



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

LR Motor Shop Repairs

Job Number 103395

Prepared for ConAgra (10859-CON)

3100 E. Main St.
Russellville AR 72801

Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *4AB27244CSV*

1.0

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Printed on 8/21/2024

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Table of Contents



Hi-Speed Industrial Service
7030 Ryburn Dr
Millington, Tn 38053
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AC Inspection as Found

ConAgra (10859-CON)

3100 E. Main St.
Russellville, AR 72801

FolderID: 103395
FormID: 21343867

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: 4AB27244CSV

Description: 300HP WEG EVAL

Hi-Speed Job Number: 103395

Manufacturer: WEG

Product Number: 8048-06530

Serial Number: 4AB27244CSV

HP/kW: 300 (HP)

RPM: 3580 (RPM)

Frame: 447TS

Voltage: 460

Current: 334

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: ODP

of Leads: 6

J-box Included: None

Coupling/Sheave: 2-631

Date Received: 08/19/2024

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: No

Shaft Machined Fit Repairs
Required: No

Bearing Housing Machined
Fit Repairs Required: Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 3 - High ● 8 - Good

Overall Condition

1. Report Date

08/19/2024

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1.0

2. Nameplate Picture



3. Photos of all six sides of the machine.





4.	Describe the Overall Condition of the Equipment as Received	
	<i>Serviceable</i>	
5.	Distance from the end of the shaft to the Coupling/Sheave	inches
	<i>Na</i>	
6.	Report Date [COPY]	08/19/2024
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	inches
	<i>Na</i>	
12.	Air Gap Variation <10%	
	<i>Na</i>	
13.	Lead Condition	(P) Pass

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14. Lead Length

19 Inches



15. Does it have Lugs?, If so what is the Stud Size?

16. Lead Numbers

1-6

17. Frame Condition

pass

18. Fan Condition

(N) NA

19. Broken or Missing Components

None

Initial Electrical Inspection

20. Insulation Resistance/Megger

2285 Megohms

21. Winding Resistance

1-2

1-3

2-3

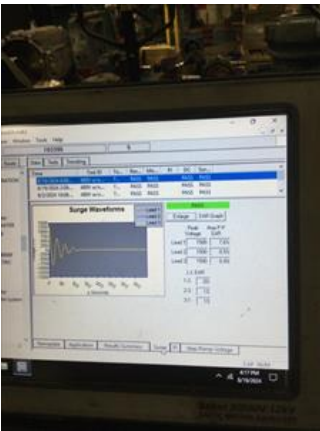
0.01233

0.01237

0.01235

22. Perform Surge Test

(P) Pass



23. Number of Stator Slots

48

24. Stator Condition

Wash and bake



25. Stator Thermistors/Ohms

Na

26. Stator Overloads/Ohms

A

Mechanical Inspection

27. Drive End Bearing Brand

SKF

28. Drive End Lubrication Type

(Grease) Grease Lubricated



29. Drive End Bearing Insulation or Grounding Device?

Na

30. Drive End Wavy Washer/Snap-Ring Other Retention Device?

Na

31. Drive End Bearing Condition

normal wear



32. Opposite Drive End Bearing Brand

SKF

33. Opposite Drive End Lubrication Type

(Grease) Grease Lubricated



34. Opposite Drive End Bearing Insulation or Grounding Device?

Na

35. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?

Na

36. Opposite Drive End Bearing Condition

grease contamination




37. Drive End Seal

Na




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38. Opposite Drive End Seal	Na
39. Drive End Bearing Number-	6313
40. Drive End Bearing Qty.	1
41. Drive End Bearing Type	(Ball) Ball Bearing
42. Opposite Drive End Bearing Number-	6313
43. Opposite Drive End Bearing Qty.	1
44. Opposite Drive End Bearing Type	(Ball) Ball Bearing
Rotor Inspection	
45. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast



46. Growler Test	(Pass) Pass
47. Number of Rotor Bars	40
48. Rotor Condition	Wash and bake
49. List the Parts needed for the Repair Below	
2-6313 Bearing	
50. Signature of Technician that Disassembled Motor	RW
	

Mechanical Fits- Rotor

51. Shaft Runout	0 inches		
52. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
 Na			
53. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
 Na			
54. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
 Na			

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55. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.5597	2.5597	2.5597
56. Drive End Bearing Shaft Fit Condition		(P) Pass



57. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.5595	2.5595	2.9554
58. Opposite Drive End Bearing Shaft Fit Condition		(P) Pass



59. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
pass	na	
Mechanical Fits- Bearing Housings		
60. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.5136	5.5134	5.5136
61. List Machine Work Needed Below		
<i>Resleeve both end bells</i>		

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62. Technician

RW


 Co sign CRW

63. Drive End - Endbell Bearing Fit Condition (F) Fail

 Resleeve

64. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

5.5148

5.5148

5.5151

65. Opposite Drive End - Endbell Bearing Fit Condition (F) Fail

 Resleeve

66. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass

67. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

pass

Root Cause of Failure

68. Failure locations

End bells and bearings

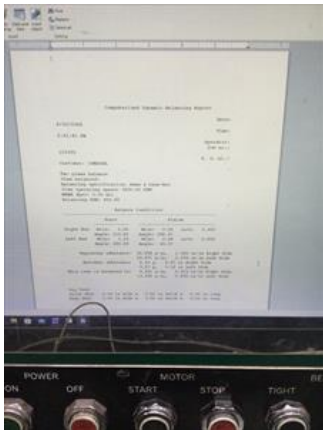
69. Root cause of failure

*Over greased***Dynamic Balance Report**

70. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



71. Initial Balance Readings

Drive End

Opposite Drive End

1.06

1.10

72. Final Balance Readings

Drive End

Opposite Drive End

.26

.24

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73. Technician

RW


Mechanical Fits- Bearing Housings - Post Repair

74. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

5.5123

5.5123

5.5124

5.5123

5.5123

5.5124



75. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

5.5124

5.5125

5.5124

5.5124

5.5125

5.5124



76. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass**pass**

77. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

pass**pass**

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78. End Bell Repair Sign-off

Gary



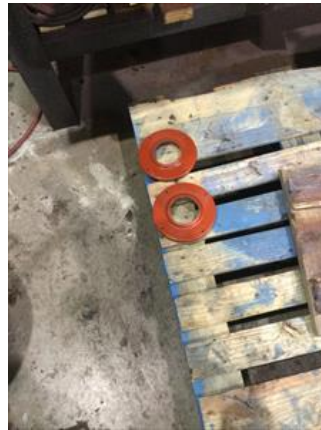
Assembly

79. QC Check All Parts for Cleanliness Prior to Assembly

RW



80. Photograph All Major Components prior to assembly





81. Final Insulation Resistance Test			Megohms
Pass the Hi pot			
82. Assembled Shaft Endplay			inches
Na			
83. Assembled Shaft Runout			0.0002 inches
84. Test Run Voltage			
Volts	Volts	Volts	
457	456	458	



Co sign TRH

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85. Test Run Amperage		
Amps	Amps	Amps
67.09999999999999	67.5	66.2



86. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.03	0.03	0.01
87. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.03	0.03	0.01
88. Ambient Temperature - Fahrenheit		
Na		
89. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
90. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
91. Document Final Condition with Pictures after paint		



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92. Final Pics and QC Review

RW

hw



Co sign TRH



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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.
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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.