



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

LR Motor Shop Repairs

Job Number 103318

Prepared for Delta Plastics (11016)

8801 Frazier Pike
Little Rock AR 72206

Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *B9126122-020002*

1.0

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Printed on 8/28/2024

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

AC Inspection as Found

Delta Plastics (11016)

8801 Frazier Pike
Little Rock, AR 72206

FolderID: 103318
FormID: 21212402

AC Inspection - Rev. 2

Location: MOTOR SHOP LR
Serial Number: B9126122-020002
Description: 150HP BALDOR 1750RPM

Hi-Speed Job Number:	103318
Manufacturer:	Baldor
Spec/ID #:	B889014
Serial Number:	B9126122-020002
HP/kW:	150 (HP)
RPM:	1750 (RPM)
Voltage:	460
Current:	180 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
Enclosure:	DP
# of Leads:	6
J-box Included:	Half
Coupling/Sheave:	None
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: ● 3 - High ● 9 - Good

Overall Condition

1. Report Date

08/05/2024

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1.0

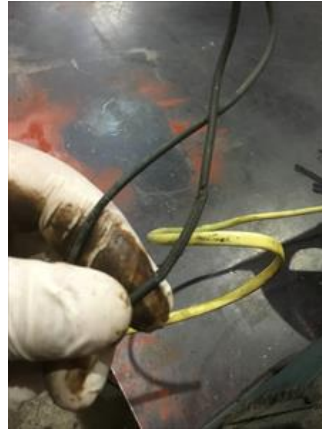
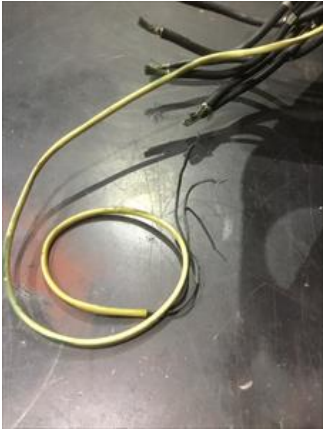
2. Nameplate Picture



3. Photos of all six sides of the machine.



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4. Describe the Overall Condition of the Equipment as Received	
<i>Dirty</i>	
5. Report Date [COPY]	08/28/2024
Initial Mechanical/Electrical	
6. Does Shaft Turn Freely?	(N) No
7. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
8. Does Shaft Have Visible Damage?	(No) No
9. Assembled Shaft Runout	0 Inches
10. Assembled Shaft End Play	0 inches
11. Air Gap Variation <10%	none
12. Lead Condition	(P) Pass
13. Lead Length	16 Inches
14. Does it have Lugs?, If so what is the Stud Size?	(No) No
15. Lead Numbers	1-1/2-2/3-3
16. Frame Condition	pass
17. Fan Condition	(N) NA
18. Broken or Missing Components	J-box cover
Initial Electrical Inspection	
19. Insulation Resistance/Megger	Megohms

Coil 2 (Ohms)	0.1127 Corr: 0....
Coil 3 (Ohms)	0.1130 Corr: 0....
Megohm Stat...	PASS
Volts (V)	498
I(μA)	0.0758
Resist	6573
At 40°C	1774
PI Status	No Test No T
Nameplate	Application Results

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20. Winding Resistance

1-2

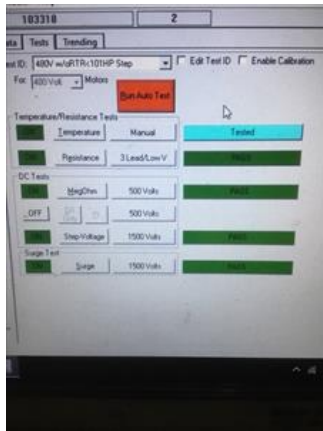
1-3

2-3

R Temp Com...	Thermoplastic	None
Resist Status	PASS	No Test
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.0749 Corr: 0....	
L2-L3 (Ohms)	0.0751 Corr: 0....	
L3-L1 (Ohms)	0.0752 Corr: 0....	
Max Delta R %	0.420	
Coil 1 (Ohms)	0.1120 Corr: 0....	
Coil 2 (Ohms)	0.1127 Corr: 0....	
Coil 3 (Ohms)	0.1130 Corr: 0....	
Minichurn Stat	Pass	Edn Test
Nameplate	Application	Results Summa

21. Perform Surge Test

(P) Pass



22. Number of Stator Slots

48

23. Stator Condition

pass

24. Stator Thermistors/Ohms

25. Stator Overloads/Ohms

0.3ohms

Mechanical Inspection

26. Drive End Bearing Brand

FAG

27. Drive End Bearing Number-

NU215

28. Drive End Bearing Qty.

1

29. Drive End Bearing Type

(Roller) Roller Bearing

30. Drive End Lubrication Type

(Grease) Grease Lubricated

31. Drive End Bearing Insulation or Grounding Device?

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

none

33. Drive End Bearing Condition

inner race is cracked



34. Opposite Drive End Bearing Brand	FAG
35. Opposite Drive End Bearing Number-	6211
36. Opposite Drive End Bearing Qty.	1
37. Opposite Drive End Bearing Type	(Ball) Ball Bearing
38. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
39. Opposite Drive End Bearing Insulation or Grounding Device?	none
40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
41. Opposite Drive End Bearing Condition	

Wear



42. Drive End Seal	na
43. Opposite Drive End Seal	na

Rotor Inspection

44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
45. Growler Test	(Pass) Pass
46. Number of Rotor Bars	40
47. Rotor Condition	pass

48. List the Parts needed for the Repair Below

NU-215

6211

Recommend new aegis ring

49. Signature of Technician that Disassembled Motor

Cw



Mechanical Fits- Rotor

50. Shaft Runout 0.0005 inches

51. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0.001

0.001

0.001

52. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

0

0

0

53. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

0

0

0


54. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

 Excessive wear

 55. Drive End Bearing Shaft Fit Condition

(F) Fail



56. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.1657

2.1657

2.1657

 57. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass

58. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

ok

ok

Mechanical Fits- Bearing Housings

59. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

5.1196


5.1191

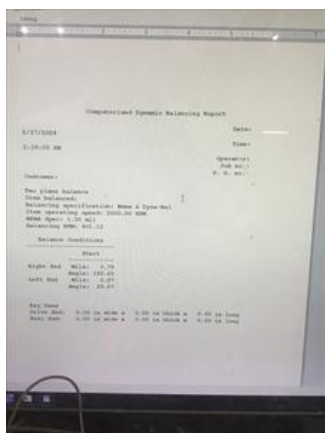
5.1194

 60. Drive End - Endbell Bearing Fit Condition

(P) Pass

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61. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
3.9379	3.9378	3.9379
62. Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
63. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
<div> <div></div> <div>Pass</div> </div>		
64. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
ok	ok	
65. List Machine Work Needed Below <i>DE shaft bearing fit</i>		
66. Technician		Cw
<div>  </div>		
<div> <div></div> <div>Co sign: RRW</div> </div>		
Root Cause of Failure		
67. Failure locations <i>Bearings and DE shaft bearing fit</i>		
68. Root cause of failure <i>DE bearing inner race failed by cracking in multiple places causing inner race to spin on shaft wearing down the bearing fit</i>		
Dynamic Balance Report		
69. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	



70. Initial Balance Readings	
Drive End	Opposite Drive End
.78	.87
71. Final Balance Readings	
Drive End	Opposite Drive End
.78	.87

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Mechanical Fits- Rotor - Post Repair

73. Shaft Runout Post Repair	0.0005 inches
------------------------------	----------------------

74. Rotor Runout Post Repair	
------------------------------	--

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0.001**0.001****0.001**

75. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

0**0****0**

76. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

0**0****0**

77. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

2.9543**2.9543****2.9543**

78. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

0**0****0**

79. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

ok**ok**

80. Shaft Repair Sign-off

Gary

Assembly

81. QC Check All Parts for Cleanliness Prior to Assembly

David Maclin



82. Photograph All Major Components prior to assembly

(Complete) Complete





83. Final Insulation Resistance Test		2000 Megohms
84. Assembled Shaft Endplay		0 inches
85. Assembled Shaft Runout		0 inches
86. Test Run Voltage		
Volts	Volts	Volts
457	456	459
Witnessed by R Wiley		

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87. Test Run Amperage		
Amps	Amps	Amps
53.2	50.9	51.6
88. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.0248	0.0384	0.0142
89. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.0163	0.0276	0.0104
90. Ambient Temperature - Fahrenheit		7
91. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
70	70	70
92. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
70	70	70
93. Document Final Condition with Pictures after paint		looks good
94. Final Pics and QC Review		David Maclin
		
 Witnessed by R Wiley		





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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.
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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.