



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

LR Motor Shop Repairs

Job Number 101451

Prepared for Riceland Foods

1200 N Park Ave
Stuttgart AR 72160

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AC Recondition Repair Report

1.0

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

AC Recondition Repair Report

FolderID: 101451
FormID: 16965167

Riceland Foods
1200 N Park Ave
Stuttgart, AR 72160

Priorities Found: ● 2 - High ● 14 - Good

General	
1. Job Number	101451
2. Report Date	
3. Customer	Riceland Foods
Name Plate Information	
4. Manufacturer	Siemens
5. Model	XP100
6. Serial Number	1MB21214EB512AG3
7. Horsepower	250 HP
8. KW	
9. Volts	460 Volts
10. Amps	278 Amps
11. RPM	1785 RPM
12. Frame	B4491
13. Enclosure	TEFC
14. Cycles	60 HZ
15. Phase	3 PH
16. Service Factor	1
17. Motor Mount Position	
Initial Inspection	
18. Number of Leads	6
19. Lead Length	
20. Lead Size	

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● 21. Lead Condition

(F) Fail



22. Lead Markings

23. Lug Size, Condition, and Type

24. Winding RTD's

25. Winding Rtd's Condition

26. Shaft Run Out

0.001

27. Does Shaft Turn Freely

yes

28. Does Shaft Have Visible Damage

no

29. Bearing Rtd's

30. Bearing Rtd's Condition

31. Contamination

● 32. Frame Condition

(P) Pass





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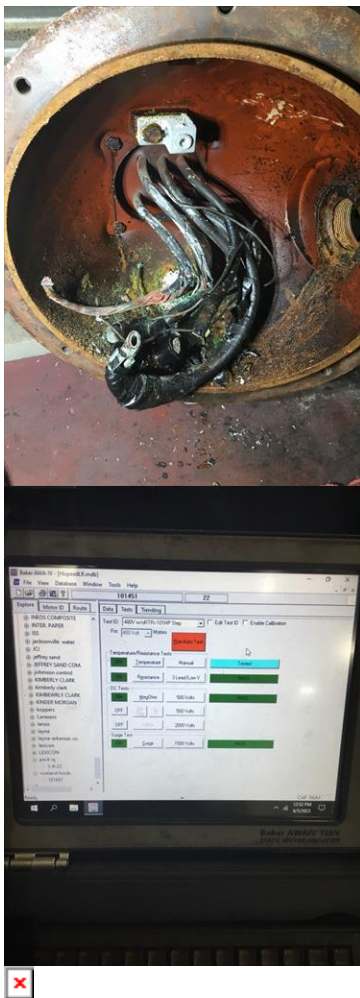
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33. Fan Condition

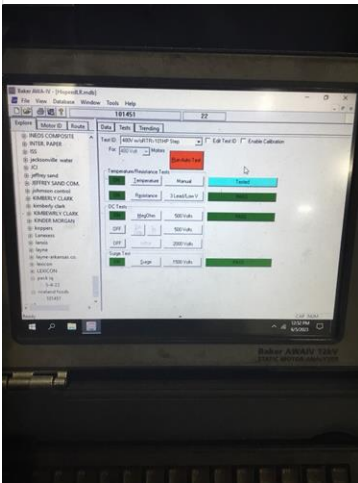
(P) Pass



34. Broken or missing components
Initial Electric Test
35. Resistance to Ground
36. Winding Resistance 1-2
37. Winding Resistance 2-3
38. Winding Resistance 1-3
39. Resistive Imbalance
40. Hi-Pot

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(P) Pass



pass

leads

Initial Rotor Inspection

squirrel cage



48. Growler Test (P) Pass

49. Rotor Condition (P) Pass

Mechanical Inspection

FAG

6318

52. Bearing DE Type



53. DE Bearing Qty.

1

54. Bearing ODE Size

6316

55. Bearing ODE Type

regular ball bearing



56. ODE Bearing Qty.

1

57. Insulated Bearing

no

58. Lubrication Type

grease

● 59. Grease Condition

(F) Fail



● 60. Bearing Retainers

(Y) Yes

61. Shaft Grounding Device

(NA) Not Applicable

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62. DE Seal	(NA) Not Applicable
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63. DE Seal Type/Size	
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64. ODE Seal	
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65. ODE Seal Type/Size	
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Root Cause of Failure

66. Component Failure	lead wires shorted to ground from loose connection
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67. Cause of Failure	<i>Loose connection</i>
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68. Comments	
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69. Service Technician	Terrence Holland
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Machine Fit Inspection Report

70. Shaft Run Out	(P) Pass
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71. Initial Shaft Run Out	0.001 "
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72. Final Shaft Run Out	
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73. DE Bearing Shaft Fit	(P) Pass
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74. DE Initial Shaft Bearing Fit Size 1	
-----------------------------------------	--

75. DE Initial Shaft Bearing Fit Size 2	
-----------------------------------------	--

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76.	DE Initial Shaft Bearing Fit Size 3	
77.	DE Finial Shaft Bearing Fit Size 1	
78.	DE Finial Shaft Bearing Fit Size 2	
79.	DE Finial Shaft Bearing Fit Size 3	"
80.	ODE Bearing Shaft Fit	(P) Pass
81.	ODE Initial Shaft Bearing Fit Size 1	3.1507 "
82.	ODE Initial Shaft Bearing Fit Size 2	3.1507 "
83.	ODE Initial Shaft Bearing Fit Size 3	3.1505 "
84.	ODE Finial Shaft Bearing Fit Size 1	
85.	ODE Finial Shaft Bearing Fit Size 2	
86.	ODE Finial Shaft Bearing Fit Size 3	
87.	DE Air Seal Shaft Fit	
88.	DE Initial Air Seal Shaft Size	
89.	DE Final Air Seal Shaft Size	
90.	ODE Air Seal Shaft Fit	
91.	ODE Initial Air Seal Shaft Size	
92.	ODE Final Air Seal Shaft Size	
93.	DE Endbell Fit	(P) Pass
94.	DE Initial Endbell Fit Size 1	7.481 "
95.	DE Initial Endbell Fit Size 2	7.4812 "
96.	DE Initial Endbell Fit Size 3	7.4813 "
97.	DE Final Endbell Fit Size 1	
98.	DE Finial Endbell Fit Size 2	
99.	DE Final Endbell Fit Size 3	
100.	DE Endbell Fit Insulated	
101.	DE Endbell Air Seal Fit	
102.	Initial Endbell Air Seal Fit Size	
103.	Finial Endbell Air Seal Fit Size	
104.	ODE Endbell Fit	(P) Pass
105.	ODE Initial Endbell Fit Size 1	6.6932 "
106.	ODE Initial Endbell Fit Size 2	6.6934 "
107.	ODE Initial Endbell Fit Size 3	6.6934 "
108.	ODE Final Endbell Fit Size 1	
109.	ODE Final Endbell Fit Size 2	
110.	ODE Final Endbell Fit Size 3	
111.	ODE Endbell Fit Insulated	
112.	ODE Endbell Air Seal Fit	
113.	ODE Initial Endbell Seal Fit Size	
114.	ODE Finial Endbell Seal Fit Size	
115.	Foot Flatness	(P) Pass
116.	Foot Condition	(P) Pass
117.	Flange Condition	
118.	Service Technician	Terrence Holland
 		

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Balancing Report

119. Balance Type
120. Balance Operating Speed
121. Start Left End
122. Start Right End
123. Balancing Specification



124. Finish Left End
125. Finish Right End
126. Service Technician

Mills
Cw

Assembly and Final Test

127. Meggar Testing Reading
128. Surge Test
129. Hi-Pot
130. Winding Resistance 1-2
131. Winding Resistance 2-3
132. Winding Resistance 1-3
133. Test Run Voltage Phase A
134. Test Run Amps A
135. Test Run Voltage Phase B
136. Test Run Amps B
137. Test Run Voltage Phase C
138. Test Run Amps C
139. DE Horizontal Vibration Reading
140. DE Vertical Vibration Reading
141. DE Axial Vibration Reading
142. ODE Horizontal Vibration Reading
143. ODE Vertical Vibration Reading
144. ODE Axial Vibration Reading
145. Ambient Temp at start of Test Run
146. Temp at 5 minutes

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147. Temp at 10 minutes
148. Temp at 15 minutes
149. Temp at 20 minutes
150. Temp at 25 minutes
151. Temp at 30 minutes
152. Temp at 35 minutes
153. Temp at 40 minutes
154. Temp at 45 minutes
155. Temp at 50 minutes
156. Temp at 55 minutes
157. Temp at 60 minutes
158. Motor Paint



159. Service Technician

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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

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