



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

LR Motor Shop Repairs

**Job Number 101633**

Prepared for Sage V Foods

5901 SLOAN DRIVE  
LITTLE ROCK AR 72206

# Table of Contents



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

## AC Inspection as Found

Sage V Foods  
5901 SLOAN DRIVE  
LITTLE ROCK, AR 72206

FolderID: 101633  
FormID: 17363892

### AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: 25 HP BROKEN SHAFT

Hi-Speed Job Number: 101633

Manufacturer: Baldor

Serial Number: C1810130237

HP/kW: 25 (HP)

RPM: 1775 (RPM)

Frame: 284T

Voltage: 230 / 460

Current: 62/31

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.00

J-box Included: Half

Coupling/Sheave: None

Date Received: 07/19/2023

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Shaft Machined Fit Repairs  
Required: Yes

Heaters: No

Bearing Type: Rolling Element

Priorities Found: ● 7 - Good

### Overall Condition

- |                      |            |
|----------------------|------------|
| 1. Report Date       | 10/30/2023 |
| 2. Nameplate Picture |            |



- |  |
|--|
| 3. Photos of all six sides of the machine. |
|--|

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Printed on 10/30/2023

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1.1





4. Describe the Overall Condition of the Equipment as Received

*D.E. shaft broken off.*



**Initial Mechanical/Electrical**

5.	Does Shaft Turn Freely?	(Yes) Yes
6.	Does Shaft Have Visible Damage?	(Yes) Yes
	Broken off.	



7.	Assembled Shaft Runout	Inches
	Na	
8.	Assembled Shaft End Play	inches
	Na	
9.	Air Gap Variation <10%	
	Na	
10.	Lead Condition	(P) Pass
11.	Lead Length	9 Inches
12.	Lead Numbers	1-9
13.	Frame Condition	pass
14.	Fan Condition	(N) NA
15.	Broken or Missing Components	D.E. shaft

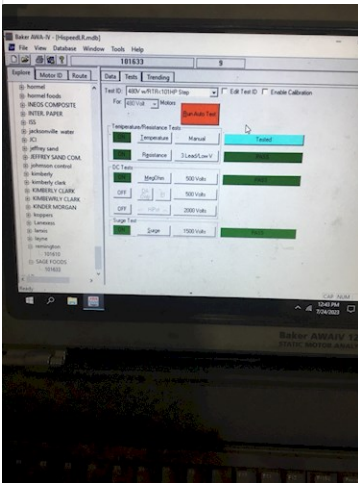
**Initial Electrical Inspection**

16.	Insulation Resistance/Megger	Megohms
17.	Winding Resistance	
1-2	1-3	2-3

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## 18. Perform Surge Test

(P) Pass



19. Number of Stator Slots	48 Megohms
20. Stator Condition	pass
21. Stator Thermistors/Ohms	none
22. Stator Overloads/Ohms	none

### Mechanical Inspection

23. Drive End Bearing Brand	Nachi
24. Drive End Bearing Number-	6311 NSE



25. Drive End Bearing Qty.

1

26. Drive End Bearing Type

(Ball) Ball Bearing



27. Drive End Lubrication Type

(Grease) Grease Lubricated

28. Drive End Bearing Insulation or Grounding Device?

none

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

none

30. Drive End Bearing Condition

replace



31. Opposite Drive End Bearing Brand

koyo



32. Opposite Drive End Bearing Number-

6309 2RS

33. Opposite Drive End Bearing Qty.

1

34. Opposite Drive End Bearing Type

(Ball) Ball Bearing

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35. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
36. Opposite Drive End Bearing Insulation or Grounding Device?	none
37. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer



38. Opposite Drive End Bearing Condition	replace
39. Drive End Seal	in pro














40. Opposite Drive End Seal	none
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### Rotor Inspection

41. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
42. Growler Test	(Pass) Pass

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43. Number of Rotor Bars	40	
44. Rotor Condition	shaft replacement needed	
45. List the Parts needed for the Repair Below <i>New shaft, and new in pro seal.</i>		
46. Signature of Technician that Disassembled Motor	Terrence Holland	
		
<b>Mechanical Fits- Rotor</b>		
47. Shaft Runout	inches	
 <i>Shaft broken off</i>		
48. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
 <i>Na</i>		
49. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
 <i>Na</i>		
50. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
 <i>Na</i>		
51. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
 <i>New shaft needed</i>		
 52. Drive End Bearing Shaft Fit Condition	(NA) Not Applicable	
 <i>Broke shaft</i>		
53. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
 <i>Na</i>		
54. Opposite Drive End Bearing Shaft Fit Condition		
 <i>New shaft needed</i>		
55. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
 <i>Na</i>		
<b>Mechanical Fits- Bearing Housings</b>		
56. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
4.7246	4.7246	4.7247
 57. Drive End - Endbell Bearing Fit Condition	(P) Pass	
58. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
3.9373	3.9373	3.9374

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59. Opposite Drive End - Endbell Bearing Fit Condition (P) Pass

60. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass



61. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

62. List Machine Work Needed Below

Machine new shaft

63. Technician

Terrence Holland

*Terrence Holland*

### Dynamic Balance Report

64. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

Na



## 65. Initial Balance Readings

Drive End

Opposite Drive End

In picture



## 66. Final Balance Readings

Drive End

Opposite Drive End

In picture



## 67. Technician

Cw

## Rewind

## 68. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

## 69. Core Hot Spot Test

Pre-Burnout


Post-Burnout

## 70. Post Rewind Electrical Test- Insulation Resistance



## 71. Post Rewind Polarization Index

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72. Post Rewind Winding Resistance		
1-2	1-3	2-3
73. Post Rewind Surge Test		
74. Post Rewind Hi-Pot		
75. Technician		
<b>Root Cause of Failure</b>		
76. Failure locations		
77. Root cause of failure		
<b>Mechanical Fits- Rotor - Post Repair</b>		
78. Shaft Runout Post Repair		inches
<div>  Machined new shaft </div>		



79. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
80. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
81. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
82. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
83. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
84. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
85. Shaft Repair Sign-off		Gary
<div>   </div>		

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**Mechanical Fits- Bearing Housings - Post Repair**

86. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

87. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

88. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

89. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

90. End Bell Repair Sign-off

**Assembly**

91. QC Check All Parts for Cleanliness Prior to Assembly



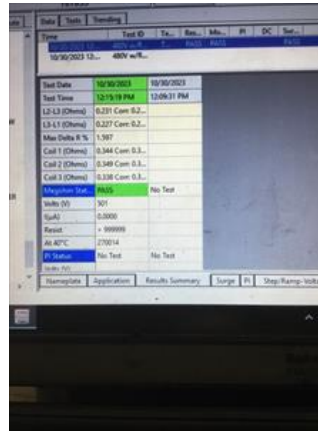
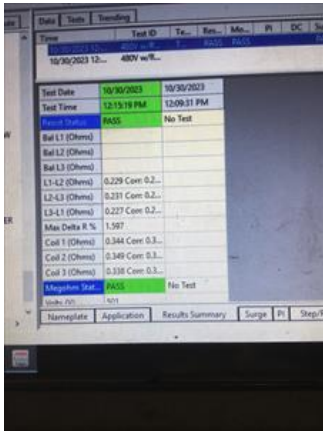
92. Photograph All Major Components prior to assembly

(Complete) Complete

93. Final Insulation Resistance Test

9999999 Megohms

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94. Assembled Shaft Endplay	inches	
Na		
95. Assembled Shaft Runout	0 inches	
96. Test Run Voltage		
Volts	Volts	Volts
Co Sign: TRH		



97. Test Run Amperage		
Amps	Amps	Amps
461	459	461



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98. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
<b>0.002</b>	<b>0.002</b>	<b>0.001</b>
99. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
<b>0.001</b>	<b>0.001</b>	<b>0.001</b>
100. Ambient Temperature - Fahrenheit		
Na		
101. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
102. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
103. Stator Temperatures- Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
104. Document Final Condition with Pictures after paint		



105. Final Pics and QC Review	Cw
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Co sign: TRH



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