



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

LR Motor Shop Repairs

Job Number 103572

Prepared for Bryce Corporation (10053-BRC)

450 S. Benton
Searcy AR 72143

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

AC Inspection as Found
Bryce Corporation (10053-BRC)
450 S. Benton
Searcy, AR 72143

FolderID: 103572
FormID: 21768595

AC Inspection - Rev. 2

Location: MOTOR SHOP LR
Serial Number: X2011M04138
Description: 300HP BALDOR 1785RPM

Hi-Speed Job Number:	103572
Manufacturer:	Baldor
Product Number:	CAT: 12085880471-20
Spec/ID #:	P40T1331
Serial Number:	X2011M04138
HP/kW:	300 (HP)
RPM:	1785 (RPM)
Frame:	PFL4034
Voltage:	460
Phase:	Three
Hz:	60 (Hz)
# of Leads:	3
J-box Included:	None
Coupling/Sheave:	Coupling
Date Received:	09/30/2024
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	Yes
Shaft Machined Fit Repairs Required:	Yes
Bearing Housing Machined Fit Repairs Required:	Yes
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● **6 - High** ● **4 - Good**

Overall Condition

1. Report Date

09/30/2024

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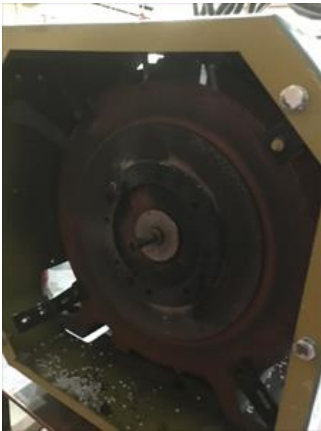
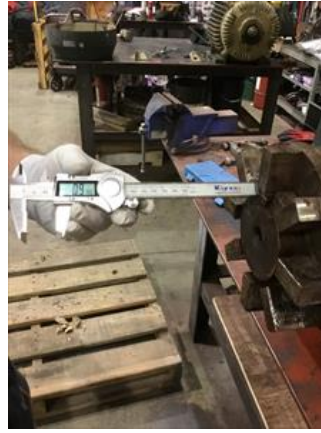
1.0

2. Nameplate Picture



3. Photos of all six sides of the machine.

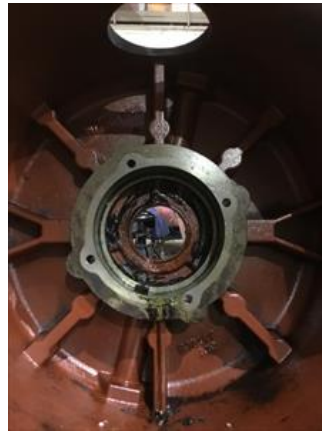




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4.	Describe the Overall Condition of the Equipment as Received		
	Plastic melted to top		
5.	Distance from the end of the shaft to the Coupling/Sheave		0.9755 inches
6.	Report Date [COPY]		09/30/2024
Initial Mechanical/Electrical			
7.	Does Shaft Turn Freely?		(Y) Yes
8.	Does the shaft require T.I.R in Lathe to identify additional repairs?		(No) No
9.	Does Shaft Have Visible Damage?		(No) No
10.	Assembled Shaft Runout		0 Inches
11.	Assembled Shaft End Play		0 inches
12.	Air Gap Variation <10%		none
13.	Lead Condition		(P) Pass
14.	Lead Length		18 Inches
15.	Does it have Lugs?, If so what is the Stud Size?		(Yes) Yes
	3/8		
16.	Lead Numbers		1-3
17.	Frame Condition		good
18.	Fan Condition		(N) NA
19.	Broken or Missing Components		none
Initial Electrical Inspection			
20.	Insulation Resistance/Megger		2000 Megohms
21.	Winding Resistance		
	1-2	1-3	2-3
	0	0	0
22.	Perform Surge Test		(F) Fail
23.	Number of Stator Slots		72
24.	Stator Condition		rewind
25.	Stator Thermistors/Ohms		0
26.	Stator Overloads/Ohms		1
	3 overloads		
Mechanical Inspection			

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27. Drive End Bearing Brand

nachi



28. Drive End Bearing Number-	6219
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?	none
33. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
34. Drive End Bearing Condition	fatigued
35. Opposite Drive End Bearing Brand	nachi
36. Opposite Drive End Bearing Number-	6316
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?	none
41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy. snap ring groove but no snap ring
42. Opposite Drive End Bearing Condition	frosting
43. Drive End Seal	none
44. Opposite Drive End Seal	none
Rotor Inspection	
45. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
46. Growler Test	(Pass) Pass
47. Number of Rotor Bars	
48. Rotor Condition	good
49. List the Parts needed for the Repair Below 3.590 aegis rewind 6219 6316	
50. Signature of Technician that Disassembled Motor	David Maclin
Mechanical Fits- Rotor	
51. Shaft Runout	0 inches

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52. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
0	0	0	
53. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
0	0	0	
54. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
0	0	0	
55. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
0	0	0	
Badly damaged			
56. Drive End Bearing Shaft Fit Condition			(F) Fail
57. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
3.9375	3.9374	3.9374	
58. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
59. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
ok	ok		
Mechanical Fits- Bearing Housings			
60. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
0	0	0	
Badly damaged			
61. Drive End - Endbell Bearing Fit Condition			(F) Fail
62. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
8.465	8.465	8.465	
63. Opposite Drive End - Endbell Bearing Fit Condition			(F) Fail
64. Bearing Cap Condition			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
sleeve	ok		
65. End Bell Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
sleeve	ok		
66. List Machine Work Needed Below			
Weld and machine rotor DE, DE endbell air seal, DE bearing cap air seal, fit aegis DE			
67. Technician			David Maclin
			
Root Cause of Failure			

68. Failure locations

De bearing

69. Root cause of failure

Fatigue, may have been due to frosting.

Dynamic Balance Report

70. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



71. Initial Balance Readings

Drive End

Opposite Drive End

Na

72. Final Balance Readings

Drive End

Opposite Drive End

Na

73. Technician

DM

Rewind

74. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

Na

75. Core Hot Spot Test

Pre-Burnout

Post-Burnout

Na

76. Post Rewind Electrical Test- Insulation Resistance

Megohms

Na

77. Post Rewind Polarization Index

Polarization Index

Na

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78. Post Rewind Winding Resistance		
1-2	1-3	2-3
Na		
79. Post Rewind Surge Test		(Pass) Pass
80. Post Rewind Hi-Pot		micro-amps
Na		
81. Technician		
Na		
Mechanical Fits- Rotor - Post Repair		
82. Shaft Runout Post Repair		0.0005 inches
83. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0.002	0.002	0.001
84. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
85. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
86. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
3.7409	3.7409	3.7409



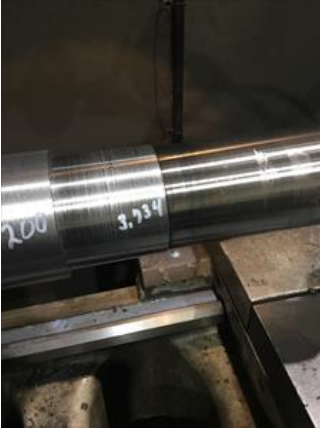
87. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees

88. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

.018



89. Shaft Repair Sign-off

Gary

Mechanical Fits- Bearing Housings - Post Repair

90. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees



91. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

92. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

4.230

Shaft dia. 4.200



93. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

3.765

Shaft dia. 3.734



94. End Bell Repair Sign-off

Gary

A handwritten signature in black ink, appearing to be 'Gary'.

Assembly

95. QC Check All Parts for Cleanliness Prior to Assembly

96. Photograph All Major Components prior to assembly



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1.11



97. Final Insulation Resistance Test			Megohms
Pass the Hi pot			
98. Assembled Shaft Endplay			inches
Na			
99. Assembled Shaft Runout			inches
Na			
100. Test Run Voltage			
Volts	Volts	Volts	
457	456	459	



Co sign DM

101. Test Run Amperage		
Amps	Amps	Amps
114.5	109.8	111.5



102. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.02	0.04	0.02
103. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.08	0.04	0.06
104. Ambient Temperature - Fahrenheit		
Na		
105. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
106. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
107. Document Final Condition with Pictures after paint		

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108. Final Pics and QC Review

RW

Co sign DM



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

AC Random Coil Rewind Report

FolderID: 103572
FormID: 21799380

Bryce Corporation (10053-BRC)


450 S. Benton
Searcy, AR 72143

MOTOR SHOP LR
Winding

Priorities Found: ● 3 - High ● 5 - Good

General	
1. Job Number	103572
2. Report Date	09/28/2024
3. Customer	Bryce Corp.
Stator Winding	
4. Core Length	17.125 "
5. Core ID	13 "
6. Back Iron Depth	1.5 "
7. Slot Depth	1.75 "
8. Tooth Width	0.28125 "
9. Number of Vents	0
10. Vent Width	0 "
● 11. Before Burnout Core loss	(P) Pass
12. Flux Before Burnout	
13. Watts before burnout	
14. Watts loss per lb. before burnout	0.87 W/lbs.
● 15. After Burnout Core Loss	(P) Pass
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	0.75 W/lbs.
● 19. Core Iron Condition	(P) Pass
● 20. RTD's	(N) No
21. RTD's Reading	
● 22. Motor Heaters	(N) No
23. Heater Qty.	0
24. Heater Voltage	Volts
25. Heater Wattage	Watts
● 26. Thermistors	(N) No
27. Number of Poles	4
28. Slots	72
29. Number of Coils	72
30. Coil Weight	190 Lbs.
31. Lead Markings	
1-3	
32. Grouping	
12g of 6c	

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33. Multiple Wires	(Y) Yes
34. Wire Size 4 #15 2 #16 4 #17	
35. Turns per coil 6-6-6-5-6-6	
36. Pitch 1 to:	16
37. Connection 4 delta	
38. Lead Length	20 "
39. Lead Size	1/0
40. Number of Leads	6
41. Megger Reading After Rewind	Mohms
42. Coil Machine Slot	8
43. Coil Machine Tip 5.5" lead end 6.25 with connection 4.5" opposite lead end	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	Ua
46. Surge Pattern After Rewind	(P) Pass
47. Service Technician  190 total wire weight 76 lbs #15 awg 38 lbs #16 awg 76 lbs #17 awg 25' 1/0 EPDM lead wire	



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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.
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.
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.
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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.