



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

LR Motor Shop Repairs

Job Number 99963

Prepared for Twin Rivers (12049)

3501 Jefferson Parkway
Pine Bluff AR 71602

Table of Contents



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

AC Recondition As Found

Twin Rivers (12049)
3501 Jefferson Parkway
Pine Bluff, AR 71602

FolderID: 99963
FormID: 13912456

AC Recondition - Rev. 2

Location: Shop
Serial Number: PG.FD212006TH
Description: 800HP TECO 1200RPM 6808

Hi-Speed Job Number:	99963
Manufacturer:	TECO Westinghouse
Product Number:	KPF8006G
Serial Number:	PG.FD212006TH
HP/kW:	800 (HP)
RPM:	1192 (RPM)
Frame:	6808
Voltage:	2300/4160
Current:	189.3/108.9
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	06/23/2022
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Shaft Machined Fit Repairs Required:	Yes
Bearing Housing Machined Fit Repairs Required:	No
Heaters:	Yes
Winding Type :	Form Coil
Bearing Type:	Rolling Element

Priorities Found: ● 1 - Good

Overall Condition

1. Report Date
2. Nameplate Picture

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3. Describe the Overall Condition of the Equipment as Received
4. Photos of all six sides of the machine.

Initial Mechanical/Electrical

5. Does Shaft Turn Freely?
6. Does Shaft Have Visible Damage?
7. Assembled Shaft Runout
8. Assembled Shaft End Play
9. Air Gap Variation <10%
10. Lead Condition
11. Lead Length
12. Frame Condition
13. Fan Condition
14. Heater Quantity, Ratings

Quantity	Volts/Watts	Pass/Fail
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15. Broken or Missing Components

Initial Electrical Inspection

16. Insulation Resistance/Megger
17. Winding Resistance

1-2	1-3	2-3
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18. Perform Surge Test

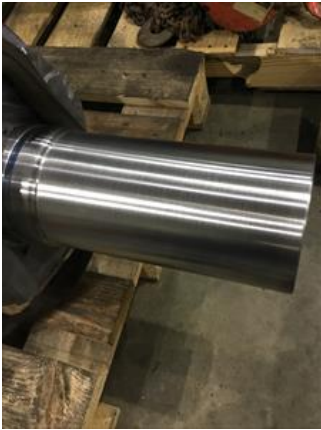
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19. Stator Condition
Mechanical Inspection
20. Drive End Bearing Number-
21. Drive End Bearing Qty.
22. Drive End Bearing Type
23. Drive End Lubrication Type
24. Drive End Bearing Insulation or Grounding Device?
25. Drive End Wavy Washer/Snap-Ring Other Retention Device?
26. Drive End Bearing Condition
27. Opposite Drive End Bearing Number-
28. Opposite Drive End Bearing Qty.
29. Opposite Drive End Bearing Type
30. Opposite Drive End Lubrication Type
31. Opposite Drive End Bearing Insulation or Grounding Device?
32. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?
33. Opposite Drive End Bearing Condition
34. Drive End Seal
35. Opposite Drive End Seal
Rotor Inspection
36. Rotor Type/Material
37. Growler Test
38. Number of Rotor Bars
39. Rotor Condition
40. List the Parts needed for the Repair Below
41. Signature of Technician that Disassembled Motor
Mechanical Fits- Rotor
42. Shaft Runout inches
43. Rotor Runout
<div style="display: flex; justify-content: space-between;"> Drive End Bearing Fit Rotor Body Opposite Drive End Bearing </div>
44. Coupling Fit Closest to Bearing Housing
<div style="display: flex; justify-content: space-between;"> 0 Degrees 90 Degrees 120 Degrees </div>
5
45. Coupling Fit Closest to the end of the Shaft
<div style="display: flex; justify-content: space-between;"> 0 Degrees 60 Degrees 120 Degrees </div>
5
46. Drive End Bearing Shaft Fit
<div style="display: flex; justify-content: space-between;"> 0 Degrees 60 Degrees 120 Degrees </div>
47. Drive End Bearing Shaft Fit Condition
48. Opposite Drive End Bearing Shaft Fit
<div style="display: flex; justify-content: space-between;"> 0 Degrees 60 Degrees 120 Degrees </div>
49. Opposite Drive End Bearing Shaft Fit Condition
50. Shaft Air Seal Fits
<div style="display: flex; justify-content: space-between;"> Drive End Air Seal Opposite Drive End Air Seal </div>

Mechanical Fits- Bearing Housings		
51. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
52. Drive End - Endbell Bearing Fit Condition		
53. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
54. Opposite Drive End - Endbell Bearing Fit Condition		
55. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
56. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
57. List Machine Work Needed Below		
58. Technician		
Dynamic Balance Report		
59. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
60. Initial Balance Readings		
Drive End	Opposite Drive End	
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		
72. Root cause of failure		
Mechanical Fits- Rotor - Post Repair		
73. Shaft Runout Post Repair		0.0005 inches

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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	
4.875	4.8752	4.875	



Modified key. Machined height to 1.173.

76. Coupling Fit Closest to the end of the Shaft Post Repair			
0 Degrees	60 Degrees	120 Degrees	
4.875	4.8749	4.8749	
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	
79. Shaft Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
80. Shaft Repair Sign-off			Gary Moore
Assembly			
81. Photograph All Major Components prior to assembly			(Complete) Complete



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82. Final Insulation Resistance Test

43,500 Megohms

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1.9



83. Assembled Shaft Endplay		
84. Assembled Shaft Runout		0.0005 inches
85. Test Run Voltage		
Volts	Volts	Volts
2282	2298	2304
High Voltage 4124 4138 4165		



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86. Test Run Amperage

Amps

Amps

Amps

67.09999999999999

63.3

64.3

High Voltage 42.6 40.2 40.9



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. Stator Temperatures- Fahrenheit

5 Minutes

10 Minutes

15 Minutes

93. Final Test Run Sign-off

94. Document Final Condition with Pictures after paint



95. Final Pics and QC Review

RW

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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

replace any defective or non-conforming goods in accordance with the applicable manufacturer's warranty. Warranty for any defective or incorrect parts is limited to the repair or replacement of those parts. Hi-Speed warrants that all services will conform in all material respects to the description of services identified in the quotation and will be performed in a good and workmanlike manner in accordance with industry practices and standards. Should the services be reasonably rejected or not conform with the foregoing warranties, Hi-Speed shall, at its sole cost, re-perform the defective or nonconforming services. Notwithstanding the foregoing, these warranties do not extend to goods or services to the extent that such goods have been subject to misuse, neglect or abuse not caused by Hi-Speed or have been used in violation of the approved written instructions furnished to Buyer. THE FOREGOING REPRESENTS THE SOLE AND EXCLUSIVE WARRANTY GIVEN BY HI-SPEED WITH RESPECT TO ALL GOODS SOLD AND IS IN LIEU OF ALL OTHER WARRANTIES EITHER EXPRESS OR IMPLIED. HI-SPEED EXPRESSLY DISCLAIMS ALL OTHER WARRANTIES INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR USE OR PURPOSE. BUYER WAIVES ANY CLAIM THAT THESE EXCLUSIONS OR LIMITATIONS DEPRIVE IT OF AN ADEQUATE REMEDY AT EQUITY OR LAW OR CAUSE THIS AGREEMENT TO FAIL IN ITS ESSENTIAL PURPOSE. BUYER SHALL BE ENTITLED TO NO OTHER REMEDY OTHER THAN AS SET FORTH HEREIN, REGARDLESS OF THE CLAIM OR CAUSE OF ACTION, WHETHER BASED IN CONTRACT, TORT, NEGLIGENCE, GOODS LIABILITY, STRICT LIABILITY OR OTHERWISE.

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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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