



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

LR Motor Shop Repairs

Job Number 102803

Prepared for BAD BOY

102 INDUSTRIAL DRIVE
BATESVILLE AR 72501

Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *C1503191212*

1.0

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

AC Inspection as Found

BAD BOY

102 INDUSTRIAL DRIVE
BATESVILLE, AR 72501

FolderID: 102803
FormID: 20116094

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: C1503191212

Description: 50HP BALDOR 1775 RPM

Hi-Speed Job Number: 102803

Manufacturer: Baldor

Product Number: CAT: EM4115T

Spec/ID #: 12H013Y141G1

Serial Number: C1503191212

HP/kW: 50 (HP)

RPM: 1775 (RPM)

Frame: 326T

Voltage: 208-230/460

Current: 128-116/58 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

of Leads: 9

J-box Included: Complete

Coupling/Sheave: None

Date Received: 04/29/2024

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: No

Shaft Machined Fit Repairs
Required: Yes

Bearing Housing Machined
Fit Repairs Required: No

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 1 - High ● 10 - Good

Overall Condition

1. Report Date

04/26/2024

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2. Nameplate Picture



3. Photos of all six sides of the machine.





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4. Describe the Overall Condition of the Equipment as Received

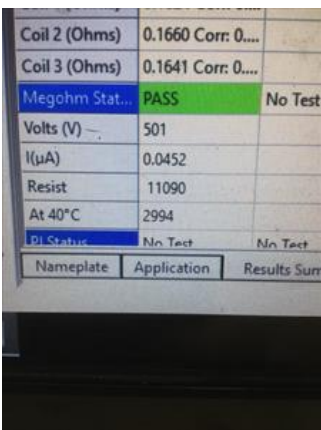
Dirty

Initial Mechanical/Electrical

5. Does Shaft Turn Freely?	(Y) Yes
6. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
7. Does Shaft Have Visible Damage?	(No) No
8. Assembled Shaft Runout	Inches
Na	
9. Assembled Shaft End Play	inches
Na	
10. Air Gap Variation <10%	
Na	
11. Lead Condition	(P) Pass
12. Lead Length	16 Inches
13. Does it have Lugs?, If so what is the Stud Size?	(No) No
14. Lead Numbers	1-9
15. Frame Condition	pass
16. Fan Condition	(P) Pass
17. Broken or Missing Components	na

Initial Electrical Inspection

18. Insulation Resistance/Megger	Megohms
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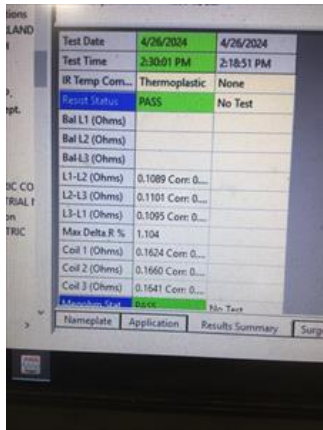
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19. Winding Resistance

1-2

1-3

2-3



Test Date	4/26/2024	4/26/2024
Test Time	2:30:01 PM	2:18:51 PM
IR Temp Conn...	Thermoplastic	None
Resist Status	PASS	No Test
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.1089 Corr: 0...	
L2-L3 (Ohms)	0.1101 Corr: 0...	
L3-L1 (Ohms)	0.1095 Corr: 0...	
Max Delta R %	1.104	
Coil 1 (Ohms)	0.1624 Corr: 0...	
Coil 2 (Ohms)	0.1660 Corr: 0...	
Coil 3 (Ohms)	0.1641 Corr: 0...	
IR Protection	Pass	No Test
Nameplate	Application	Results Summary

20. Perform Surge Test

(P) Pass



21. Number of Stator Slots

48

22. Stator Condition

needs washed

23. Stator Thermistors/Ohms

Na

24. Stator Overloads/Ohms

Na

Mechanical Inspection

25. Drive End Bearing Brand

FAG



26. Drive End Bearing Number- 6312

27. Drive End Bearing Qty. 1

28. Drive End Bearing Type (Ball) Ball Bearing

29. Drive End Lubrication Type (Grease) Grease Lubricated

30. Drive End Bearing Insulation or Grounding Device?

Na

31. Drive End Wavy Washer/Snap-Ring Other Retention Device? spanner nut

32. Drive End Bearing Condition

Signs of contamination



33. Opposite Drive End Bearing Brand

FAG



34. Opposite Drive End Bearing Number-	6311
35. Opposite Drive End Bearing Qty.	1
36. Opposite Drive End Bearing Type	(Ball) Ball Bearing
37. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
38. Opposite Drive End Bearing Insulation or Grounding Device?	
Na	
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
40. Opposite Drive End Bearing Condition	
Signs of contamination	



41. Drive End Seal	na
42. Opposite Drive End Seal	
Na	
Rotor Inspection	
43. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
44. Growler Test	(Pass) Pass
45. Number of Rotor Bars	46
46. Rotor Condition	needs cleaned
47. List the Parts needed for the Repair Below	
6312	
6311	

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48. Signature of Technician that Disassembled Motor

Cw



Mechanical Fits- Rotor

49. Shaft Runout 0.003 inches

50. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

Na

51. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

Na

52. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

Na

53. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

Failed
Bearing spun on shaft



54. Drive End Bearing Shaft Fit Condition (F) Fail

55. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.1656

2.1657

2.1656

56. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

57. Shaft Air Seal Fits


Drive End Air Seal

Opposite Drive End Air Seal

Na



Mechanical Fits- Bearing Housings

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58. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.1185	5.1184	5.1185
59. Drive End - Endbell Bearing Fit Condition		(P) Pass
60. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
4.7247	4.7248	4.7247
61. Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
62. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
Pass		
63. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
Na		
64. List Machine Work Needed Below		
DE shaft bearing fit		
65. Technician		Cw
		
Witness: TRH		
Root Cause of Failure		
66. Failure locations		
Bearings and DE shaft bearing fit		
67. Root cause of failure		
Wear and contamination and mixed grease		
Dynamic Balance Report		
68. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	



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69. Initial Balance Readings		
Drive End	Opposite Drive End	
0.59	1.28	
70. Final Balance Readings		
Drive End	Opposite Drive End	
0.24	0.37	
71. Technician		RW
		
Mechanical Fits- Rotor - Post Repair		
72. Shaft Runout Post Repair	inches	
73. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
74. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
75. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
76. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
2.3629	2.3629	2.3629
		
77. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
78. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	

79. Shaft Repair Sign-off

RW

[Handwritten signature]

Assembly

80. QC Check All Parts for Cleanliness Prior to Assembly

RW

[Handwritten signature]

81. Photograph All Major Components prior to assembly

(Complete) Complete



82. Final Insulation Resistance Test

Megohms

HP passed

83. Assembled Shaft Endplay

inches

84. Assembled Shaft Runout

0.001 inches

85. Test Run Voltage

Volts

Volts

Volts

457

456

459



86. Test Run Amperage

Amps

Amps

Amps

21.2

21.2

21.2



Co witness CRW

87. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.02

0.04

0.04

88. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.05

0.04

0.04

89. Ambient Temperature - Fahrenheit

90. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

91. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

92. Document Final Condition with Pictures after paint

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93. Final Pics and QC Review

RW

hw

Co witness CRW



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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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