----------------------------|--------------|
| 6. Assembled Shaft Runout | 0.001 Inches |
| 7. Assembled Shaft End Play | |
| 8. Air Gap Variation <10% | |
| 9. Lead Condition | (P) Pass |



- | | |
|---------------------|----------|
| 10. Lead Length | 5 Inches |
| 11. Frame Condition | (P) Pass |

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12. Fan Condition

(P) Pass

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13. Brush Information

Brush Number	Quantity	Condition
T566	2	good
		



14. Brush Holder Condition - Verify proper gap to Commutator



Incoming Electrical Test

15. General Condition of the Armature/Commutator



16. Armature Insulation Resistance to Ground

17. Field Circuit Insulation Resistance to Ground

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18.	Interpole Circuit Insulation Resistance to Ground		
19.	Field Drop Test Fields 1&2		
	Total AC Voltage	Field #1	Field #2
	120	0.425	0.423
20.	Field Drop Test Fields 3&4		
	Field #3	Field #4	Field #2
21.	Field Drop Test Fields 5&6		
	Field #5	Field #6	Field #2
22.	Field Drop Test Fields 7&8		
	Field #7	Field #8	Field #2
23.	Interpole Drop Test 1&2		
	Total AC Voltage	Interpole #1	Interpole #2
		0.101	0.104
24.	Interpole Drop Test 3&4		
	Interpole #3	Interpole #4	Field #2
25.	Interpole Drop Test 5&6		
	Interpole #5	Interpole #6	Field #2
26.	Interpole Drop Test 7&8		
	Interpole #7	Interpole #8	Field #2
27.	Armature Number of Bars - Bar to Bar Test		
	Number of Bars	Bar to Bar Test	



Mechanical Inspection

28.	Shaft Runout Drive End		0.001 inches
29.	Shaft Runout Armature		
	Drive End Bearing Journal	Armature Core	ODE Bearing Journal

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30. Drive End Bearing Number

6211-2Z/C3



31. Drive End Bearing Quantity	1
32. Drive End Bearing Type	(Ball) Ball Bearing
33. Drive End Lubrication Type	(Grease) Grease Lubricated
34. Drive End Bearing Insulation or Grounding Device?	(NA)
35. Drive End Wavy Washer/Snap-Ring Other Retention Device?	



36. Drive End Bearing Condition

replace



37. Opposite Drive End Bearing Number

6210 2RS/C3

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38. Opposite Drive End Bearing Quantity	1
39. Opposite Drive End Bearing Type	(Ball) Ball Bearing
40. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
41. Opposite Drive End Bearing Insulation or Grounding Device?	(NA)
42. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
43. Opposite Drive End Bearing Condition	replace



44. Signature of Technician who Performed Teardown	Terrence Holland
	

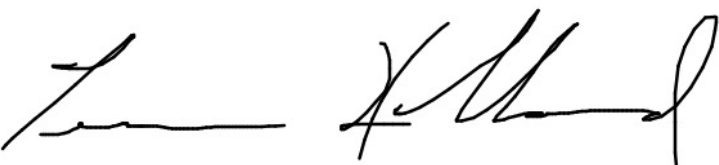
45. List Parts Needed Prior to Reassembly
Bearings: 6211 & 6210. Aegis ring D.E. 2.455. Insulated 6210 sleeve.

Mechanical Fits - Armature

46. Coupling Fit Closest to Bearing Housing			
0 Degrees	60 degrees	120 degrees	
47. Coupling Fit Closest to the End of the Shaft			
0 Degrees	60 degrees	120 degrees	

48. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.1656	2.1656	2.1656
49. Drive End Bearing Shaft Fit Condition		(P) Pass
50. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
1.9684	1.9684	1.9684
51. Opposite Drive End Bearing Shaft Fit Condition		(F) Fail
52. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings		
53. Drive End - End Bell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
3.9381	3.9382	
54. Drive End - Endbell Bearing Fit Condition		(F) Fail
55. Opposite Drive End - End Bell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees



56. Opposite Drive End - Endbell Bearing Fit Condition		(F) Fail
57. Bearing Cap Condition		
Drive End	Opposite Drive End	
pass		
58. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
59. List any Machine work Needed Below		O.D.E shaft bearing journal & housing fits.
60. Signature of Technician Performing Measurements		Terrence Holland
		

Root Cause of Failure

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61. Failure Locations <i>Both housing fits and ode shaft bearing journal. Polish comm.</i>		
62. Root Cause of Failure		
Commutator Data		
63. Total Copper Segment Length		
64. Number of Bars		
65. Number of Wires Per Copper Bar and Size		
Number of Wires per Bar	Wire Size	
66. Equalizers per Copper Bar and Equalizer Wire Size		
Equalizers per Bar	Wire Size	
67. Document Commutator Diameter, Minimum and Max		
Current Comm Diameter	Minimum Comm Diameter	Maximum Comm Diameter
68. Commutator Shaft Diameter		
Front Shaft Diameter	Back Shaft Diameter	
69. Commutator Type		
70. Commutator Bore		
71. Signature of Technician Recording Data		
Dynamic Balance Report		
72. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
73. Initial Balance Readings		
Drive End Readings	Opposite Drive End Readings	
.26	.18	



74. Final Balance Readings		
Drive End Readings	Opposite Drive End Readings	
.26	.18	

75. Signature of the Balance Technician

RW

Post Armature Rewind Testing

76. Post Rewind Armature Insulation Resistance to Ground

77. Post Rewind Field Circuit Measure the Insulation Resistance to Ground

78. Post Rewind Armature Number of Bars - Bar to Bar Test

Number of Bars

Bar to Bar Test

79. Post Rewind Field Circuit Insulation Resistance to Ground

80. Post Rewind Interpole Circuit Insulation Resistance to Ground

81. Post Rewind Field Drop Test Fields 1&2

Total AC Voltage

Field #1

Field #2

82. Post Rewind Field Drop Test Fields 3&4

Field #3

Field #4

Field #2

83. Post Rewind Field Drop Test Fields 5&6

Field #5

Field #6

Field #2

84. Post Rewind Field Drop Test Fields 7&8

Field #7

Field #8

Field #2

85. Post Rewind Interpole Drop Test 1&2

Total AC Voltage

Interpole #1

Interpole #2

86. Post Rewind Interpole Drop Test 3&4

Interpole #3

Interpole #4

Field #2

87. Post Rewind Interpole Drop Test 5&6

Interpole #5

Interpole #6

Field #2

88. Post Rewind Interpole Drop Test 7&8

Interpole #7

Interpole #8

Field #2

Post Mechanical Repair

89. Post Repair Coupling Fit Closest to Bearing Housing

0 Degrees

60 degrees

120 degrees

90. Post Repair Coupling Fit Closest to the End of the Shaft

0 Degrees

60 degrees

120 degrees

91. Post Repair Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

92. Post Repair Drive End Bearing Shaft Fit Condition

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93. Post Repair Drive End Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
94. Post Repair Drive End Opposite Drive End Bearing Shaft Fit Condition		
95. Post Repair Drive End - End Bell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
96. Post Repair Drive End - Endbell Bearing Fit Condition		
97. Post Repair Opposite Drive End - End Bell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
98. Post Repair Opposite Drive End - Endbell Bearing Fit Condition		
99. Post Repair Bearing Cap Condition		
Drive End	Opposite Drive End	
100. Post Repair End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
101. Signature of Tech Performing Mechanical Repairs		
Assembly		

102. Take Pictures of all Major Components Prior to Reassembly



●	103. Verify Brush Box Holders Have the Proper Clearance, and Brushes have been Seated Properly	(P) Pass
	104. Assembled Shaft End Play and Runout	
	Shaft Endplay	Shaft Runout

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105. Perform No-Load Test Run, Record Armature Voltage and Current

Voltage	Current
496.7	1.9



106. Perform No-Load Test Run, Record Field Voltage and Current

Voltage	Current
299	2.8



107. Document Vibration Readings Drive End

Horizontal	Vertical	Axial
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108. Document Vibration Readings Opposite Drive End

Horizontal	Vertical	Axial
------------	----------	-------

109. Perform Full-Load Test Run, Record Armature Voltage and Current

Voltage	Current
---------	---------

110. Perform Full-Load Test Run, Record Field Voltage and Current

Voltage	Current
---------	---------

111. Document Vibration Readings Under Full Load Drive End

Horizontal	Vertical	Axial
.01	.01	.01

112. Document Vibration Readings Under Full Load Opposite Drive End		
Horizontal	Vertical	Axial
.01	.01	.01
113. Ambient Temperature		
114. Drive End Bearing Temps Under Full Load		
5 Minutes	10 Minutes	15 Minutes
115. Opposite Drive End Bearing Temps Under Full Load		
5 Minutes	10 Minutes	15 Minutes
116. Final Test Run Sign-Off		
117. Document Final Condition With Pictures		



118. Final QC Sign-Off

RW

[Handwritten signature]



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1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
2. **PRICE.** All quoted prices shall remain firm and binding for a period of thirty (30) days from the date of quotation or for the period specifically stated in the quotation. The price for any and all goods and/or services ordered or approved by Buyer after thirty (30) days from the date of any quotation are subject to any increase in price that may occur after the expiration of thirty (30) days from the issuance of the quotation and the date the Buyer releases any shipment.
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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.
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.
7. **INSPECTION/ACCEPTANCE.** All goods and services ordered pursuant to any quotation shall be subject to inspection by Buyer after delivery or performance to determine conformity with the quotation and/or purchase order and Hi-Speed's advertised or published specifications. Buyer shall have a period of thirty (30) days from shipment of goods at the delivery destination specified in the quotation within which to inspect the goods for conformity with the quotation, order and/or Hi-Speed's advertised and published specifications and to provide Hi-Speed with written notice of any discrepancy or rejection. Buyer shall have a period of thirty (30) days following completion of any services within which to inspect the services for conformity with the quotation, purchase order and/or Hi-Speed's advertised and published specifications and to provide Hi-Speed with written notice of any discrepancy or rejection. If the goods delivered or services performed do not so conform, upon delivery of notice to Hi-Speed of any discrepancy, nonconformance or rejection, Hi-Speed shall have sixty (60) days to cure the alleged discrepancy and/or nonconformance. If Hi-Speed fails to cure in this time period, Buyer shall have the right to reject such goods or services. After the cure period, goods that have been delivered and rejected, in whole or in part, shall be returned to Hi-Speed. Buyer shall notify Hi-Speed and arrange for the return of the goods as required. Should such non-conforming services be rejected Hi-Speed shall, at its sole cost, re-perform the non-conforming services. Inspection or failure to inspect on any occasion shall not affect Buyer's rights under the warranty provisions herein.
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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10. **SEVERABILITY.** The partial or complete invalidity of any provision of these Standard Terms and Conditions shall not affect the enforceability of the remainder of these Standard Terms and Conditions. If any provision is found to be invalid or unenforceable, that portion shall be modified to make it enforceable or shall be stricken and the remainder of these Standard Terms and Conditions shall enforced.
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.
12. **ABANDONED EQUIPMENT.** Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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.
14. **NONWAIVER.** No course of dealing or failure of either party to strictly enforce any term, right, or condition of these Standard Terms and Conditions will be construed as a waiver of such term, right or condition. Any waiver by Hi-Speed will only be in writing and will waive no succeeding breach of a term, right or condition.
15. **ASSIGNMENT.** The rights and obligations of the parties shall neither be assigned nor delegated without the prior written consent of the other party. However, any party may assign or delegate its respective rights and obligations, in whole or in part, (i) to any subsidiary, (ii) pursuant to other financing, merger or reorganization or (iii) pursuant to any sale or transfer of substantially all of the assets of the assigning party. These Standard Terms and Conditions shall bind the heirs, successors and assigns of the parties hereto.
16. **NO INDIVIDUAL LIABILITY.** Notwithstanding any other agreement to the contrary, the Buyer agrees that in no event will the Buyer hold and Hi-Speed owner, director, officer or employee personally liable for unintentional tortious conduct or conduct that constitutes the breach of any contract between Hi-Speed and the Buyer, even if the Hi-Speed owner, director, officer or employee is or could be construed to be a party to such contract.