



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

LR Motor Shop Repairs

Job Number 103338

Prepared for FUTURE FUEL CHEMICAL

2800 GAP RD HWY 394 SO
BATESVILLE AR 72501

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

AC Inspection as Found
FUTURE FUEL CHEMICAL
2800 GAP RD HWY 394 SO
BATESVILLE, AR 72501

FolderID: 103338
FormID: 21245685

AC Inspection - Rev. 2

Location: LR MOTOR SHOP

Serial Number: 1-5139-LR67718-03

Description: 20/10HP SIEMENS

Hi-Speed Job Number: 1033388

Manufacturer: Siemens

Serial Number: 1-5139-LR67718-03

HP/kW: 20 (HP)

RPM: 1730 (RPM)

Frame: 284T

Voltage: 460

Current: 24.3/18.6

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.0

Enclosure: XP

of Leads: 6

J-box Included: Complete

Coupling/Sheave: None

Date Received: 08/08/2024

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: No

Shaft Machined Fit Repairs Required: No

Bearing Housing Machined Fit Repairs Required: No

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: 2 - High 12 - Good

Overall Condition

1. Report Date 08/08/2024

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Printed on 9/19/2024

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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

Dirty

5. Report Date [COPY]

Initial Mechanical/Electrical

<input checked="" type="radio"/>	6. Does Shaft Turn Freely?	(Y) Yes
<input checked="" type="radio"/>	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	Inches
	10. Assembled Shaft End Play	inches
	11. Air Gap Variation <10%	
<input checked="" type="radio"/>	12. Lead Condition	(F) Fail



	13. Lead Length	12 Inches
<input checked="" type="radio"/>	14. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
<input type="radio"/>	Yes	
	15. Lead Numbers	1-6
	16. Frame Condition	pass
<input checked="" type="radio"/>	17. Fan Condition	(P) Pass
<input checked="" type="radio"/>	18. Broken or Missing Components	two j-box bolts

Initial Electrical Inspection

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19. Insulation Resistance/Megger

Megohms

Coil 3 (Ohms)	1.257 Corr: 1.2...
Megohm Stat...	PASS
Volts (V)	491
I(μA)	0.0975
Resist	5036
At 40°C	1359
DI Status	No Test
Nameplate	Application
Results	

20. Winding Resistance

1-2

1-3

2-3

Test Time	3:10:04 PM	2:55:01 PM
IR Temp Com...	Thermoplastic	None
Resist Status	PASS	No Test
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.839 Corr: 0.8...	
L2-L3 (Ohms)	0.839 Corr: 0.8...	
L3-L1 (Ohms)	0.839 Corr: 0.8...	
Max Delta R %	0.005	
Coil 1 (Ohms)	1.257 Corr: 1.2...	
Coil 2 (Ohms)	1.257 Corr: 1.2...	
Coil 3 (Ohms)	1.257 Corr: 1.2...	
Megohm Stat...	PASS	No Test
Nameplate	Application	Results Summary

21. Perform Surge Test

(P) Pass

motor needs rewound because of lead condition

Tools	Help
103338	2
Tests	Trending
Test ID: 480V w/oRTT-101HP Step	Edit Test ID
For: 480 Volts	Motor
Run Auto Test	
Temperature/Resistance Tests	
Temperature	Manual
Resistance	3 Lead/Low V
DC Tests	
MegOhm	500 Volts
OFF	500 Volts
Step-Voltage	1500 Volts
Surge Test	1500 Volts

22. Number of Stator Slots

48

23. Stator Condition

Needs cleaned

24. Stator Thermistors/Ohms

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25. Stator Overloads/Ohms	1.7
Mechanical Inspection	
26. Drive End Bearing Brand	NTN
27. Drive End Bearing Number-	6310
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?	
32. Drive End Wavy Washer/Snap-Ring Other Retention Device?	
33. Drive End Bearing Condition	
Frosting	





34. Opposite Drive End Bearing Brand	NTN
35. Opposite Drive End Bearing Number-	6209
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?	
40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	
41. Opposite Drive End Bearing Condition	
Fluting	




42. Drive End Seal	
43. Opposite Drive End Seal	

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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			
48. List the Parts needed for the Repair Below	6310 6209 Leads		
49. Signature of Technician that Disassembled Motor	Cw 		
Mechanical Fits- Rotor			
50. Shaft Runout	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	
1.9686	1.9685	1.9686	
55. Drive End Bearing Shaft Fit Condition	(P) Pass		
56. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
1.7716	1.7717	1.7717	
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	
4.3309	4.331	4.3308	
60. Drive End - Endbell Bearing Fit Condition	(P) Pass		
61. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
3.3475	3.3472	3.3473	
62. Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass		

63. Bearing Cap Condition	Drive End Bearing Cap	Opposite Drive End Bearing Cap
64. End Bell Air Seal Fits	Drive End Air Seal	Opposite Drive End Air Seal
65. List Machine Work Needed Below		
66. Technician	Cw	
		
 Co sign RRW		
Root Cause of Failure		
67. Failure locations	Bearings	
68. Root cause of failure	Fluting and frosting	
Dynamic Balance Report		
69. Rotor Weight and Balance Grade	Rotor Weight	Balance Grade



70. Initial Balance Readings	Drive End	Opposite Drive End
	.25	.49
71. Final Balance Readings	Drive End	Opposite Drive End
	.20	.09
72. Technician	RW	
		
Assembly		

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73. QC Check All Parts for Cleanliness Prior to Assembly

RW

[Handwritten signature]

74. Photograph All Major Components prior to assembly

(Complete) Complete



75. Final Insulation Resistance Test

Megohms

Pass the Hi pot

76. Assembled Shaft Endplay

inches

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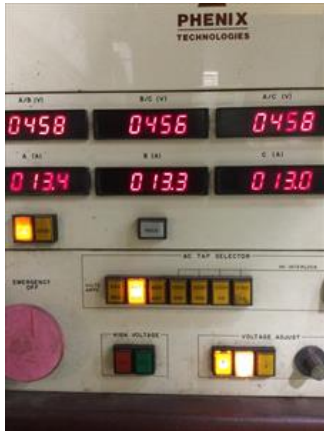
Na		
77. Assembled Shaft Runout		0.0002 inches
78. Test Run Voltage		
Volts	Volts	Volts
459	458	461



Co sign SC

Low speed



79. Test Run Amperage		
Amps	Amps	Amps
5.4	5.3	0.3



High speed

Low speed

80. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
Na		
81. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
Na		
82. Ambient Temperature - Fahrenheit		
Na		

83. Drive End Bearing Temps - Fahrenheit			
5 Minutes		10 Minutes	
15 Minutes			
	Na		
84. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes		10 Minutes	
15 Minutes			
	Na		
85. Document Final Condition with Pictures after paint			



86. Final Pics and QC Review	RW
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A handwritten signature in black ink, appearing to be 'HL' with a long horizontal stroke extending to the right.

Co sign SC



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

AC Random Coil Rewind Report

FolderID: 103338
FormID: 21578082

FUTURE FUEL CHEMICAL
2800 GAP RD HWY 394 SO
BATESVILLE, AR 72501

LR MOTOR SHOP

Priorities Found: ● 3 - High ● 4 - Good

General

1. Job Number 103338
- 2.5 DE coil extension
2.5 ODE coil extension



2. Report Date 09/10/2024
3. Customer Future Fuel

Stator Winding

4. Core Length 6.0625 "
5. Core ID 7.5 "
6. Back Iron Depth 0.9375 "
7. Slot Depth 1.0625 "
8. Tooth Width 0.25 "
9. Number of Vents 0
10. Vent Width "
- 11. Before Burnout Core loss (P) Pass
12. Flux Before Burnout
13. Watts before burnout
14. Watts loss per lb. before burnout 2.27 W/lbs.
15. After Burnout Core Loss
- 2.6
16. Flux After burnout
17. Watts After Burnout
18. Watts loss per lb After Burnout 1.4 W/lbs.
- 19. Core Iron Condition (P) Pass
- 20. RTD's (N) No

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21.	RTD's Reading Klixon 3 in series	Ohm's
22.	Motor Heaters	(N) No
23.	Heater Qty.	
24.	Heater Voltage	Volts
25.	Heater Wattage	
26.	Thermistors	(N) No
27.	Number of Poles 4/8	
28.	Slots	48
29.	Number of Coils	48
30.	Coil Weight	32 Lbs.
31.	Lead Markings 1-6	
32.	Grouping 12g 4c	
33.	Multiple Wires	(Y) Yes
34.	Wire Size 1#19&2#18	
35.	Turns per coil	22
36.	Pitch 1 to:	7
37.	Connection 2y1d	
38.	Lead Length	9.5 "
39.	Lead Size	14
40.	Number of Leads	6
41.	Megger Reading After Rewind Hi 38067. Low. 114973	Mohms
42.	Coil Machine Slot	
43.	Coil Machine Tip	
44.	Coil Machine Pitch	
45.	Hi Pot Reading After Rewind Hi. 0.0844. 0.0637	Ua
46.	Surge Pattern After Rewind	(P) Pass
47.	Service Technician 	RHR
	32lbs. & 12Ft. OF Hi Temp glass Lead wire#16	



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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.
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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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.
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.