



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

LR Motor Shop Repairs

**Job Number 100836**

Prepared for Georges Inc

1810 S. St. Louis Street  
Batesville AR 72501

# Table of Contents



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

## AC Recondition As Found

Georges Inc  
1810 S. St. Louis Street  
Batesville, AR 72501

FolderID: 100836  
FormID: 15814466

### AC Recondition - Rev. 2

Location: Shop  
Serial Number: 1MAF34079-013 NP  
Description: 40HP AQUA JET AERATOR  
1200RPM 364LPZ

Hi-Speed Job Number:	100836
Manufacturer:	Reliance
Product Number:	2404001
Serial Number:	1MAF34079-013 NP
HP/kW:	40 (HP)
RPM:	1185 (RPM)
Frame:	364LPZ
Voltage:	460
Current:	47.7
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
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



3. Photos of all six sides of the machine.

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1.1





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1.2



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1.3



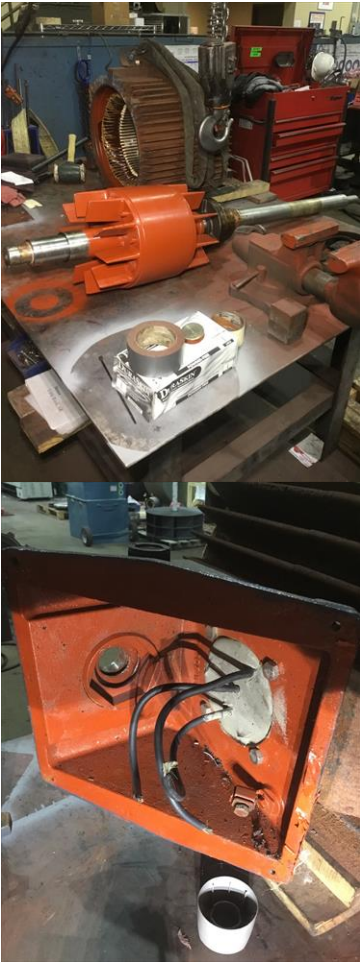


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1.4



4. Describe the Overall Condition of the Equipment as Received  
*Dirty/serviceable.*
5. Distance from the end of the shaft to the Coupling/Sheave

**Initial Mechanical/Electrical**

- |                                  |                            |  |           |
|----------------------------------|----------------------------|--|-----------|
| <input checked="" type="radio"/> | 6. Does Shaft Turn Freely? |  | (Yes) Yes |
|----------------------------------|----------------------------|--|-----------|

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7. Does Shaft Have Visible Damage?

(No) No



8. Assembled Shaft Runout

0.005 Inches

9. Assembled Shaft End Play

10. Air Gap Variation <10%

11. Lead Condition

(P) Pass



12. Lead Length

9 Inches

13. Frame Condition

pass

14. Fan Condition

(P) Pass



15. Broken or Missing Components

none

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Initial Electrical Inspection

16. Insulation Resistance/Megger

Megohms



17. Winding Resistance

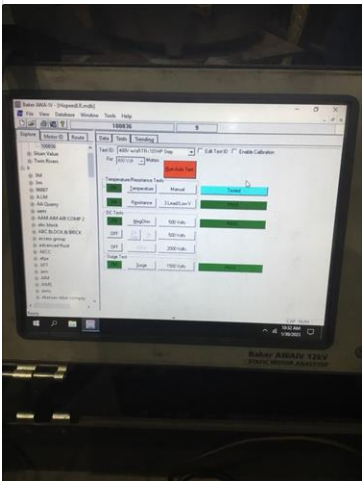
1-2

1-3

2-3

18. Perform Surge Test

(P) Pass



19. Number of Stator Slots

20. Stator Condition

pass

Mechanical Inspection

21. Drive End Bearing Number-

6215 C3 DBL Wide DBL row.



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22. Drive End Bearing Qty.	1
23. Drive End Bearing Type	(Ball) Ball Bearing
24. Drive End Lubrication Type	(Grease) Grease Lubricated
25. Drive End Bearing Insulation or Grounding Device?	none
26. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
27. Drive End Bearing Condition	replace



28. Opposite Drive End Bearing Number-	6313 C3
--	---------



29. Opposite Drive End Bearing Qty.	1
30. Opposite Drive End Bearing Type	(Ball) Ball Bearing
31. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated

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32. Opposite Drive End Bearing Insulation or Grounding Device?	none
33. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer

34. Opposite Drive End Bearing Condition	replace
35. Drive End Seal	
36. Opposite Drive End Seal	

### Rotor Inspection



37. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
-------------------------	--

38. Growler Test	(Pass) Pass
39. Number of Rotor Bars	
40. Rotor Condition	pass
41. List the Parts needed for the Repair Below	
42. Signature of Technician that Disassembled Motor	Terrence Holland

### Mechanical Fits- Rotor

43. Shaft Runout	0.005 inches
44. Rotor Runout	

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
-----------------------	------------	----------------------------

45. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
46. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
47. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.9533	2.9534	2.9533	
48. Drive End Bearing Shaft Fit Condition			(P) Pass
49. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.5593	2.5593	2.5594	
50. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
51. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
<b>Mechanical Fits- Bearing Housings</b>			
52. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.1187	5.1188	5.1188	
53. Drive End - Endbell Bearing Fit Condition			(P) Pass
54. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.5123	5.5123	5.5125	
55. Opposite Drive End - Endbell Bearing Fit Condition			(P) Pass
56. Bearing Cap Condition			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
	pass		
<div>   </div>			
57. End Bell Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
58. List Machine Work Needed Below			
None			

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59. Technician

Terrence Holland


**Dynamic Balance Report**

60. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

61. Initial Balance Readings

Drive End

Opposite Drive End

62. Final Balance Readings

Drive End

Opposite Drive End

63. Technician

**Rewind**

64. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

65. Core Hot Spot Test

Pre-Burnout

Post-Burnout

66. Post Rewind Electrical Test- Insulation Resistance

67. Post Rewind Polarization Index

68. Post Rewind Winding Resistance

1-2

1-3

2-3

69. Post Rewind Surge Test

70. Post Rewind Hi-Pot

71. Technician

**Root Cause of Failure**

72. Failure locations

73. Root cause of failure

**Mechanical Fits- Rotor - Post Repair**

74. Shaft Runout Post Repair

75. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

76. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

77. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

78. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

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79. Opposite Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
80. Shaft Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
81. Shaft Repair Sign-off			
<b>Mechanical Fits- Bearing Housings - Post Repair</b>			
82. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
83. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
84. Bearing Cap Condition Post Repair			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
85. End Bell Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
86. End Bell Repair Sign-off			
<b>Assembly</b>			
87. Photograph All Major Components prior to assembly			
88. Final Insulation Resistance Test			
89. Assembled Shaft Endplay			
90. Assembled Shaft Runout			
91. Test Run Voltage			
Volts	Volts	Volts	
<b>457</b>	<b>456</b>	<b>456</b>	



92. Test Run Amperage

Amps	Amps	Amps
<b>24.3</b>	<b>24.5</b>	<b>23.6</b>



93. Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
<b>0.05</b>	<b>0.06</b>	<b>0.03</b>

94. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial
<b>0.03</b>	<b>0.05</b>	<b>0.03</b>

95. Ambient Temperature - Fahrenheit

96. Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes
-----------	------------	------------

97. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes
-----------	------------	------------

98. Final Test Run Sign-off

99. Document Final Condition with Pictures after paint





100. Final Pics and QC Review

RW

RW





## STANDARD TERMS AND CONDITIONS FOR PURCHASE OF GOOD AND/OR SERVICES

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.
2. **PRICE.** All quoted prices shall remain firm and binding for a period of thirty (30) days from the date of quotation or for the period specifically stated in the quotation. The price for any and all goods and/or services ordered or approved by Buyer after thirty (30) days from the date of any quotation are subject to any increase in price that may occur after the expiration of thirty (30) days from the issuance of the quotation and the date the Buyer releases any shipment.
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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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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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.