



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

LR Motor Shop Repairs

Job Number 102418

Prepared for Custom Craft Poultry

3064 E Main St
Batesville AR 72501

Table of Contents

AC Inspection as Found - *Shop*

AC Inspection - Rev. 2

1.0

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

AC Inspection as Found

Custom Craft Poultry

3064 E Main St
Batesville, AR 72501

FolderID: 102418
FormID: 19225444

AC Inspection - Rev. 2

Location: Shop

Serial Number:

Hi-Speed Job Number: 102418

Manufacturer: Toshiba

Serial Number: 7011743-01-FB-02

HP/kW: 250 (HP)

RPM: 3565 (RPM)

Frame: 445TS

Voltage: 230 / 460

Current: 570/285

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15


Enclosure: ODP

J-box Included: None

Coupling/Sheave: None

Date Received: 02/01/2024

Repair Stage: Final

Priorities Found:  8 - Good

Overall Condition

1. Report Date
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		
Initial Mechanical/Electrical		
5.	Does Shaft Turn Freely?	(Yes) Yes
6.	Does the shaft require T.I.R in Lathe to identify additional repairs?	
7.	Does Shaft Have Visible Damage?	(No) No
8.	Assembled Shaft Runout	
9.	Assembled Shaft End Play	
10.	Air Gap Variation <10%	na
11.	Lead Condition	(P) Pass
12.	Lead Length	13 Inches
13.	Lead Numbers	
	No numbers	
14.	Stator Temperature Detector Rating and Function	
	Quantity	Rating
		Quantity Passed
	Na	
15.	Bearing Temperature Detector Rating and Function	
	Quantity	Rating
		Quantity Passed
	Na	
16.	Frame Condition	pass
17.	Fan Condition	(N) NA
18.	Heater Quantity, Ratings	
	Quantity	Volts/Watts
		Pass/Fail
	Na	
19.	Broken or Missing Components	
	Na	
Initial Electrical Inspection		
20.	Insulation Resistance/Megger	19896 Megohms
21.	Winding Resistance	
	1-2	1-3
		2-3
	0.0217	0.0217
		0.0214

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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

Na

Mechanical Inspection

27. Drive End Bearing Brand

Koyo

28. Drive End Bearing Number-

6313



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?	nut
34. Drive End Bearing Condition	
Balls skid and contaminate grease	



35. Opposite Drive End Bearing Brand	Koyo
36. Opposite Drive End Bearing Number-	6313







Frosted and contaminated grease

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?	
Nut	
42. Opposite Drive End Bearing Condition	



Frosted and grease contamination

43. Drive End Seal			
 Na			
44. Opposite Drive End Seal			
 Na			
45. DE Sleeve Bearing Inside Diameter			
0 degrees	120 degrees	240 degrees	
 Na			
46. DE Sleeve Bearing Outside Diameter			
0 degrees	120 degrees	240 degrees	
 Na			

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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	40	
56. Rotor Condition	dirty	



57. List the Parts needed for the Repair Below
1-6313 Bearing 2-6313 Bearing

58. Signature of Technician that Disassembled Motor

RW

RW

Mechanical Fits- Rotor

59. Shaft Runout 0.0013 inches

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

2.4743

2.3743

2.3743



62. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

2.3741

2.3743

2.3743

63. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.5593

2.5593

2.5593

64. Drive End Bearing Shaft Fit Condition

(P) Pass

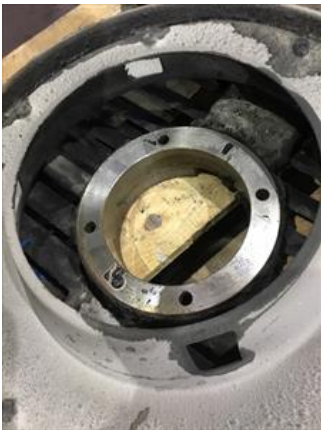


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65. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.5593	2.5593	2.5593	
66. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass



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		120 Degrees	
5.5125		5.5125	
69. Drive End - Endbell Bearing Fit Condition			
			(P) Pass



70. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.5126	5.5126	5.5126	



72. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass**pass**

73. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

74. List Machine Work Needed Below

None

75. Technician

RW**Root Cause of Failure**

76. Failure locations

Leads have no numbers

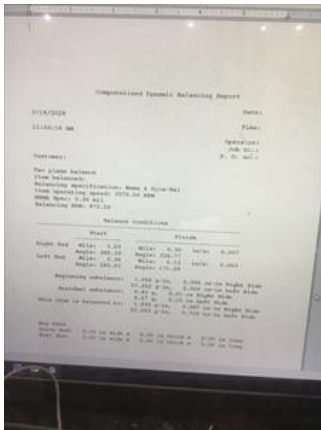
77. Root cause of failure

Dynamic Balance Report

78. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



79. Initial Balance Readings

Drive End

Opposite Drive End

.36**.29**

80. Final Balance Readings

Drive End

Opposite Drive End

.13**.30**

81. Technician

David Maclin

Rewind

82. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

0

83. Core Hot Spot Test

Pre-Burnout

Post-Burnout

na

84. Post Rewind Electrical Test- Insulation Resistance

0 Megohms

85. Post Rewind Polarization Index

0 Polarization Index

86. Post Rewind Winding Resistance

1-2

1-3

2-3

0**0****0**

87. Post Rewind Surge Test

(Pass) Pass

88. Post Rewind Hi-Pot

0 micro-amps

89. Technician



David Maclin

Mechanical Fits- Rotor - Post Repair

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90.	Shaft Runout Post Repair	0 inches	
91.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
	0	0	0
92.	Coupling Fit Closest to Bearing Housing Post Repair		
	0 Degrees	90 Degrees	120 Degrees
	0	0	0
93.	Coupling Fit Closest to the end of the Shaft Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	0	0	0
94.	Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	0	0	0
95.	Opposite Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	0	0	0
96.	Shaft Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
	ok	ok	
97.	Shaft Repair Sign-off	David Maclin	
			
Mechanical Fits- Bearing Housings - Post Repair			
98.	Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	0	0	0
99.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	0	0	0
100.	Bearing Cap Condition Post Repair		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	ok	ok	
101.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
	ok	ok	
102.	DE Sleeve Bearing Inside ID Post Repair		
	Measure 1	Measure 2	Measure 3
	0	0	0
103.	DE Sleeve Bearing Outside ID Post Repair		
	Measure 1	Measure 2	Measure 3
	0	0	0
104.	DE Sleeve Bearing Inside OD Post Repair		
	Measure 1	Measure 2	Measure 3
	0	0	0

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105. DE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
0	0	0
106. End Bell Repair Sign-off		David Maclin
		
107. ODE Sleeve Bearing Inside ID Post Repair		
Measure 1	Measure 2	Measure 3
0	0	0
108. ODE Sleeve Bearing Outside ID Post Repair		
Measure 1	Measure 2	Measure 3
0	0	0
109. ODE Sleeve Bearing Inside OD Post Repair		
Measure 1	Measure 2	Measure 3
0	0	0
110. ODE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
0	0	0
Assembly		
111. QC Check All Parts for Cleanliness Prior to Assembly		David Maclin
		
112. Photograph All Major Components prior to assembly		





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113. Final Insulation Resistance Test	2000 Megohms	
114. Assembled Shaft Endplay	0 inches	
115. Assembled Shaft Runout	0 inches	
116. Test Run Voltage		
Volts	Volts	Volts
458	458	460
Witnessed by Trevor Hall		



117. Test Run Amperage		
Amps	Amps	Amps
80.8	75.59999999999999	77.5
118. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.0284	0.0257	0.0183
119. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.0321	0.0528	0.0162
120. Ambient Temperature - Fahrenheit	70	
121. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
70	70	70
122. Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes

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70	70	70	
123. Drive End Bearing Temps - Fahrenheit 35-45 Minutes			
35 Minutes	40 Minutes	45 Minutes	
70	70	70	
124. Drive End Bearing Temps - Fahrenheit 50-60 Minutes			
50 Minutes	55 Minutes	60 Minutes	
70	70	70	
125. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
70	70	70	
126. Opposite Drive End Bearing Temps - Fahrenheit 20-30 Minutes			
20 Minutes	25 Minutes	30 Minutes	
70	70	70	
127. Opposite Drive End Bearing Temps - Fahrenheit 35-45 Minutes			
35 Minutes	40 Minutes	45 Minutes	
70	70	70	
128. Opposite Drive End Bearing Temps - Fahrenheit 50-60 Minutes			
50 Minutes	55 Minutes	60 Minutes	
70	70	70	
129. Stator Temperatures- Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
70	70	70	
130. Stator Temperatures- Fahrenheit 20-30 Minutes			
20 Minutes	25 Minutes	30 Minutes	
70	70	70	
131. Stator Temperatures- Fahrenheit 35-45 Minutes			
35 Minutes	40 Minutes	45 Minutes	
70	70	70	
132. Stator Temperatures- Fahrenheit 50-60 Minutes			
50 Minutes	55 Minutes	60 Minutes	
70	70	70	
133. Document Final Condition with Pictures after paint			looks good
134. Final Pics and QC Review			David Maclin
			





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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.
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

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.
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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.