



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

LR Motor Shop Repairs

Job Number 100090

Prepared for Lexicon (10257)

8900 Fouche Dam Pike
Little Rock AR

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

AC Recondition As Found

Lexicon (10257)
8900 Fouche Dam Pike
Little Rock, AR

FolderID: 100090
FormID: 14181951

AC Recondition - Rev. 2

Location: SHOP

Serial Number: 823471A-6

Description: 20HP REULAND 1800RPM WER-324S

Hi-Speed Job Number: 100090

Manufacturer: Other

Product Number: 3888-XH8787C

Serial Number: 823471A-6

HP/kW: 20 (HP)

RPM: 1800 (RPM)

Frame: WER-324S

Voltage: 230 / 460

Current: 51.2/25.6

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TENV

J-box Included: None

Coupling/Sheave: None

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Shaft Machined Fit Repairs
Required: Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: 1 - 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

Dirty

Initial Mechanical/Electrical

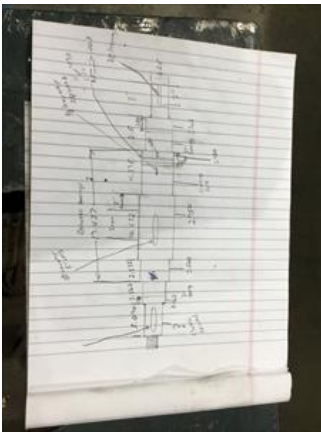
● 5. Does Shaft Turn Freely?

(Yes) Yes

6. Does Shaft Have Visible Damage?

(Yes) Yes

Machine new shaft



Clutch shaft dimensions to match new bore in clutch spindle.

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	pass
13. Fan Condition	(N) NA
14. Broken or Missing Components	key for clutch, a cover, ode end bell is cracked

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Initial Electrical Inspection

15. Insulation Resistance/Megger	Megohms		
16. Winding Resistance			
1-2	1-3	2-3	

17. Perform Surge Test (F) Fail

Rotor and stator is blown

18. Stator Condition

Mechanical Inspection

19. Drive End Bearing Number-	6311-2RS
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?	na
24. Drive End Wavy Washer/Snap-Ring Other Retention Device?	na
25. Drive End Bearing Condition	worn
26. Opposite Drive End Bearing Number-	6311-2RS
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?	na
31. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
32. Opposite Drive End Bearing Condition	worn
33. Drive End Seal	na
34. Opposite Drive End Seal	na

Rotor Inspection

35. Rotor Type/Material

Wound rotor

36. Growler Test (Fail) Fail

37. Number of Rotor Bars

38. Rotor Condition

windings blown

39. List the Parts needed for the Repair Below

6311-2RS x 2
12 brushes
6014-2RS x2

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40. Signature of Technician that Disassembled Motor

Cw



Mechanical Fits- Rotor

41. Shaft Runout

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

 Pass

 46. Drive End Bearing Shaft Fit Condition

(P) Pass

47. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

 Pass

 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

 Pass

 51. Drive End - Endbell Bearing Fit Condition

(P) Pass

52. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

 Pass

 53. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass

54. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

 Na

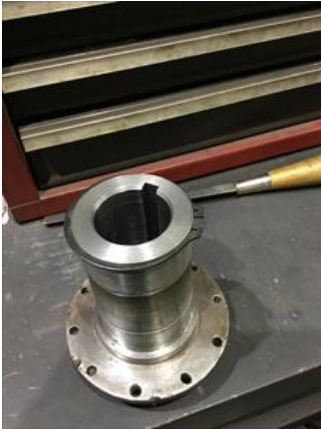
55. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

56. List Machine Work Needed Below

DE shaft key way is destroyed along with the clutch key way and the threaded part of the DE shaft is broke off



Sleeved, welded and remachined clutch spindle.

57. Technician

Gary

[Handwritten signature: Gary]

Dynamic Balance Report

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

Rewind

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

Root Cause of Failure

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70. Failure locations

De shaft key way and threaded part of the shaft broke and stator and rotor windings are blown

71. Root cause of failure

*Threaded part of shaft broke allowing clutch to be loose rocking side to side wearing out keyway.
Rotor windings blow from overload causing stator to blow*

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

🗨 *Sleeved clutch bearing housing*



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

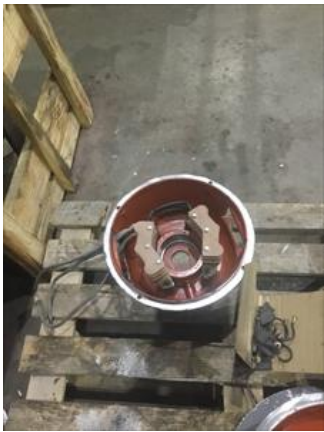
80. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
4.7247	4.7248	4.7248



81. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees		60 Degrees	
		120 Degrees	
82. Bearing Cap Condition Post Repair			
Drive End Bearing Cap		Opposite Drive End Bearing Cap	
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

(Complete) Complete



86. Final Insulation Resistance Test

87. Assembled Shaft Endplay

88. Assembled Shaft Runout

89. Test Run Voltage

Volts

Volts

Volts

456

455

456



Slip ring

Motor

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90. Test Run Amperage		
Amps	Amps	Amps
9.6	9.800000000000001	9.4



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		



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

RW

RW



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

AC Random Coil Rewind Report

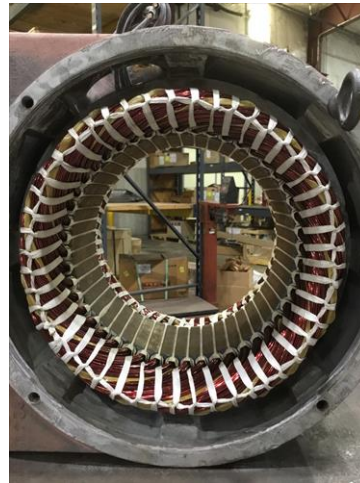
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Lexicon (10257)
8900 Fouche Dam Pike
Little Rock, AR

Priorities Found: ● 1 - Good

General

1. Job Number	100090
2. Report Date	
3. Customer	Prospect Steel



Stator Winding

4. Core Length	4.25 "
5. Core ID	9.375 "
6. Back Iron Depth	1.125 "
7. Slot Depth	1.062 "
8. Tooth Width	0.319 "
9. Number of Vents	
10. Vent Width	

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2.0

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	36 Lbs.
31. Lead Markings	
32. Grouping 12 of 4	
33. Multiple Wires	(Y) Yes
34. Wire Size 3#16&2#17	
35. Turns per coil	8
36. Pitch 1 to:	11
37. Connection 1y	
38. Lead Length	12 "
39. Lead Size 12	
40. Number of Leads	3
41. Megger Reading After Rewind	Mohms
42. Coil Machine Slot Head 5	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	
46. Surge Pattern After Rewind	
47. Service Technician	R H Roberson

✓ 12 1 + 8 12

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