



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

LR Motor Shop Repairs

Job Number 100392

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: 100392
FormID: 14720015

AC Recondition - Rev. 2

Location: SHOP
Serial Number: 736261D 13001 2010
Description: 22.2KW LEROY SOMERS 1760RPM
TWO SPEED

| | |
|---|--------------------|
| Hi-Speed Job Number: | 99633 |
| Manufacturer: | Leroy Somer |
| Product Number: | LS180LG-T |
| Serial Number: | 736261D 13001 2010 |
| HP/kW: | 22.2 (kW) |
| RPM: | 1760 (RPM) |
| Voltage: | 460 |
| Current: | 35.7 |
| Phase: | Three |
| Hz: | 60 (Hz) |
| Enclosure: | ODP |
| J-box Included: | Complete |
| Coupling/Sheave: | Coupling |
| Date Received: | 04/08/2022 |
| Bearing RTDs: | No |
| Stator RTDs: | No |
| Repair Stage: | Final |
| Rewind: | Yes |
| Shaft Machined Fit Repairs Required: | Yes |
| Bearing Housing Machined Fit Repairs Required: | No |
| 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 | |
| | <i>Serviceable</i> | |
| 5. | Distance from the end of the shaft to the Coupling/Sheave | |
| Initial Mechanical/Electrical | | |
| 6. | Does Shaft Turn Freely? | (Yes) Yes |
| 7. | Does Shaft Have Visible Damage? | (No) No |
| 8. | Assembled Shaft Runout | |
| 9. | Assembled Shaft End Play | |
| 10. | Air Gap Variation <10% | |
| 11. | Lead Condition | (P) Pass |
| 12. | Lead Length | |
| 13. | Frame Condition | |

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15. Broken or Missing Components

Initial Electrical Inspection

16. Insulation Resistance/Megger

Megohms

17. Winding Resistance

1-2

1-3

2-3

18. Perform Surge Test

19. Stator Condition

rewind**Mechanical Inspection**

20. Drive End Bearing Number-

6312 2Z



| | |
|---|----------------------------|
| 21. Drive End Bearing Qty. | 1 |
| 22. Drive End Bearing Type | (Ball) Ball Bearing |
| 23. Drive End Lubrication Type | (Grease) Grease Lubricated |
| 24. Drive End Bearing Insulation or Grounding Device? | none |
| 25. Drive End Wavy Washer/Snap-Ring Other Retention Device? | none |
| 26. Drive End Bearing Condition | none |
| 27. Opposite Drive End Bearing Number- | 6214 2Z |



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| | |
|--|----------------------------|
| 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? | none |
| 32. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? | yes |



| | |
|--|---------|
| 33. Opposite Drive End Bearing Condition | replace |
| 34. Drive End Seal | |
| 35. Opposite Drive End Seal | |

Rotor Inspection

36. Rotor Type/Material

(Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast

| | |
|---|-------------------|
| 37. Growler Test | (Pass) Pass |
| 38. Number of Rotor Bars | 54 |
| 39. Rotor Condition | pass |
| 40. List the Parts needed for the Repair Below | |
| 41. Signature of Technician that Disassembled Motor | Terrence. Holland |

Mechanical Fits- Rotor

| | |
|------------------|--------------|
| 42. Shaft Runout | 0.002 inches |
|------------------|--------------|

| | |
|------------------|--|
| 43. Rotor Runout | |
|------------------|--|

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

| | |
|---|--|
| 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

2.3628

2.3627

2.3627

| | |
|---|----------|
| 47. Drive End Bearing Shaft Fit Condition | (P) Pass |
|---|----------|

| | |
|--|--|
| 48. Opposite Drive End Bearing Shaft Fit | |
|--|--|

0 Degrees

60 Degrees

120 Degrees

2.7555

2.7556

2.7556

| | |
|--|----------|
| 49. Opposite Drive End Bearing Shaft Fit Condition | (F) Fail |
|--|----------|

Too small

| | |
|-------------------------|--|
| 50. Shaft Air Seal Fits | |
|-------------------------|--|

Drive End Air Seal

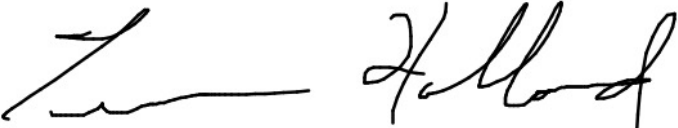
Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

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| | | |
|--|--------------------------------|-------------|
| 51. Drive End - Endbell Bearing Fit | | |
| 0 Degrees | 60 Degrees | 120 Degrees |
| 52. Drive End - Endbell Bearing Fit Condition | | (P) Pass |
| 53. Opposite Drive End - Endbell Bearing Fit | | |
| 0 Degrees | 60 Degrees | 120 Degrees |
| 54. Opposite Drive End - Endbell Bearing Fit Condition | | (P) Pass |
| 55. Bearing Cap Condition | | |
| Drive End Bearing Cap | Opposite Drive End Bearing Cap | |
| pass | pass | |



| | |
|---|-----------------------------|
| 56. End Bell Air Seal Fits | |
| Drive End Air Seal | Opposite Drive End Air Seal |
| 57. List Machine Work Needed Below <i>Ode shaft bearing journal.</i> | |
| 58. Technician | Terrence Holland |
|  | |

Dynamic Balance Report

59. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



60. Initial Balance Readings

Drive End

Opposite Drive End

1.45

248

61. Final Balance Readings

Drive End

Opposite Drive End

1.08

.080

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

Windings/ode shaft bearing journal.

72. Root cause of failure

Electrical Overload.

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

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| | | |
|--|---------------|---------------|
| 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 |
| 2.7562 | 2.7563 | 2.7563 |



| | | |
|-------------------------------------|-----------------------------|--|
| 79. Shaft Air Seal Fits Post Repair | | |
| Drive End Air Seal | Opposite Drive End Air Seal | |
| 80. Shaft Repair Sign-off | | |
| Assembly | | |

81. Photograph All Major Components prior to assembly



82. Final Insulation Resistance Test

83. Assembled Shaft Endplay

84. Assembled Shaft Runout

85. Test Run Voltage

Volts

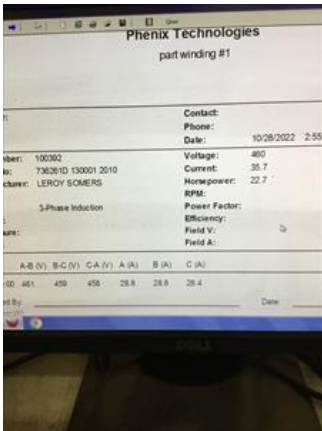
Volts

Volts

461

459

460



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| | | |
|---|------------|------------|
| 86. Test Run Amperage | | |
| Amps | Amps | Amps |
| 10.1 | 10.5 | 9.4 |
| 87. Drive End Vibration Readings - Inches Per Second | | |
| Horizontal | Vertical | Axial |
| 88. Opposite Drive End Vibration Readings - Inches Per Second | | |
| Horizontal | Vertical | Axial |
| 89. Ambient Temperature - Fahrenheit | | |
| 90. Drive End Bearing Temps - Fahrenheit | | |
| 5 Minutes | 10 Minutes | 15 Minutes |
| 91. Opposite Drive End Bearing Temps - Fahrenheit | | |
| 5 Minutes | 10 Minutes | 15 Minutes |
| 92. Final Test Run Sign-off | | |
| 93. Document Final Condition with Pictures after paint | | Looks good |
| 94. Final Pics and QC Review | | |





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

AC Random Coil Rewind Report

FolderID: 100392
FormID: 14895333

Lexicon (10257)

8900 Fouche Dam Pike
Little Rock, AR

Priorities Found: ● 2 - Good

General

| | |
|----------------|----------------|
| 1. Job Number | 10039 |
| 2. Report Date | 10/24/2022 |
| 3. Customer | Prospect Steel |

Stator Winding

| | |
|----------------|------|
| 4. Core Length | 10 " |
|----------------|------|



| | |
|---------------------------------------|---------|
| 5. Core ID | 7.875 " |
| 6. Back Iron Depth | 1.125 " |
| 7. Slot Depth | 1.125 " |
| 8. Tooth Width | 0.162 " |
| 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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2.0

| | |
|---|-------------------|
| 23. Heater Qty. | |
| 24. Heater Voltage | |
| 25. Heater Wattage | Watts |
| 26. Thermistors | (Y) Yes |
| 1 | |
| 27. Number of Poles | 4 |
| 4/12 | |
| 28. Slots | 72 |
| 29. Number of Coils | 84 |
| 36-High speed 48- Low speed | |
| 30. Coil Weight | 50 Lbs. |
| 31. Lead Markings | |
| 11,12,13 -High speed 1,2,3 - low speed | |
| 32. Grouping | |
| High speed - 12 of 3 Low speed -24 of 2 | |
| 33. Multiple Wires | (Y) Yes |
| 34. Wire Size | |
| H- 4#18 , 2#19 L- 2#18,3#20 | |
| 35. Turns per coil | |
| H-6 L-7&15 | |
| 36. Pitch 1 to: | |
| H-14,16,18 L-4,6 | |
| 37. Connection | |
| 1 wye 1 Wye | |
| 38. Lead Length | 36 " |
| 39. Lead Size | 10 |
| 40. Number of Leads | 6 |
| 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 | Robert H R |
|  | |



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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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