



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

LR Motor Shop Repairs

Job Number 99920

Prepared for Twin Rivers (12049)

1701 Jefferson Parkway
White Hall AR 71602

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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: 99920
FormID: 13837184

AC Recondition - Rev. 2

Location: Shop
Serial Number: TZ.AD146029-1
Description: 800HP TECO 1200RPM 6808B

Hi-Speed Job Number: 99920
Manufacturer: TECO Westinghouse
Product Number: KG8006
Serial Number: TZ.AD146029-1
HP/kW: 800 (HP)
RPM: 1185 (RPM)
Frame: 6808B
Voltage: 2300/4160
Current: 179.3/99.1
Phase: Three
Hz: 60 (Hz)
Service Factor: 1.15
Enclosure: TEFC
J-box Included: Complete
Coupling/Sheave: None
Date Received: 06/14/2022
Bearing RTDs: Yes
Stator RTDs: Yes
Repair Stage: Final
Heaters: Yes
Winding Type : Form Coil
Bearing Type: Rolling Element

Priorities Found: ● 1 - High ● 1 - Low ● 7 - Good

Overall Condition

- | | |
|----------------------|-----------|
| 1. Report Date | 6/15/2022 |
| 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

<input checked="" type="radio"/>	5. Does Shaft Turn Freely?	(Yes) Yes
<input type="radio"/>	6. Does Shaft Have Visible Damage?	(No) No
<input type="radio"/>	7. Assembled Shaft Runout	
<input type="radio"/>	8. Assembled Shaft End Play	
<input type="radio"/>	9. Air Gap Variation <10%	

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10. Lead Condition

(P) Pass



11. Lead Length

24 Inches

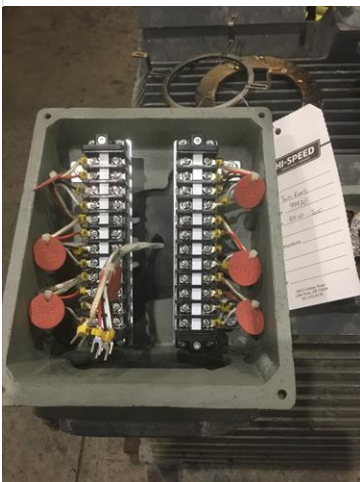
12. Stator Temperature Detector Rating and Function

Quantity

Rating

Quantity Passed

7



13. Bearing Temperature Detector Rating and Function

Quantity

Rating

Quantity Passed

14. Frame Condition

pass

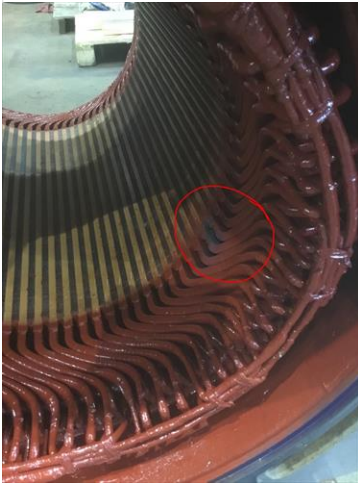
15. Fan Condition

(P) Pass



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16. Heater Quantity, Ratings		
Quantity	Volts/Watts	Pass/Fail
2	120/200W	pass
17. Broken or Missing Components		
Initial Electrical Inspection		
18. Insulation Resistance/Megger		0 Megohms
19. Winding Resistance		
1-2	1-3	2-3
20. Perform Surge Test (F) Fail		
Grounded		



Grounded at edge of slot



21. Stator Condition	rewind
22. Number of Stator Slots	
Mechanical Inspection	
23. Drive End Bearing Number-	6326
24. Drive End Bearing Qty.	1
25. Drive End Bearing Type	(Ball) Ball Bearing
26. Drive End Lubrication Type	(Grease) Grease Lubricated
27. Drive End Bearing Insulation or Grounding Device?	Aegis ring



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

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29. Drive End Bearing Condition



30. Opposite Drive End Bearing Number-	6322
31. Opposite Drive End Bearing Qty.	1
32. Opposite Drive End Bearing Type	(Ball) Ball Bearing
33. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
34. Opposite Drive End Bearing Insulation or Grounding Device?	no
35. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	
36. Opposite Drive End Bearing Condition	



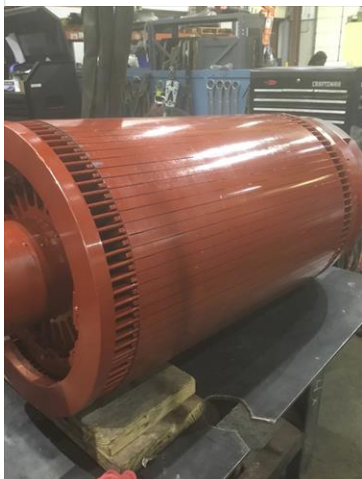
37. Drive End Seal
38. Opposite Drive End Seal

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Rotor Inspection

39. Rotor Type/Material

(Copper Barred) Copper
Barred Rotor



40. Growler Test

41. Number of Rotor Bars

88

42. Rotor Condition

pass

43. List the Parts needed for the Repair Below

6326

6322

AEGIS Ring

44. Signature of Technician that Disassembled Motor

Robert Wiley

Mechanical Fits- Rotor

45. Shaft Runout

46. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

47. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees


120 Degrees

48. Coupling Fit Closest to the end of the Shaft


0 Degrees

60 Degrees

120 Degrees

49. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
5.1187	5.1187	5.1187	
			
50. Drive End Bearing Shaft Fit Condition			(P) Pass
51. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
4.331	4.331	4.331	
			
52. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
53. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Mechanical Fits- Bearing Housings			
54. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
11.0246	11.0246	11.0246	
55. Drive End - Endbell Bearing Fit Condition			(P) Pass
56. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
9.4495	9.4495	9.4495	
57. Opposite Drive End - Endbell Bearing Fit Condition			(P) Pass

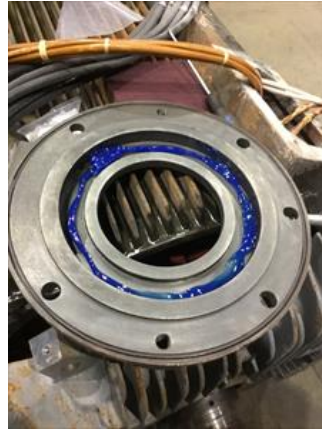
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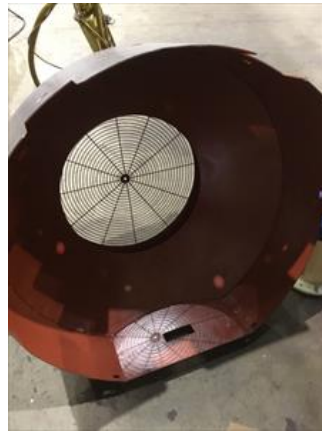
58. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
yes	yes	
59. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
60. List Machine Work Needed Below		
61. Technician	RW	
		
Dynamic Balance Report		
62. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
63. Initial Balance Readings		
Drive End	Opposite Drive End	
64. Final Balance Readings		
Drive End	Opposite Drive End	
65. Technician		
Rewind		
66. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	
67. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	
68. Post Rewind Electrical Test- Insulation Resistance		
69. Post Rewind Polarization Index		
70. Post Rewind Winding Resistance		
1-2	1-3	2-3
71. Post Rewind Surge Test		
(Pass) Pass		
72. Post Rewind Hi-Pot		
73. Technician		
Root Cause of Failure		
74. Failure locations		
<i>Stator - Drive end, end of core iron slot</i>		
75. Root cause of failure		
<i>Moisture caused motor to short to ground upon startup</i>		
Mechanical Fits- Rotor - Post Repair		
76. Shaft Runout Post Repair		
77. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

78. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
79. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
80. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
81. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
82. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
83. Shaft Repair Sign-off		
Mechanical Fits- Bearing Housings - Post Repair		
84. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
85. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
86. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
87. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
88. End Bell Repair Sign-off		
Assembly		
89. Photograph All Major Components prior to assembly		



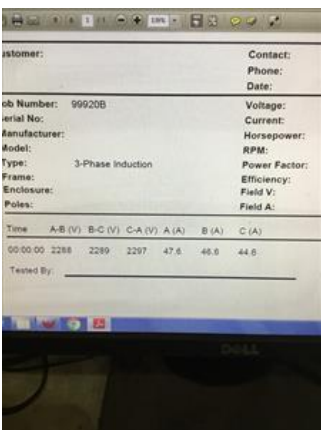








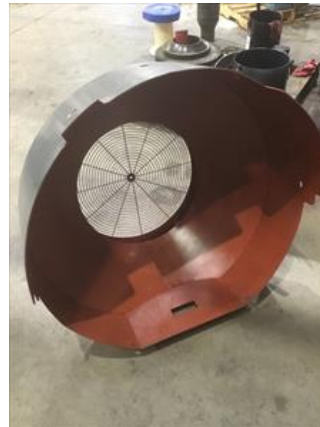
90. Final Insulation Resistance Test	Megohms	
91. Assembled Shaft Endplay		
92. Assembled Shaft Runout		
93. Test Run Voltage		
Volts	Volts	Volts
4150	4159	4172



94. Test Run Amperage		
Amps	Amps	Amps
28.8	28.4	27.3

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95. Drive End Vibration Readings - Inches Per Second			
Horizontal		Vertical	Axial
0.0412		362	0.0993
96. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal		Vertical	Axial
0.0594		0.0372	0.0877
97. Ambient Temperature - Fahrenheit			70.2
98. Drive End Bearing Temps - Fahrenheit			
5 Minutes		10 Minutes	15 Minutes
71		74.2	81
99. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes		10 Minutes	15 Minutes
70.3		73.2	79.2
100. Stator Temperatures- Fahrenheit			
5 Minutes		10 Minutes	15 Minutes
101. Final Test Run Sign-off			David Maclin
			
102. Document Final Condition with Pictures after paint			



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103. Final Pics and QC Review

David Maclin

1220



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

AC Form Coil Winding Report

FolderID: 99920
FormID: 14475239

Twin Rivers (12049)
1701 Jefferson Parkway
White Hall, AR 71602

Priorities Found: ● 1 - Good

Stator Winding

1. Core Length


"



2. Core ID	"
3. Back Iron Depth	1.75 "
4. Finger Plate Width	0.437 "
5. Overall Coil Length	9 "
6. Connection End Extension Length	"
7. Opposite Connection End Extension Length	
8. Straight Length Bottom Side	
9. Straight Length Top Side	
10. Small knuckle drop Connection End	
11. Small knuckle drop opposite connection end	
12. Large knuckle drop connection end	
13. Large knuckle drop opposite connection end	
14. Connection Support Ring from Core	
15. Opposite Connection Support Ring from core	
16. Connection Support Ring Id	
17. Opposite Connection Support Ring ID	
18. Slot Depth	2.25 "
19. Slot depth under wedge	2.248
20. Slot Width	0.495
21. Lead Location	B
22. Coil Type	BH
23. Tooth Width	"

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24. Number of Vents	0
25. Vent Width	"
26. Before Burnout Core loss	
27. Flux Before Burnout	
28. Watts before burnout	
29. Watts loss per lb. before burnout	
30. After Burnout Core Loss	
31. Flux After burnout	
32. Watts After Burnout	
33. Watts loss per lb After Burnout	
34. Core Iron Condition	
35. RTD's	(Y) Yes
36. RTD's Reading	113 Ohm's
37. Motor Heaters	
38. Heater Qty.	
39. Heater Voltage	
40. Heater Wattage	
41. Thermistors	
42. Number of Poles	6
43. Slots	72
44. Number of Coils	72
45. Coil Weight	Lbs.
46. Lead Markings	
47. Grouping	
48. Wire Size	
49. Turns per coil	
50. Total Wires in parallel	
51. Wire Insulation	
52. Iron Skewed	
53. Pitch 1 to:	
54. Connection <i>2 Wye 2 Delta</i>	
55. Lead Length	32 "
56. Lead Size	4
57. Number of Leads	4
58. Megger Reading After Rewind	Mohms
59. Coil Machine Slot	
60. Coil Machine Tip	
61. Coil Machine Pitch	
62. Hi Pot Reading After Rewind	
63. Surge Pattern After Rewind	
64. Service Technician	Robert R , Trent



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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.
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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

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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.