



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

LR Motor Shop Repairs

**Job Number 101155**

Prepared for Hormel (11974)

8201 Fraizer Pike  
Little Rock AR 72206

# Table of Contents

AC Recondition As Found - *MOTOR SHOP LR*

AC Recondition - Rev. 2: 1027188410

**1.0**

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Hi-Speed Industrial Service  
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## AC Recondition As Found

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

FolderID: 101155  
FormID: 16338330

### AC Recondition - Rev. 2

Location: MOTOR SHOP LR  
Serial Number: 1027188410  
Description: 60HP WEG 1800RPM 364/5T

Hi-Speed Job Number:	101155
Manufacturer:	WEG
Product Number:	06018ET3E364T-W22
Serial Number:	1027188410
HP/kW:	60 (HP)
RPM:	1775 (RPM)
Frame:	364/5T
Voltage:	230 / 460
Current:	137/68.3
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.25
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: ● 5 - High ● 4 - Good

### Overall Condition

1. Report Date

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## 2. Nameplate Picture



3. Photos of all six sides of the machine.

4. Describe the Overall Condition of the Equipment as Received

### Initial Mechanical/Electrical

●	5. Does Shaft Turn Freely?	(Yes) Yes
	6. Does Shaft Have Visible Damage?	(No) No
●	7. Assembled Shaft Runout	0.0005 Inches
	8. Assembled Shaft End Play	
	9. Air Gap Variation <10%	

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10. Lead Condition

(P) Pass



11. Lead Length

12 Inches

12. Frame Condition

pass

13. Fan Condition

(F) Fail

Needs new fan



14. Broken or Missing Components

### Initial Electrical Inspection

15. Insulation Resistance/Megger

0 Megohms

16. Winding Resistance

1-2

1-3

2-3

17. Perform Surge Test

(F) Fail

18. Number of Stator Slots

## 19. Stator Condition

rewind over loaded

**Mechanical Inspection**

20. Drive End Bearing Brand

NS

21. Drive End Bearing Number-

6314



22. Drive End Bearing Qty.

1

23. Drive End Bearing Type

(Ball) Ball Bearing

24. Drive End Lubrication Type

(Grease) Grease Lubricated

*Mixed grease*

25. Drive End Bearing Insulation or Grounding Device?

na

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26. Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>snap ring</b>
27. Drive End Bearing Condition	<b>ID OVER SIZED SHAFT FIT</b>
<div> <div></div> <div><i>Some frosting</i></div> </div>	



28. Opposite Drive End Bearing Brand	<b>NSK</b>
29. Opposite Drive End Bearing Number-	<b>6314</b>



30. Opposite Drive End Bearing Qty.	<b>1</b>
31. Opposite Drive End Bearing Type	<b>(Ball) Ball Bearing</b>
32. Opposite Drive End Lubrication Type	<b>(Grease) Grease Lubricated</b>



*Mixed grease*

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33. Opposite Drive End Bearing Insulation or Grounding Device?	na
34. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	springs



35. Opposite Drive End Bearing Condition	ID OVER SIZED SHAFT FIT
 The start of fluting	



Aegis ring shaft size 3.295

36. Drive End Seal	
37. Opposite Drive End Seal	
Rotor Inspection	
38. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast



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39.	Growler Test	(Pass) Pass	
40.	Number of Rotor Bars	40	
41.	Rotor Condition	wash and bake	
42.	List the Parts needed for the Repair Below		
43.	Signature of Technician that Disassembled Motor		
Mechanical Fits- Rotor			
44.	Shaft Runout		
45.	Rotor Runout		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
46.	Coupling Fit Closest to Bearing Housing		
	0 Degrees	90 Degrees	120 Degrees
47.	Coupling Fit Closest to the end of the Shaft		
	0 Degrees	60 Degrees	120 Degrees
48.	Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	2.7565	2.7565	2.7565



● 49. Drive End Bearing Shaft Fit Condition	(P) Pass
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50. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.7565	2.7565	2.7565	



51. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass		
52. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
<b>Mechanical Fits- Bearing Housings</b>			
53. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.9069	5.9069	5.9069	
54. Drive End - Endbell Bearing Fit Condition	(F) Fail		
Resleeve			



55. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.9068	5.9069	5.9069	

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56. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail

Resleeve



57. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass

pass

58. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

59. List Machine Work Needed Below

*Both end bells need to be resleeved*

60. Technician

RW



### Dynamic Balance Report

61. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

62. Initial Balance Readings

Drive End

Opposite Drive End

63. Final Balance Readings

Drive End

Opposite Drive End

64. Technician

### Rewind

65. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

66. Core Hot Spot Test

Pre-Burnout

Post-Burnout

67. Post Rewind Electrical Test- Insulation Resistance

68. Post Rewind Polarization Index

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69. Post Rewind Winding Resistance		
1-2	1-3	2-3
70. Post Rewind Surge Test		
71. Post Rewind Hi-Pot		
72. Technician		
<b>Root Cause of Failure</b>		
73. Failure locations		
74. Root cause of failure		
<b>Mechanical Fits- Rotor - Post Repair</b>		
75. Shaft Runout Post Repair		
76. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
77. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
78. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
79. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
80. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
81. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
82. Shaft Repair Sign-off		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
83. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
84. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
85. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
86. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
87. End Bell Repair Sign-off		
<b>Assembly</b>		
88. QC Check All Parts for Cleanliness Prior to Assembly		
89. Photograph All Major Components prior to assembly		
90. Final Insulation Resistance Test		
91. Assembled Shaft Endplay		

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92.	Assembled Shaft Runout		
93.	Test Run Voltage		
	Volts	Volts	Volts
94.	Test Run Amperage		
	Amps	Amps	Amps
95.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
96.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
97.	Ambient Temperature - Fahrenheit		
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
100.	Document Final Condition with Pictures after paint		
101.	Final Pics and QC Review		



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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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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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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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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.