



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

LR Motor Shop Repairs

**Job Number 101029**

Prepared for Custom Craft Poultry

3064 E Main St  
Batesville AR 72501

# Table of Contents

AC Recondition As Found - *Shop*

AC Recondition - Rev. 2: *NO SN*

**1.0**

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*Table of Contents*



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

## AC Recondition As Found

### Custom Craft Poultry

3064 E Main St  
Batesville, AR 72501

FolderID: 101029  
FormID: 16111737

#### AC Recondition - Rev. 2

Location: Shop  
Serial Number: NO SN  
Description: 25KW BALDOR 1200RPM D200L

Hi-Speed Job Number:	101029
Manufacturer:	Baldor
Product Number:	12N051W299G1
Spec/ID #:	12N051W299G1
HP/kW:	25 (kW)
RPM:	1150 (RPM)
Frame:	D200L
Voltage:	460
Current:	37
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	Propeller
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 1 - High ● 8 - 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 <i>Clean</i>		
5. Distance from the end of the shaft to the Coupling/Sheave		
<b>Initial Mechanical/Electrical</b>		
6. Does Shaft Turn Freely?		(Yes) Yes
7. Does Shaft Have Visible Damage?		(No) No
8. Assembled Shaft Runout		Inches
9. Assembled Shaft End Play		0 inches
10. Air Gap Variation <10%		
11. Lead Condition		(P) Pass
12. Lead Length		12 Inches
13. Frame Condition		good
14. Fan Condition		(P) Pass
15. Broken or Missing Components		2 front bearing cap bolts missing
<b>Initial Electrical Inspection</b>		
16. Insulation Resistance/Megger		2000 Megohms
17. Winding Resistance		
1-2	1-3	2-3
18. Perform Surge Test		
(P) Pass		

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19. Number of Stator Slots	
20. Stator Condition	good
<b>Mechanical Inspection</b>	
21. Drive End Bearing Brand	NTN



22. Drive End Bearing Number-	6312 2RS
23. Drive End Bearing Qty.	1
24. Drive End Bearing Type	(Ball) Ball Bearing
25. Drive End Lubrication Type	(Grease) Grease Lubricated
26. Drive End Bearing Insulation or Grounding Device?	no
27. Drive End Wavy Washer/Snap-Ring Other Retention Device?	N12-W12 spanner
28. Drive End Bearing Condition	
29. Opposite Drive End Bearing Brand	
30. Opposite Drive End Bearing Number-	6311 2RS
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?	none
35. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
36. Opposite Drive End Bearing Condition	
37. Drive End Seal	labyrinth in good condition
38. Opposite Drive End Seal	none

#### Rotor Inspection

39. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
40. Growler Test	(Pass) Pass
41. Number of Rotor Bars	50
42. Rotor Condition	good
43. List the Parts needed for the Repair Below 6311 2RS, 6312 2RS, 2- 8mm 1.25 x 25mm bolts.	
44. Signature of Technician that Disassembled Motor	David Maclin

**Mechanical Fits- Rotor**

45. Shaft Runout	inches	
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
<b>2.3628</b>	<b>2.3628</b>	<b>2.3628</b>
50. Drive End Bearing Shaft Fit Condition	<b>(P) Pass</b>	
51. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
<b>2.1659</b>	<b>2.1659</b>	<b>2.1659</b>
52. Opposite Drive End Bearing Shaft Fit Condition	<b>(P) Pass</b>	
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
<b>5.1185</b>	<b>5.1185</b>	<b>5.1185</b>
55. Drive End - Endbell Bearing Fit Condition	<b>(P) Pass</b>	
56. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
<b>4.7247</b>	<b>4.7247</b>	<b>4.7247</b>
57. Opposite Drive End - Endbell Bearing Fit Condition	<b>(P) Pass</b>	
58. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
59. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
60. List Machine Work Needed Below		
<i>None</i>		
61. Technician	<b>David Maclin</b>	

**Dynamic Balance Report**

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## 62. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



## 63. Initial Balance Readings

Drive End

Opposite Drive End

1.89

## 64. Final Balance Readings

Drive End

Opposite Drive End

1.18

## 65. Technician

David Maclin

## 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

## 72. Post Rewind Hi-Pot

## 73. Technician

## Root Cause of Failure

## 74. Failure locations

## 75. Root cause of failure

## Mechanical Fits- Rotor - Post Repair

## 76. Shaft Runout Post Repair

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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		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
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		
<b>Assembly</b>		
89. Photograph All Major Components prior to assembly		





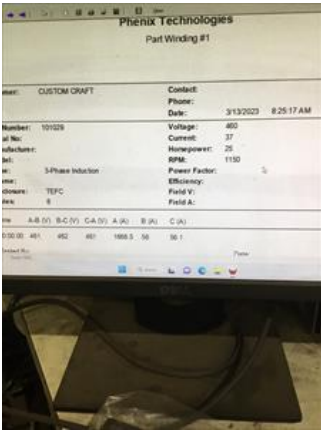
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90. Final Insulation Resistance Test			
91. Assembled Shaft Endplay			
92. Assembled Shaft Runout			
93. Test Run Voltage			
Volts	Volts		Volts
<b>461</b>	<b>462</b>		<b>461</b>



94. Test Run Amperage			
Amps	Amps		Amps
<b>56</b>	<b>56.1</b>		<b>56</b>
95. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical		Axial
<b>0.0907</b>	<b>0.0078</b>		<b>0.03</b>
96. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical		Axial
<b>0.0398</b>	<b>0.0131</b>		<b>0.0156</b>
97. Ambient Temperature - Fahrenheit			<b>70</b>
98. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes		15 Minutes
99. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes		15 Minutes

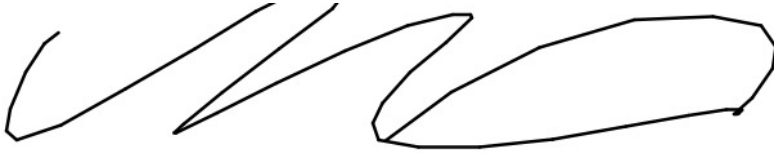
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100. QC Check All Parts for Cleanliness Prior to Assembly

101. Document Final Condition with Pictures after paint

102. Final Pics and QC Review

**David Maclin**







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1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
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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.
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