



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

LR Motor Shop Repairs

**Job Number 102309**

Prepared for MIDDLETON INCORPORATED

P.O. BOX 506  
BRYANT AR 72089

# Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *1098C 0396*

**1.0**

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*Printed on 3/14/2024*

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

**AC Inspection as Found**  
**MIDDLETON INCORPORATED**  
P.O. BOX 506  
BRYANT, AR 72089

FolderID: 102309  
FormID: 18968909

**AC Inspection - Rev. 2**

**Location:** MOTOR SHOP LR  
**Serial Number:** 1098C 0396  
**Description:** 10HP BALDOR 1800RPM 254T

<b>Hi-Speed Job Number:</b>	102309
<b>Manufacturer:</b>	Baldor
<b>Product Number:</b>	EM2333T
<b>Spec/ID #:</b>	09P26W980G1
<b>Serial Number:</b>	1098C 0396
<b>HP/kW:</b>	10 (HP)
<b>RPM:</b>	1765 (RPM)
<b>Frame:</b>	254T
<b>Voltage:</b>	230 / 460
<b>Current:</b>	36/18
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b>Service Factor:</b>	1.15
<b>Enclosure:</b>	TEFC
<b>J-box Included:</b>	Complete
<b>Coupling/Sheave:</b>	None
<b>Bearing RTDs:</b>	No
<b>Stator RTDs:</b>	No
<b>Repair Stage:</b>	Final
<b>Heaters:</b>	No
<b>Winding Type :</b>	Random Wound
<b>Bearing Type:</b>	Rolling Element

Priorities Found: ● 3 - High ● 8 - 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  
*Dirty*

**Initial Mechanical/Electrical**

5.	Does Shaft Turn Freely?	(Yes) Yes
6.	Does Shaft Have Visible Damage?	(No) No
7.	Assembled Shaft Runout	0.001 Inches
8.	Assembled Shaft End Play	inches
	<i>Na</i>	
9.	Air Gap Variation <10%	
	<i>Na</i>	
10.	Lead Condition	(P) Pass
11.	Lead Length	8 Inches
12.	Lead Numbers	1-9
13.	Frame Condition	pass

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14. Fan Condition

(P) Pass



15. Broken or Missing Components

na

Initial Electrical Inspection

16. Insulation Resistance/Megger

Megohms

In picture

Test Time	2:47:34 PM	2:58:27 PM	2:59:00 PM	2:59:00 PM
3-L3 (Ohms)	0.606 Corr: 0.6...			
3-L1 (Ohms)	0.607 Corr: 0.6...			
Max Delta R %	0.206			
Coil 1 (Ohms)	0.911 Corr: 0.9...			
Coil 2 (Ohms)	0.907 Corr: 0.9...			
Coil 3 (Ohms)	0.910 Corr: 0.9...			
Megohm Stat...	PASS	PASS	PASS	No
Volts (V)	491	487	504	
I(μA)	0.0098	0.0548	0.0583	
Resist	50354	8881	8641	
At 40°C	13596			
PI Status	No Test	No Test	No Test	No T
Volts (AC)				
Nameplate	Application	Results Summary	Surge	PI
			Step	

17. Winding Resistance

1-2

1-3

2-3

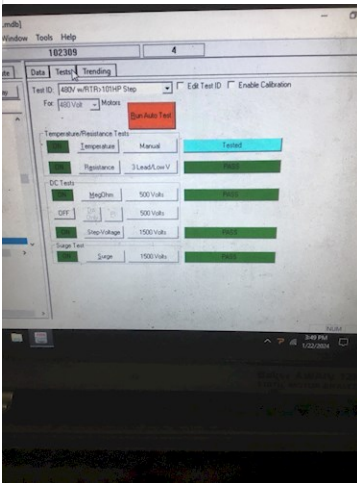
In picture

Test Time	3:47:34 PM	2:58:27 PM	2:59:00 PM	2:59:00 PM
Temp Com...	Thermoplastic	None	No	No
Resist Status	PASS	No Test	No	No
Bal L1 (Ohms)				
Bal L2 (Ohms)				
Bal L3 (Ohms)				
L1-L2 (Ohms)	0.607 Corr: 0.6...			
L2-L3 (Ohms)	0.606 Corr: 0.6...			
L3-L1 (Ohms)	0.607 Corr: 0.6...			
Max Delta R %	0.206			
Coil 1 (Ohms)	0.911 Corr: 0.9...			
Coil 2 (Ohms)	0.907 Corr: 0.9...			
Coil 3 (Ohms)	0.910 Corr: 0.9...			
Megohm Stat...	PASS	PASS	PASS	No
Nameplate	Application	Results Summary	Surge	PI
			Step	

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18. Perform Surge Test

(P) Pass



19. Number of Stator Slots	48
20. Stator Condition	dirty
21. Stator Thermistors/Ohms	na
22. Stator Overloads/Ohms	na

### Mechanical Inspection

23. Drive End Bearing Brand	skf
-----------------------------	-----



24. Drive End Bearing Number-	6309
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?	na
29. Drive End Wavy Washer/Snap-Ring Other Retention Device?	spacer nut



30. Drive End Bearing Condition

Signs of fluting



31. Opposite Drive End Bearing Brand


skf








32. Opposite Drive End Bearing Number-	6208
33. Opposite Drive End Bearing Qty.	1
34. Opposite Drive End Bearing Type	(Ball) Ball Bearing
35. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
36. Opposite Drive End Bearing Insulation or Grounding Device?	na
37. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
38. Opposite Drive End Bearing Condition	signs of fluting



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39.	Drive End Seal		
	Na		
40.	Opposite Drive End Seal		
	Na		
<b>Rotor Inspection</b>			
41.	Rotor Type/Material		(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
42.	Growler Test		(Pass) Pass
43.	Number of Rotor Bars		54
44.	Rotor Condition		pass
45.	List the Parts needed for the Repair Below		
	6309		
	6208		
	Sleeve for ODE end bell bearing fit		
46.	Signature of Technician that Disassembled Motor		Cw
			
<b>Mechanical Fits- Rotor</b>			
47.	Shaft Runout		0.001 inches
48.	Rotor Runout		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
	Na		
49.	Coupling Fit Closest to Bearing Housing		
	0 Degrees	90 Degrees	120 Degrees
	Na		
50.	Coupling Fit Closest to the end of the Shaft		
	0 Degrees	60 Degrees	120 Degrees
	Na		
51.	Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	1.772	1.7719	1.7719
52.	Drive End Bearing Shaft Fit Condition		(P) Pass
53.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	1.575	1.5751	1.5751
54.	Opposite Drive End Bearing Shaft Fit Condition		(P) Pass
55.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
	Na		
<b>Mechanical Fits- Bearing Housings</b>			

56. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
3.9378	3.9379	3.9379
57. Drive End - Endbell Bearing Fit Condition		(P) Pass
58. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
 Severely pitted unable to get accurate measurements		
		
59. Opposite Drive End - Endbell Bearing Fit Condition		(F) Fail
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		
ODE end bell bearing fit		
63. Technician	Cw	



### Root Cause of Failure

64. Failure locations

*Bearings and ODE bearing fit*

65. Root cause of failure

*Fluting and contamination in the bearings and wear for the bearing fit*

### Dynamic Balance Report

66. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

Na

67. Initial Balance Readings

Drive End

Opposite Drive End

.2

.2

68. Final Balance Readings

Drive End

Opposite Drive End

.2

.2

69. Technician

Trevor Hall



### Rewind

70. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

Na

71. Core Hot Spot Test

Pre-Burnout

Post-Burnout

Na

72. Post Rewind Electrical Test- Insulation Resistance

Megohms

Na

73. Post Rewind Polarization Index

Polarization Index

Na

74. Post Rewind Winding Resistance

1-2

1-3

2-3

Na

75. Post Rewind Surge Test

Na

76. Post Rewind Hi-Pot

micro-amps

Na

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### Mechanical Fits- Rotor - Post Repair

78. Shaft Runout Post Repair inches

 Na

79. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

 Na

80. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

 Na

81. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

 Na

82. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

 Na

83. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

 Na

84. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

 Na

85. Shaft Repair Sign-off

 Na

### Mechanical Fits- Bearing Housings - Post Repair

86. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

 Na

87. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
3.15	3.1502	3.1502





88. Bearing Cap Condition Post Repair		
Drive End Bearing Cap		Opposite Drive End Bearing Cap
	Na	
89. End Bell Air Seal Fits Post Repair		
Drive End Air Seal		Opposite Drive End Air Seal
	Na	
90. End Bell Repair Sign-off		Gary
 		

Assembly		
91. QC Check All Parts for Cleanliness Prior to Assembly		Trevor Hall
<div> <div></div> <div></div> </div>		
92. Photograph All Major Components prior to assembly		





93.	Final Insulation Resistance Test			2000 Megohms
94.	Assembled Shaft Endplay			0.001 inches
95.	Assembled Shaft Runout			inches
	Na			
96.	Test Run Voltage			
	Volts	Volts	Volts	
	460	460	460	
97.	Test Run Amperage			
	Amps	Amps	Amps	
	7	7	7	
98.	Drive End Vibration Readings - Inches Per Second			
	Horizontal	Vertical	Axial	
	0.02	0.03	0.03	
99.	Opposite Drive End Vibration Readings - Inches Per Second			
	Horizontal	Vertical	Axial	
	0.02	0.03	0.03	
100.	Ambient Temperature - Fahrenheit			75
101.	Drive End Bearing Temps - Fahrenheit			
	5 Minutes	10 Minutes	15 Minutes	
	Na			
102.	Opposite Drive End Bearing Temps - Fahrenheit			

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5 Minutes

10 Minutes

15 Minutes

Na

103. Document Final Condition with Pictures after paint



104. Final Pics and QC Review

Trevor Hall

A handwritten signature in black ink, appearing to read 'Trevor Hall'.

Co-sign: Chris W.



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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

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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.
12. **ABANDONED EQUIPMENT.** Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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.