



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

LR Motor Shop Repairs

Job Number 103360

Prepared for DeWaffelbakkers (10743)

10000 Crystal Hill Road
N.Little Rock AR 72113

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AC Inspection as Found - *LR MOTOR SHOP*

AC Inspection - Rev. 2: 93X26057

1.0

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AC Inspection as Found

DeWaffelbakkers (10743)

10000 Crystal Hill Road
N.Little Rock, AR 72113

FolderID: 103360
FormID: 21287956

AC Inspection - Rev. 2

Location: LR MOTOR SHOP
Serial Number: 93X26057
Description: 200HP RAM/TOSHIBA EVAL

Hi-Speed Job Number:	103360
Manufacturer:	Toshiba
Product Number:	1279780-01-NW-P-2
Serial Number:	93X26057
HP/kW:	200 (HP)
RPM:	3565 (RPM)
Frame:	444TS
Voltage:	230 / 460
Current:	470/236
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	ODP
# of Leads:	9
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	08/12/2024
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: ● 1 - High ● 10 - Good

Overall Condition

1. Report Date	08/19/2024
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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.	Report Date [COPY]	08/19/2024
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	(Y) Yes
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	0.001 Inches
10.	Assembled Shaft End Play	0 inches
11.	Air Gap Variation <10%	pass



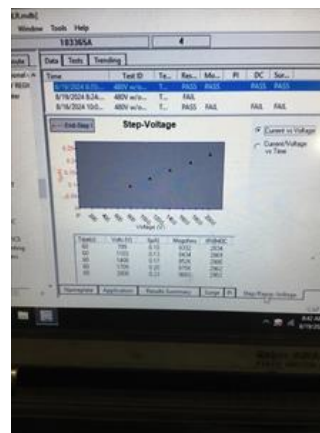
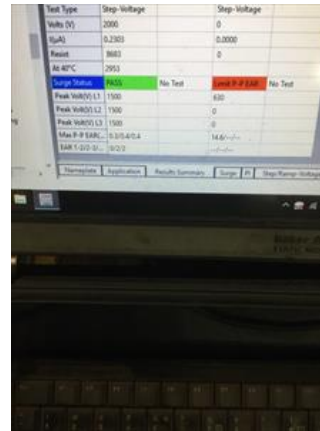
13. Lead Length	5.5 Inches
14. Does it have Lugs?, If so what is the Stud Size?	(No) No
15. Lead Numbers	1-12
16. Frame Condition	pass
17. Fan Condition	(N) NA
18. Broken or Missing Components	none
Initial Electrical Inspection	
19. Insulation Resistance/Megger	17.39 Megohms



2-3

Results	Date	Tests	Trending	Test ID	Te...	Res...	Pass	Pl	...
Regional & NATY REG	Time								
	8/16/2024 8:25	400V m/h...		PA55	PASS				
	8/16/2024 8:24	400V m/h...		FAIL					
water	8/16/2024 10:0	400V m/h...		PASS	FAIL				FA
	Test Date	8/16/2024		8/16/2024	8/16/2024				8/16/2024
	Temp Status	30.75-66.25 AM		8:24:25 AM	10:00:07 AM				9:54
	Temp Status	Tested		Tested					
	IR Temp Count	14.4		21.9					
	IR Temp Count	Thermoplastic	Thermoplastic	Thermoplastic	Thermoplastic				None
	Pass Status	PASS		FAIL	PASS				No Te...
	BALL1 (Ohms)			5612.8					
	BALL2 (Ohms)								
	BALL3 (Ohms)								
	L3-L2 (Ohms)	0.0206 Core 0...		0.0063 Core 0...	2.774 Core 2...				
	L3-L1 (Ohms)	0.0203 Core 0...		0.0407 Core 0...	2.776 Core 2...				
	L2-L1 (Ohms)	0.0207 Core 0...		0.0399 Core 0...	2.787 Core 2...				
	Max Delta R	2.586		0.161					
	Coat 1 (Ohms)	0.0001 Core 0...		0.0119 Core 0...	0.119				
	Coat 2 (Ohms)	1.9476 Core 0...		0.0070 Core 0...	4.146 Core 4...				
	Thermoplastic	Thermoplastic		Residual Summ...					
				Temp	Pl				Step

(P) Pass



48
dirty

1.6

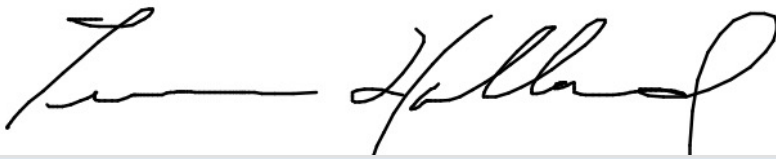


27. Drive End Bearing Number-	6313 C3
28. Drive End Bearing Qty.	1
29. Drive End Bearing Type	(Ball) Ball Bearing
30. Drive End Lubrication Type	(Grease) Grease Lubricated
31. Drive End Bearing Insulation or Grounding Device?	none
32. Drive End Wavy Washer/Snap-Ring Other Retention Device?	
Gland nut and lock washer.	
33. Drive End Bearing Condition	replace
34. Opposite Drive End Bearing Brand	SKF
35. Opposite Drive End Bearing Number-	6313



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?	gland nut and lock washer
41. Opposite Drive End Bearing Condition	replace
42. Drive End Seal	
43. Opposite Drive End Seal	
Rotor Inspection	
44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast

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45. Growler Test	(Pass) Pass	
46. Number of Rotor Bars	40	
47. Rotor Condition	pass	
48. List the Parts needed for the Repair Below <i>Bearings.</i>		
49. Signature of Technician that Disassembled Motor	Terrence Holland	
		
Mechanical Fits- Rotor		
50. Shaft Runout	0.001 inches	
51. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
52. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
53. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
54. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.5593	2.5593	2.5593
55. Drive End Bearing Shaft Fit Condition	(P) Pass	
56. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.5594	2.5593	2.5593
57. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	
58. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings		
59. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.5134	5.5131	
60. Drive End - Endbell Bearing Fit Condition	(F) Fail	
61. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.5121	5.5123	5.512
62. Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass	
63. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
pass	pass	
64. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	

65. List Machine Work Needed Below
D.E housing fit out of tolerance.

66. Technician

Terrence Holland



Co sign: CRW

Root Cause of Failure

67. Failure locations

Windings were very dirty. Leads are only 5.5" long. Top connection box cover as black mark that appears to be from where the leads shorted against it.



68. Root cause of failure

Possible leads shorting against connection box cover.

Dynamic Balance Report

69. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade
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70. Initial Balance Readings

Drive End	Opposite Drive End
0.19	0.54

71. Final Balance Readings

Drive End	Opposite Drive End
0.13	0.19

72. Technician	RW
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Handwritten signature: R W



Mechanical Fits- Bearing Housings - Post Repair

73. Drive End - Endbell Bearing Fit Post Repair

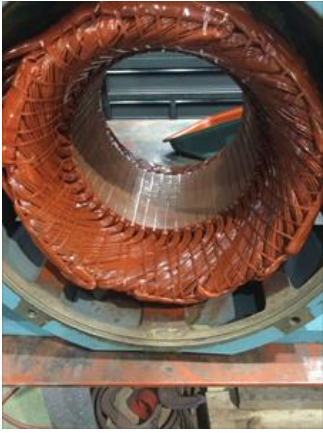
0 Degrees	60 Degrees	120 Degrees
5.5124	5.5124	5.5124

Na



74. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
Na		
75. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
Na		
76. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
Na		
77. End Bell Repair Sign-off		
		
Na		
Assembly		
78. QC Check All Parts for Cleanliness Prior to Assembly		RW
		
79. Photograph All Major Components prior to assembly		(Complete) Complete







80. Final Insulation Resistance Test			Megohms
Pass the Hi pot			
81. Assembled Shaft Endplay			inches
Na			
82. Assembled Shaft Runout			0.0003 inches
83. Test Run Voltage			
Volts	Volts	Volts	
459	459	460	



Co sign DM

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84. Test Run Amperage

Amps

71.7

Amps

69.2

Amps

70.7



85. Drive End Vibration Readings - Inches Per Second

Horizontal

0.01

Vertical

0.02

Axial

0.01

86. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

0.02

Vertical

0.03

Axial

0.02

87. Ambient Temperature - Fahrenheit

Na

88. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

89. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

90. Document Final Condition with Pictures after paint





91. Final Pics and QC Review

RW

HL



Co sign DM



STANDARD TERMS AND CONDITIONS FOR PURCHASE OF GOOD AND/OR SERVICES

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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.
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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.
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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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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.
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