



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

LR Motor Shop Repairs

Job Number 100842

Prepared for Hormel (11974)

8201 Fraizer Pike
Little Rock AR 72206

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

AC Recondition As Found

Hormel (11974)
8201 Fraizer Pike
Little Rock, AR 72206

FolderID: 100842
FormID: 15836915

AC Recondition - Rev. 2

Location: MOTOR SHOP LR
Serial Number: NO NP
Description: 200HP BALDOR 3600RPM 447TY

Hi-Speed Job Number:	100842
Manufacturer:	Baldor
Product Number:	Z44G8505
Spec/ID #:	Z44G8505
Serial Number:	NO NP
HP/kW:	200 (HP)
RPM:	3575 (RPM)
Frame:	447TY
Voltage:	460
Current:	222
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
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 1 - High ● 5 - Good

Overall Condition

1. Report Date
2. Nameplate Picture



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3. Photos of all six sides of the machine.



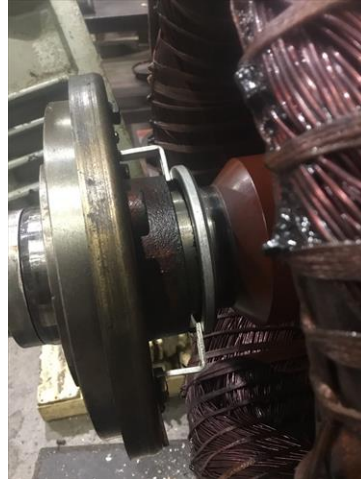


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1.2





4. Describe the Overall Condition of the Equipment as Received
Coated with sticky peanut butter



Initial Mechanical/Electrical

5.	Does Shaft Turn Freely?	(Yes) Yes
6.	Does Shaft Have Visible Damage?	(No) No



7.	Assembled Shaft Runout	0.003 Inches
8.	Assembled Shaft End Play	
9.	Air Gap Variation <10%	

10. Lead Condition

(P) Pass



11. Lead Length

17 Inches

6 leads #1,2,3



12. Frame Condition

pass

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

(F) Fail



18. Number of Stator Slots

19. Stator Condition

**Blowout in coil extension,
copper balls present**

Mechanical Inspection

20. Drive End Bearing Number-

NU 313-E-XL-M1-C3



21. Drive End Bearing Qty.

1

22. Drive End Bearing Type

(Roller) Roller Bearing

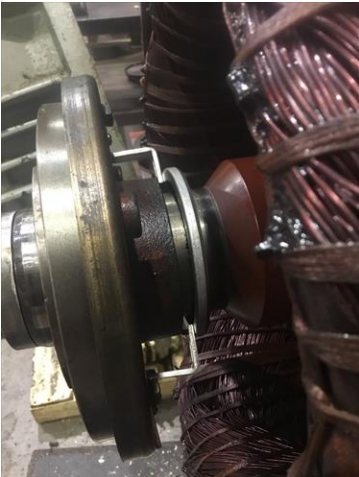


23. Drive End Lubrication Type

(Oil) Oil Lubricated

24. Drive End Bearing Insulation or Grounding Device?

yes (aegis)



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

spacer



26. Drive End Bearing Condition	replace
27. Opposite Drive End Bearing Number-	6313 2Z/C3



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?	none
32. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
33. Opposite Drive End Bearing Condition	worn
34. Drive End Seal	TC 65*85*8
Also has lip seal	

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35. Opposite Drive End Seal



CR-25956



Rotor Inspection

36. Rotor Type/Material



37. Growler Test

38. Number of Rotor Bars

39. Rotor Condition

40. List the Parts needed for the Repair Below

41. Signature of Technician that Disassembled Motor

Terrence Holland



Mechanical Fits- Rotor

42. Shaft Runout 0.003 inches

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

2.5603

2.56

2.5602

47. Drive End Bearing Shaft Fit Condition

48. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.5598

2.5599

2.5599

49. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

50. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

51. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

52. Drive End - Endbell Bearing Fit Condition

53. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

54. Opposite Drive End - Endbell Bearing Fit Condition

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

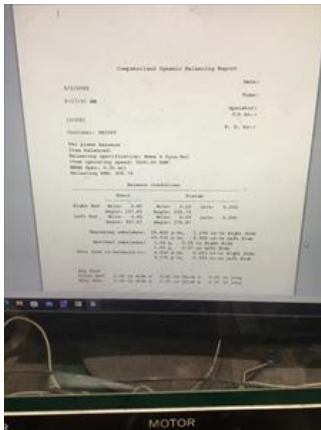
Dynamic Balance Report

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59. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



60. Initial Balance Readings

Drive End

Opposite Drive End

.42

.65

61. Final Balance Readings

Drive End

Opposite Drive End

.09

.09

62. Technician

RW

Rewind

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

70. Technician

Root Cause of Failure

71. Failure locations

Stator

72. Root cause of failure

Blown windings from a short

Mechanical Fits- Rotor - Post Repair

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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
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		
Mechanical Fits- Bearing Housings - Post Repair		
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		
Assembly		

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

91. Test Run Amperage

Amps

Amps

Amps

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. QC Check All Parts for Cleanliness Prior to Assembly		
98. Document Final Condition with Pictures after paint		



99. Final Pics and QC Review	RW
	



Hi-Speed Industrial Service
7030 Ryburn Dr
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901-873-5300

AC Random Coil Rewind Report

FolderID: 100842
FormID: 16093270

Hormel (11974)
8201 Fraizer Pike
Little Rock, AR 72206

Priorities Found:

General	
1. Job Number	100842
2. Report Date	02/28/2023
3. Customer	Skippys
Stator Winding	
4. Core Length	"



5. Core ID
6. Back Iron Depth
7. Slot Depth
8. Tooth Width
9. Number of Vents
10. Vent Width

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11. Before Burnout Core loss
12. Flux Before Burnout
13. Watts before burnout
14. Watts loss per lb. before burnout
15. After Burnout Core Loss
16. Flux After burnout
17. Watts After Burnout
18. Watts loss per lb After Burnout
19. Core Iron Condition
20. RTD's
21. RTD's Reading
22. Motor Heaters
23. Heater Qty.
24. Heater Voltage
25. Heater Wattage
26. Thermistors
27. Number of Poles
28. Slots
29. Number of Coils
30. Coil Weight
31. Lead Markings
32. Grouping
33. Multiple Wires
34. Wire Size
35. Turns per coil
36. Pitch 1 to:
37. Connection
38. Lead Length
39. Lead Size
40. Number of Leads
41. Megger Reading After Rewind
42. Coil Machine Slot
43. Coil Machine Tip
44. Coil Machine Pitch
45. Hi Pot Reading After Rewind
46. Surge Pattern After Rewind
47. Service Technician



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