



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

LR Motor Shop Repairs

Job Number 100035

Prepared for Twin Rivers (12049)

1701 Jefferson Parkway
White Hall 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)
1701 Jefferson Parkway
White Hall, AR 71602

FolderID: 100035
FormID: 14047946

AC Recondition - Rev. 2

Location: Shop
Serial Number: 324ZLPH
Description: 25HP US MOTORS 1200RPM
324ZLPH

Hi-Speed Job Number:	100034
Manufacturer:	US Motors/Nidec
HP/kW:	25 (HP)
RPM:	1190 (RPM)
Frame:	324ZLPH
Voltage:	460
Current:	31
Phase:	Three
Hz:	60 (Hz)
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	07/11/2022
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

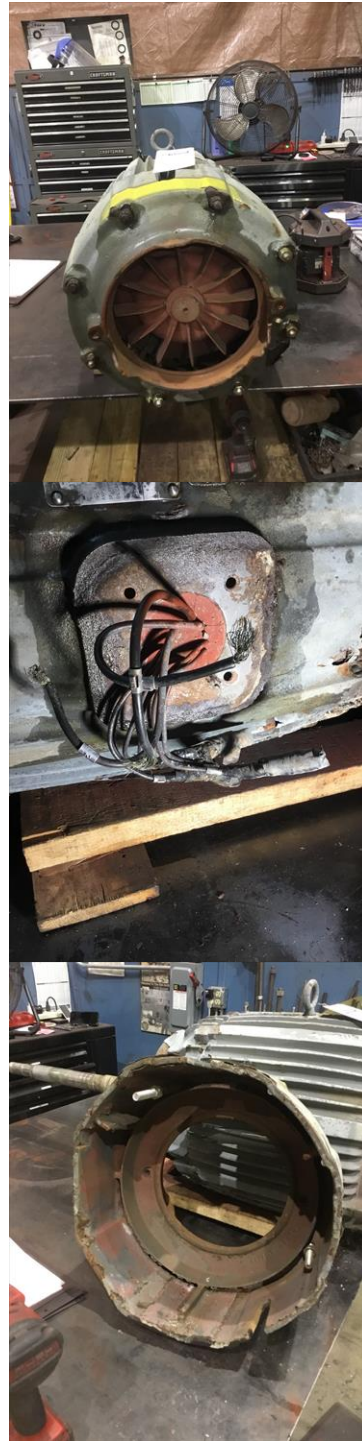
Priorities Found: ● 5 - Good

Overall Condition

1. Report Date
2. Nameplate Picture



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3. Describe the Overall Condition of the Equipment as Received

Dirty but okay

4. Photos of all six sides of the machine.

Initial Mechanical/Electrical

● 5. Does Shaft Turn Freely?

(Yes) Yes

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6. Does Shaft Have Visible Damage?

(Yes) Yes



7. Assembled Shaft Runout

8. Assembled Shaft End Play

9. Air Gap Variation <10%

10. Lead Condition



11. Lead Length

8 Inches

12. Frame Condition

pass

13. Fan Condition

(P) Pass

14. Broken or Missing Components

fan cover

Initial Electrical Inspection

15. Insulation Resistance/Megger

16. Winding Resistance

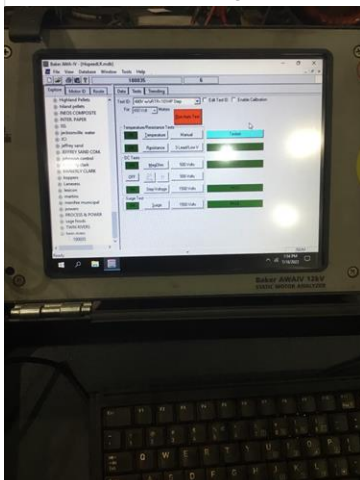
1-2

1-3

2-3

17. Perform Surge Test

(P) Pass



18. Stator Condition

shaft bent 40ths

Mechanical Inspection

19. Drive End Bearing Number-

5216



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?

none

24. Drive End Wavy Washer/Snap-Ring Other Retention Device?

none

25. Drive End Bearing Condition

worn

26. Opposite Drive End Bearing Number-

6211



27. Opposite Drive End Bearing Qty.

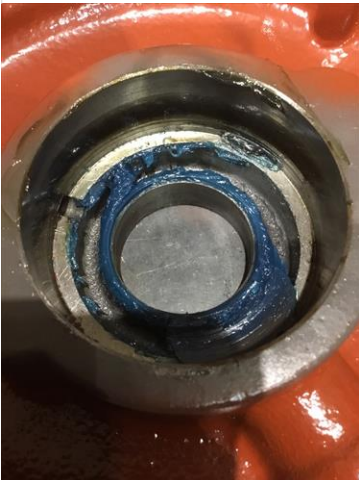
1

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?

none

31. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?

none

32. Opposite Drive End Bearing Condition



33. Drive End Seal

34. Opposite Drive End Seal

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Rotor Inspection

- | | |
|--|--|
| 35. Rotor Type/Material | (Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast |
| 36. Growler Test | (Pass) Pass |
| 37. Number of Rotor Bars | |
| 38. Rotor Condition | pass. shaft bent out of limits |
| 39. List the Parts needed for the Repair Below
<i>5216 2rs, 62112rs, fan cover, seal, shaft</i> | |
| 40. Signature of Technician that Disassembled Motor | Terrence Holland |


Mechanical Fits- Rotor

- | | | | |
|--|-----------------------------|----------------------------|--|
| 41. Shaft Runout | 0.04 inches | | |
| 42. Rotor Runout | | | |
| Drive End Bearing Fit | Rotor Body | Opposite Drive End Bearing | |
| 0.04 | | | |
| 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 | |
| 3.1503 | | | |
| 46. Drive End Bearing Shaft Fit Condition | | | |
| 47. Opposite Drive End Bearing Shaft Fit | | | |
| 0 Degrees | 60 Degrees | 120 Degrees | |
| 2.1661 | 2.1662 | 2.1661 | |
| 48. Opposite Drive End Bearing Shaft Fit Condition | | | |
| 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 | |
| 5.5126 | 5.5127 | 5.5127 | |
| 51. Drive End - Endbell Bearing Fit Condition | (P) Pass | | |
| 52. Opposite Drive End - Endbell Bearing Fit | | | |
| 0 Degrees | 60 Degrees | 120 Degrees | |
| 3.9377 | 3.9378 | 3.9378 | |
| 53. Opposite Drive End - Endbell Bearing Fit Condition | (P) Pass | | |

54. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap



55. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

56. List Machine Work Needed Below

New shaft needed.

57. Technician

Terrence. Holland

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		
70. Failure locations <i>D.E. Shaft bent.</i>		
71. Root cause of failure <i>Shaft bent out of limits.</i>		
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
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	



 *Machined new shaft.*



Mechanical Fits- Bearing Housings - Post Repair

80. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

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

86. Final Insulation Resistance Test

87. Assembled Shaft Endplay

88. Assembled Shaft Runout

89. Test Run Voltage

Volts

Volts

Volts

90. Test Run Amperage

Amps

Amps

Amps

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

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