



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

LR Motor Shop Repairs

**Job Number 101648**

Prepared for Twin Rivers

1701 Jefferson Parkway  
White Hall AR 71602

# Table of Contents



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

## AC Inspection as Found

### Twin Rivers

1701 Jefferson Parkway  
White Hall, AR 71602

FolderID: 101648  
FormID: 17422648

#### AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: 25 HP

Hi-Speed Job Number: 101648

Manufacturer: US Motors/Nidec

Spec/ID #: C0420706018-0001 M 001

HP/kW: 25 (HP)

RPM: 1190 (RPM)

Frame: 324ZLPHZ

Voltage: 230 / 460

Current: 62 / 31

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

# of Leads: 9

J-box Included: Complete

Coupling/Sheave: Propeller

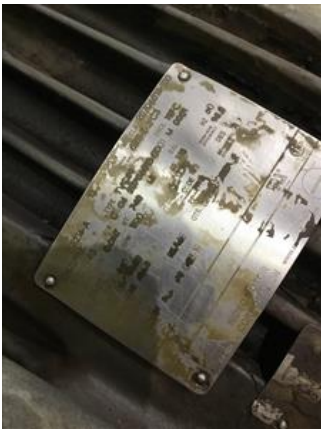
Date Received: 07/24/2023

Repair Stage: Final

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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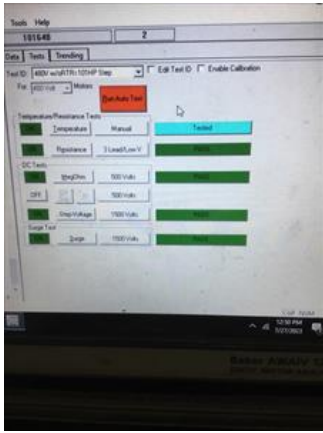


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4. Describe the Overall Condition of the Equipment as Received

*Dirty*

5. Distance from the end of the shaft to the Coupling/Sheave

#### Initial Mechanical/Electrical

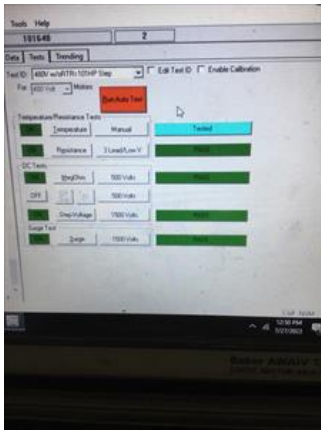
6. Does Shaft Turn Freely?	(Yes) Yes
7. Does Shaft Have Visible Damage?	(No) No
8. Assembled Shaft Runout	Inches
9. Assembled Shaft End Play	inches
10. Air Gap Variation <10%	

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11. Lead Condition		(P) Pass
12. Lead Length		8 Inches
13. Lead Numbers		1-9
14. Stator Temperature Detector Rating and Function		
Quantity	Rating	Quantity Passed
Na		
15. Bearing Temperature Detector Rating and Function		
Quantity	Rating	Quantity Passed
Na		
16. Frame Condition		pass
17. Fan Condition		(P) Pass




18. Heater Quantity, Ratings		
Quantity	Volts/Watts	Pass/Fail
Na		
19. Broken or Missing Components		impeller, fan cover, j-box cover, and lifting eyes
<b>Initial Electrical Inspection</b>		
20. Insulation Resistance/Megger		
21. Winding Resistance		
1-2	1-3	2-3




23. Number of Stator Slots	
24. Stator Condition	pass
25. Stator Thermistors/Ohms	na
26. Stator Overloads/Ohms	na
<b>Mechanical Inspection</b>	
27. Drive End Bearing Brand	
28. Drive End Bearing Number-	5216
29. Drive End Bearing Qty.	1
30. Drive End Bearing Type	(Thrust) Thrust
31. Drive End Lubrication Type	(Grease) Grease Lubricated
32. Drive End Bearing Insulation or Grounding Device?	na
33. Drive End Wavy Washer/Snap-Ring Other Retention Device?	spanner nut
34. Drive End Bearing Condition	severe metal fatigue
35. Opposite Drive End Bearing Brand	peer
36. Opposite Drive End Bearing Number-	6211
37. Opposite Drive End Bearing Qty.	1
38. Opposite Drive End Bearing Type	(Ball) Ball Bearing
39. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
40. Opposite Drive End Bearing Insulation or Grounding Device?	na
41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	na
42. Opposite Drive End Bearing Condition	signs of wear
43. Drive End Seal	lip seal
44. Opposite Drive End Seal	na
45. DE Sleeve Bearing Inside Diameter	
0 degrees	120 degrees
	240 degrees
46. DE Sleeve Bearing Outside Diameter	
0 degrees	120 degrees
	240 degrees
47. DE Sleeve Bearing Housing Inside Diameter	
0 degrees	120 degrees
	240 degrees



48. DE Sleeve Bearing to Housing Clearance	0 degrees	120 degrees	240 degrees
49. ODE Sleeve Bearing Inside Diameter	0 degrees	120 degrees	240 degrees
50. ODE Sleeve Bearing Outside Diameter	0 degrees	120 degrees	240 degrees
51. ODE Sleeve Bearing Housing Inside Diameter	0 degrees	120 degrees	240 degrees
52. ODE Sleeve Bearing to Housing Clearance	0 degrees	120 degrees	240 degrees
<b>Rotor Inspection</b>			
53. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast		
54. Growler Test	(Pass) Pass		
55. Number of Rotor Bars	42		
56. Rotor Condition	pass		
57. List the Parts needed for the Repair Below 5216 6211 Fan cover Lifting eyes J-box cover			
58. Signature of Technician that Disassembled Motor	Cw		
			
<b>Mechanical Fits- Rotor</b>			
59. Shaft Runout	0.002 inches		
60. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
61. Coupling Fit Closest to Bearing Housing	0 Degrees	90 Degrees	120 Degrees
62. Coupling Fit Closest to the end of the Shaft	0 Degrees	60 Degrees	120 Degrees
63. Drive End Bearing Shaft Fit	0 Degrees	60 Degrees	120 Degrees
	3.1502	3.1501	3.1502
64. Drive End Bearing Shaft Fit Condition	(P) Pass		
65. Opposite Drive End Bearing Shaft Fit	0 Degrees	60 Degrees	120 Degrees
	2.166	2.1659	2.1659

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66.	Opposite Drive End Bearing Shaft Fit Condition		(P) Pass
67.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
<b>Mechanical Fits- Bearing Housings</b>			
68.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	5.513	5.5136	5.5134
69.	Drive End - Endbell Bearing Fit Condition		(P) Pass
70.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	3.937	3.9371	3.9371
71.	Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
72.	Bearing Cap Condition		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	Pass		
73.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
74.	List Machine Work Needed Below <i>DE end bell bearing fit</i>		
75.	Technician		Cw
			
<b>Dynamic Balance Report</b>			
76.	Rotor Weight and Balance Grade		
	Rotor Weight	Balance Grade	
77.	Initial Balance Readings		
	Drive End	Opposite Drive End	
78.	Final Balance Readings		
	Drive End	Opposite Drive End	
79.	Technician		
<b>Rewind</b>			
80.	Core Test Results - Watts loss per Pound		
	Pre-Burnout	Post Burnout	
81.	Core Hot Spot Test		
	Pre-Burnout	Post-Burnout	
82.	Post Rewind Electrical Test- Insulation Resistance		
83.	Post Rewind Polarization Index		

84. Post Rewind Winding Resistance		
1-2	1-3	2-3
85. Post Rewind Surge Test		
86. Post Rewind Hi-Pot		
87. Technician		
<b>Root Cause of Failure</b>		
88. Failure locations		
<i>DE end bell bearing fit, DE seal, bearings, and impeller</i>		
89. Root cause of failure		
<i>Wear, metal fatigue, and impeller cracked</i>		
<b>Mechanical Fits- Rotor - Post Repair</b>		
90. Shaft Runout Post Repair		
91. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
92. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
93. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
94. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
95. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
96. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
97. Shaft Repair Sign-off		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
98. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees

99. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
5.5126	5.5126	5.5126



100.	Bearing Cap Condition Post Repair		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
101.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
102.	DE Sleeve Bearing Inside ID Post Repair		
	Measure 1	Measure 2	Measure 3
103.	DE Sleeve Bearing Outside ID Post Repair		
	Measure 1	Measure 2	Measure 3
104.	DE Sleeve Bearing Inside OD Post Repair		
	Measure 1	Measure 2	Measure 3
105.	DE Sleeve Bearing Outside OD Post Repair		
	Measure 1	Measure 2	Measure 3
106.	End Bell Repair Sign-off		
107.	ODE Sleeve Bearing Inside ID Post Repair		
	Measure 1	Measure 2	Measure 3
108.	ODE Sleeve Bearing Outside ID Post Repair		
	Measure 1	Measure 2	Measure 3
109.	ODE Sleeve Bearing Inside OD Post Repair		
	Measure 1	Measure 2	Measure 3
110.	ODE Sleeve Bearing Outside OD Post Repair		
	Measure 1	Measure 2	Measure 3

### Assembly

111. QC Check All Parts for Cleanliness Prior to Assembly

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112. Photograph All Major Components prior to assembly





113. Final Insulation Resistance Test		
114. Assembled Shaft Endplay		
115. Assembled Shaft Runout		
116. Test Run Voltage		
Volts	Volts	Volts
117. Test Run Amperage		
Amps	Amps	Amps
118. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
119. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
120. Ambient Temperature - Fahrenheit		
121. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
122. Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
123. Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
124. Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
125. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
126. Opposite Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes

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127. Opposite Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
128. Opposite Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
129. Stator Temperatures- Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
130. Stator Temperatures- Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
131. Stator Temperatures- Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
132. Stator Temperatures- Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
133. Document Final Condition with Pictures after paint		
134. Final Pics and QC Review		



## 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.
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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

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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11. **GOVERNING LAW AND JURISDICTION.** Any controversy arising out of any quotation, the purchase order, the goods sold or delivered, repair or replacement thereof, or any services provided pursuant to any quotation or any purchase order, or these Standard Terms and Conditions shall be governed by the laws of the state of Tennessee without regard to any choice of law provisions and any cause of action related in any manner thereto shall be brought only in the state or federal courts of Shelby County, Tennessee.
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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.
14. **NONWAIVER.** No course of dealing or failure of either party to strictly enforce any term, right, or condition of these Standard Terms and Conditions will be construed as a waiver of such term, right or condition. Any waiver by Hi-Speed will only be in writing and will waive no succeeding breach of a term, right or condition.
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.