



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

LR Motor Shop Repairs

Job Number 101929

Prepared for 3M-Main Plant (10001)

310 Walter Road
Little Rock AR 72216

Table of Contents



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

AC Inspection as Found
3M-Main Plant (10001)
310 Walter Road
Little Rock, AR 72216

FolderID: 101929
FormID: 18064448

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: 300 HP RELIANCE

Hi-Speed Job Number: 101929

Manufacturer: Reliance

Product Number: VNQ00434-A1-VU

HP/kW: 300 (HP)

RPM: 594 (RPM)

Frame: 35EG 5810S

Voltage: 460

Current: 400

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

J-box Included: None

Coupling/Sheave: Coupling

Date Received: 10/03/2023

Repair Stage: Final

Priorities Found: ● 3 - High ● 6 - Good

Overall Condition

- | | |
|----------------------|------------|
| 1. Report Date | 12/14/2023 |
| 2. Nameplate Picture | |



3. Photos of all six sides of the machine.

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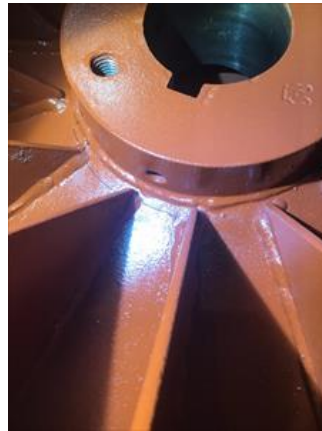
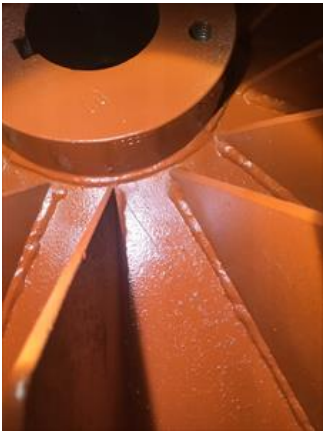
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Faced coupling and redrilled holes.
Gary



Removed broken bolt.
Gary

Bored to 4.371 as per customer request.
"For different motor "

4.	Describe the Overall Condition of the Equipment as Received	
	<i>Dirty</i>	
5.	Distance from the end of the shaft to the Coupling/Sheave	inches
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	(Yes) Yes
7.	Does Shaft Have Visible Damage?	(Yes) Yes



8.	Assembled Shaft Runout	Inches
	<i>Wasn't able to properly check runout</i>	
9.	Assembled Shaft End Play	inches
	<i>Na</i>	
10.	Air Gap Variation <10%	
	<i>Na</i>	
11.	Lead Condition	(P) Pass
12.	Lead Length	16 Inches
13.	Lead Numbers	
	<i>Leads are unmarked</i>	
14.	Stator Temperature Detector Rating and Function	
	Quantity	Rating
		Quantity Passed
	<i>Na</i>	

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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
2	240/1000	pass



19. Broken or Missing Components		
Na		
Initial Electrical Inspection		
20. Insulation Resistance/Megger		Megohms
Na		
21. Winding Resistance		
1-2	1-3	2-3
Na		
22. Perform Surge Test		(NA) Not Applicable
Unable to perform surge test due to unmarked leads		
23. Number of Stator Slots		90
24. Stator Condition		pass

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25. Stator Thermistors/Ohms	
108.6-1TD	
108.5-2TD	
108.3-3TD	
108.4-4TD	
108.4-5TD	
108.4-6TD	
26. Stator Overloads/Ohms	na
Mechanical Inspection	
27. Drive End Bearing Brand	NTN
28. Drive End Bearing Number-	6224
29. Drive End Bearing Qty.	1
30. Drive End Bearing Type	(Ball) Ball Bearing
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?	na
34. Drive End Bearing Condition	signs of metal fatigue



35. Opposite Drive End Bearing Brand	NTN
36. Opposite Drive End Bearing Number-	6224
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



43. Drive End Seal

Na

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

Na

47. DE Sleeve Bearing Housing Inside Diameter

0 degrees

120 degrees

240 degrees

Na

48. DE Sleeve Bearing to Housing Clearance

0 degrees

120 degrees

240 degrees

Na

49. ODE Sleeve Bearing Inside Diameter

0 degrees

120 degrees

240 degrees

Na

50. ODE Sleeve Bearing Outside Diameter

0 degrees

120 degrees

240 degrees

Na

51. ODE Sleeve Bearing Housing Inside Diameter

0 degrees

120 degrees

240 degrees

Na


52. ODE Sleeve Bearing to Housing Clearance



0 degrees

120 degrees

240 degrees

Na

Rotor Inspection			
53. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast		
54. Growler Test	(Pass) Pass		
55. Number of Rotor Bars	116		
56. Rotor Condition	pass		
57. List the Parts needed for the Repair Below 6224x2 Two end bell bearing sleeves			
58. Signature of Technician that Disassembled Motor	Cw		
			
Mechanical Fits- Rotor			
59. Shaft Runout	inches		
Na			
60. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
Na			
61. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
Na			
62. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
Pass			
63. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
4.7249	4.7248	4.7249	
64. Drive End Bearing Shaft Fit Condition	(P) Pass		
65. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
4.7249	4.725	4.7251	
66. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass		
67. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Na			
Mechanical Fits- Bearing Housings			
68. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
8.4663	8.4665	8.4658	
69. Drive End - Endbell Bearing Fit Condition	(F) Fail		

70.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	8.4693	8.466799999999999	8.4674
	71. Opposite Drive End - Endbell Bearing Fit Condition		(F) Fail
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	
<div><div></div><div>Na</div></div>		
74. List Machine Work Needed Below		
<i>Both end bell bearing fits</i>		
75. Technician	Cw	
<div></div>		

Root Cause of Failure

76. Failure locations	
Bearings and both end bell bearing fits	
77. Root cause of failure	
Wear and metal fatigue	

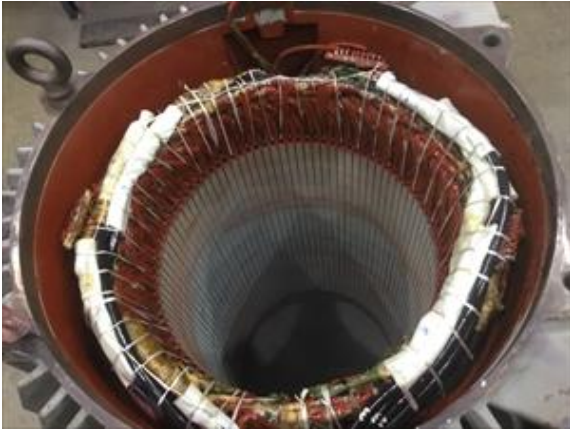
Dynamic Balance Report

78. Rotor Weight and Balance Grade		
Rotor Weight		Balance Grade
Na		

Opposite Drive End



Chris

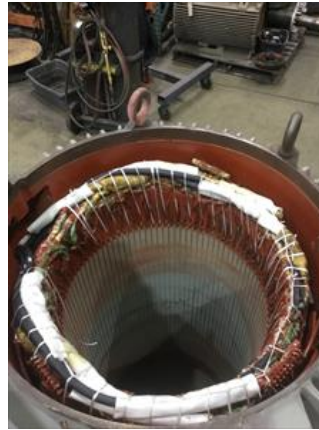
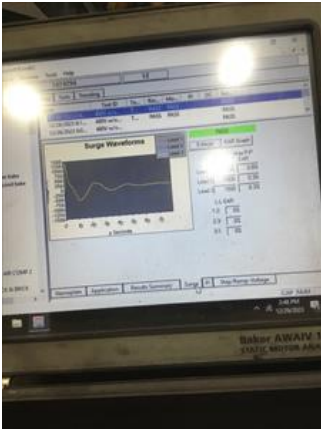


Rewind

82. Core Test Results - Watts loss per Pound		
Pre-Burnout		Post Burnout
Na		
83. Core Hot Spot Test		
Pre-Burnout		Post-Burnout
Na		
84. Post Rewind Electrical Test- Insulation Resistance		14129 Megohms
85. Post Rewind Polarization Index		Polarization Index
Na		
86. Post Rewind Winding Resistance		
1-2	1-3	2-3
0.0229	0.0229	0.0229

87. Post Rewind Surge Test

(Pass) Pass



88. Post Rewind Hi-Pot

micro-amps

Na

89. Technician

RW

[Handwritten signature: RW]

Co witnesses RHR

Mechanical Fits- Rotor - Post Repair

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		
Mechanical Fits- Bearing Housings - Post Repair		
98. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
8.465	8.465	8.465



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

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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		Cw
		

112. Photograph All Major Components prior to assembly

(Complete) Complete



113. Final Insulation Resistance Test

Na

Megohms

114. Assembled Shaft Endplay

Na







inches

115. Assembled Shaft Runout












Na

inches

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116. Test Run Voltage		
Volts	Volts	Volts
<div>  <i>In picture</i> </div>		
		
117. Test Run Amperage		
Amps	Amps	Amps
<div>  <i>In picture</i> </div>		
		
118. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.008999999999999999	0.008	0.008999999999999999
119. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.008999999999999999	0.01	0.008999999999999999
120. Ambient Temperature - Fahrenheit		
<div>  <i>Na</i> </div>		
121. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
<div>  <i>Na</i> </div>		

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122. Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
 Na		
123. Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
 Na		
124. Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
 Na		
125. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
 Na		
126. Opposite Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
 Na		
127. Opposite Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
 Na		
128. Opposite Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
 Na		
129. Stator Temperatures- Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
 Na		
130. Stator Temperatures- Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
 Na		
131. Stator Temperatures- Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
 Na		
132. Stator Temperatures- Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
 Na		
133. Document Final Condition with Pictures after paint		



134. Final Pics and QC Review

Cw

A handwritten signature in black ink, which appears to read "Trevor Hall".



Co sign: TREVOR HALL



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.
3. **SCOPE OF GOODS AND/OR SERVICES.** The goods and/or services provided by Hi-Speed pursuant to any quotation shall be limited exclusively to those goods and/or services expressly identified therein. Hi-Speed does not assume any responsibility and/or liability for the failure to provide any other goods and/or services not identified in any quotation. Modifications, additions or deletions to or from the scope referenced in any quotation shall only be effective if evidenced in writing and signed by Hi-Speed. The sale of any of all goods and/or services affected by such modification, addition or deletion shall be subject to these same Standard Terms and Conditions whether or not referenced therein.
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.
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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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10. **SEVERABILITY.** The partial or complete invalidity of any provision of these Standard Terms and Conditions shall not affect the enforceability of the remainder of these Standard Terms and Conditions. If any provision is found to be invalid or unenforceable, that portion shall be modified to make it enforceable or shall be stricken and the remainder of these Standard Terms and Conditions shall enforced.
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.