



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

LR Motor Shop Repairs

**Job Number 100764**

Prepared for Twin Rivers (12049)

1701 Jefferson Parkway  
White Hall AR 71602

# Table of Contents



Hi-Speed Industrial Service  
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Millington, Tn 38053  
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## AC Recondition As Found

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

FolderID: 100764  
FormID: 15673239

### AC Recondition - Rev. 2

Location: Shop  
Serial Number: EJ595 2116 01002  
Description: 1.5KW SIEMENS 1800RPM 90L

Hi-Speed Job Number:	100764
Manufacturer:	Siemens
Product Number:	1 LA5096-4BA99-Z
Serial Number:	EJ595 2116 01002
HP/kW:	1.5 (kW)
RPM:	1735 (RPM)
Frame:	90L
Voltage:	230 / 460
Current:	6.2/3.1
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	Yes
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 6 - Good

### Overall Condition

1. Report Date
2. Nameplate Picture



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3. Photos of all six sides of the machine.





4. Describe the Overall Condition of the Equipment as Received	
<b>Initial Mechanical/Electrical</b>	
<input checked="" type="radio"/> 5. Does Shaft Turn Freely?	<b>(Yes) Yes</b>
6. Does Shaft Have Visible Damage?	<b>(No) No</b>
7. Assembled Shaft Runout	
8. Assembled Shaft End Play	
9. Air Gap Variation <10%	
10. Lead Condition	

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11. Lead Length

6 Inches



12. Frame Condition

● 13. Fan Condition

(P) Pass



14. Broken or Missing Components

**Initial Electrical Inspection**

15. Insulation Resistance/Megger

16. Winding Resistance

1-2

1-3

2-3

17. Perform Surge Test

18. Number of Stator Slots



**Mechanical Inspection**

20. Drive End Bearing Number-	6305
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?	no
25. Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
26. Drive End Bearing Condition	
27. Opposite Drive End Bearing Number-	6004
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?	no
32. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
33. Opposite Drive End Bearing Condition	
34. Drive End Seal	25 40 7
35. Opposite Drive End Seal	


**Rotor Inspection**

36. Rotor Type/Material	
37. Growler Test	(Pass) Pass
38. Number of Rotor Bars	
39. Rotor Condition	wash and bake
40. List the Parts needed for the Repair Below	
41. Signature of Technician that Disassembled Motor	RW

**Mechanical Fits- Rotor**

42. Shaft Runout		
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	
<b>0.9847</b>	<b>0.9847</b>	<b>0.9847</b>	
47. Drive End Bearing Shaft Fit Condition			<b>(P) Pass</b>
48. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
<b>0.7879</b>	<b>0.7879</b>	<b>0.7879</b>	
49. Opposite Drive End Bearing Shaft Fit Condition			<b>(P) Pass</b>
50. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
<b>Mechanical Fits- Bearing Housings</b>			
51. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
<b>2.4415</b>	<b>2.4415</b>	<b>2.4415</b>	
52. Drive End - Endbell Bearing Fit Condition			<b>(P) Pass</b>
53. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
<b>1.6538</b>	<b>1.6538</b>	<b>1.6538</b>	
54. Opposite Drive End - Endbell Bearing Fit Condition			<b>(P) Pass</b>
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			<b>RW</b>
			
<b>Dynamic Balance Report</b>			
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		

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62. Technician			
<b>Rewind</b>			
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			micro-amps



70. Technician			
<b>Root Cause of Failure</b>			
71. Failure locations			
<i>De seal</i>			
72. Root cause of failure			
<i>De seal failed letting oil inside of motor causing damage to winding</i>			
<b>Mechanical Fits- Rotor - Post Repair</b>			
73. Shaft Runout Post Repair			
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	
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	

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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			
<b>Mechanical Fits- Bearing Housings - Post Repair</b>			
81. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
82. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
83. Bearing Cap Condition Post Repair			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
84. End Bell Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
85. End Bell Repair Sign-off			
<b>Assembly</b>			

86. Photograph All Major Components prior to assembly



87. Final Insulation Resistance Test

88. Assembled Shaft Endplay

89. Assembled Shaft Runout

90. Test Run Voltage		
Volts	Volts	Volts
<b>460</b>	<b>459</b>	<b>458</b>



91. Test Run Amperage		
Amps	Amps	Amps
<b>2.1</b>	<b>2.2</b>	<b>2.1</b>



92. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
93. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
94. Ambient Temperature - Fahrenheit		
95. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
96. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
97. Final Test Run Sign-off		
98. Document Final Condition with Pictures after paint		
99. Final Pics and QC Review		

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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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