



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

LR Motor Shop Repairs

Job Number 103448

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

FolderID: 103448
FormID: 21443583

AC Inspection - Rev. 2

Location: LR MOTOR SHOP

Serial Number: AAP7021KD03A

Description: 3HP GE 1765RPM

Hi-Speed Job Number: 103448

Manufacturer: GE

Serial Number: AAP7021KD03A

HP/kW: 3 (HP)

RPM: 1785 (RPM)

Frame: 11841P10

Voltage: 230 / 460

Current: 8.6/4.3 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.00

Enclosure: TEFC

of Leads: 9

J-box Included: Complete

Coupling/Sheave: None

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: Yes

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

09/03/2024

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Printed on 9/17/2024

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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.	Report Date [COPY]	09/03/2024
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	Inches
	Na	
10.	Assembled Shaft End Play	inches
	Na	
11.	Air Gap Variation <10%	
	Na	
12.	Lead Condition	(P) Pass
13.	Lead Length	10 Inches
14.	Does it have Lugs?, If so what is the Stud Size?	(No) No
15.	Lead Numbers	1-9

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16. Frame Condition

pass



17. Fan Condition

(P) Pass



18. Broken or Missing Components

broken bolt in T-box

Initial Electrical Inspection

19. Insulation Resistance/Megger

0 Megohms

20. Winding Resistance

1-2

1-3

2-3

Na

21. Perform Surge Test

(F) Fail

22. Number of Stator Slots

36



24. Stator Thermistors/Ohms

na

25. Stator Overloads/Ohms

yes

Mechanical Inspection

26. Drive End Bearing Brand

sky

27. Drive End Bearing Number-

5307



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?

na

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

na

33. Drive End Bearing Condition

normal wear



34. Opposite Drive End Bearing Brand	na
35. Opposite Drive End Bearing Number-	6206 C3
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?	na
40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	spacer
41. Opposite Drive End Bearing Condition	normal wear



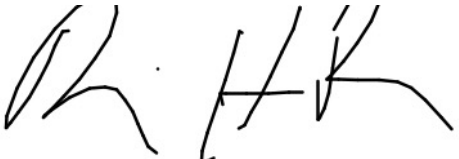
42. Drive End Seal	pass
43. Opposite Drive End Seal	pass

Rotor Inspection

44. Rotor Type/Material

(Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast



45. Growler Test	(Pass) Pass		
46. Number of Rotor Bars	28		
47. Rotor Condition	wash		
48. List the Parts needed for the Repair Below 1-5307 1-6206			
49. Signature of Technician that Disassembled Motor	RHR		
			
Mechanical Fits- Rotor			
50. Shaft Runout	inches		
Na			
51. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
Na			
52. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
Na			
53. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
Na			
54. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
1.3781	1.3781	1.3781	

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55. Drive End Bearing Shaft Fit Condition

(P) Pass



56. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.1812

1.1812

1.1812

57. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass



58. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

pass

pass

Mechanical Fits- Bearing Housings

59. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
3.1515	3.151	3.1517



60. Drive End - Endbell Bearing Fit Condition		(F) Fail
Resleeve		
61. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
2.4436	2.4426	2.4334



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

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
pass	pass

65. List Machine Work Needed Below	
<i>Both end bells</i>	

66. Technician	RHR
	
 <i>Witnessed RRW</i>	

Root Cause of Failure
67. Failure locations
<i>End bell bearings fits and winding</i>
68. Root cause of failure
<i>Water shorted windings</i>

Dynamic Balance Report	
69. Rotor Weight and Balance Grade	
Rotor Weight	Balance Grade
 <i>Na</i>	
70. Initial Balance Readings	
Drive End	Opposite Drive End
 <i>Na</i>	
71. Final Balance Readings	
Drive End	Opposite Drive End
 <i>Na</i>	
72. Technician	
 <i>A</i>	

Rewind

73. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

Na

74. Core Hot Spot Test

Pre-Burnout

Post-Burnout

Na

75. Post Rewind Electrical Test- Insulation Resistance

Megohms

Na

76. Post Rewind Polarization Index

Polarization Index

Na

77. Post Rewind Winding Resistance

1-2

1-3

2-3

Na

78. Post Rewind Surge Test

(Pass) Pass

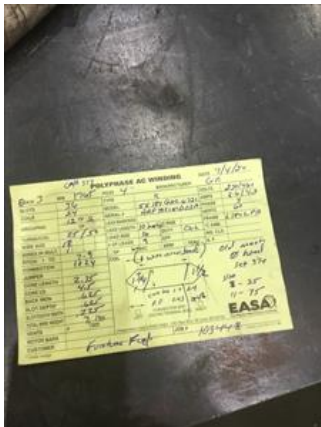
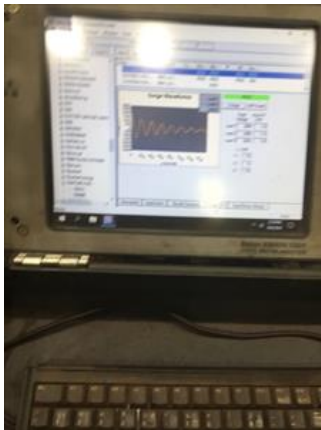
79. Post Rewind Hi-Pot

micro-amps

Na

80. Technician

Na



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Mechanical Fits- Bearing Housings - Post Repair

81. Drive End - Endbell Bearing Fit Post Repair

0 Degrees	60 Degrees	120 Degrees
3.1499	3.1499	3.1499





82. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees	60 Degrees	120 Degrees
2.441	2.441	2.441



83. Bearing Cap Condition Post Repair

Drive End Bearing Cap	Opposite Drive End Bearing Cap
-----------------------	--------------------------------

84. End Bell Air Seal Fits Post Repair		
Drive End Air Seal		Opposite Drive End Air Seal
85. End Bell Repair Sign-off		
		Gary- Robert
		
Assembly		
86. QC Check All Parts for Cleanliness Prior to Assembly		RW
		

87. Photograph All Major Components prior to assembly



88. Final Insulation Resistance Test

Megohms

Passed hi pot

89. Assembled Shaft Endplay

inches

Na

90. Assembled Shaft Runout

0 inches

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91. Test Run Voltage		
Volts	Volts	Volts
455	456	457



Co sign CRW

92. Test Run Amperage		
Amps	Amps	Amps
2	2.1	2



93. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
94. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
95. Ambient Temperature - Fahrenheit		
96. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
97. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
98. Document Final Condition with Pictures after paint		

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99. Final Pics and QC Review

RW

RW

Co sign CRW



Hi-Speed Industrial Service
7030 Ryburn Dr
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AC Random Coil Rewind Report

FolderID: 103448
FormID: 21525615

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

LR MOTOR SHOP

Priorities Found: 2 - High 1 - Good

General	
1. Job Number	103448
2. Report Date	
3. Customer	Furture Fuel
Stator Winding	
4. Core Length	2.75 "
5. Core ID	4.5 "
6. Back Iron Depth	0.625 "
7. Slot Depth	0.625 "
8. Tooth Width	0.225 "
9. Number of Vents	0
10. Vent Width	0 "
11. Before Burnout Core loss	
1.7	
12. Flux Before Burnout	
13. Watts before burnout	
14. Watts loss per lb. before burnout	
15. After Burnout Core Loss	
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	
19. Core Iron Condition	
20. RTD's	
21. RTD's Reading	0 Ohm's
22. Motor Heaters	(N) No
23. Heater Qty.	0
24. Heater Voltage	0 Volts
25. Heater Wattage	0 Watts
26. Thermistors	(N) No
27. Number of Poles	4
28. Slots	36
29. Number of Coils	24
30. Coil Weight	
31. Lead Markings	
1-9	
32. Grouping	
12of2	

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33. Multiple Wires	
34. Wire Size	
1#18	
35. Turns per coil	
1-7 1-9	
25 50	
36. Pitch 1 to:	
1-7 9	
37. Connection	
1 Wye @ 460	
2 Wye @ 230	
38. Lead Length	10 "
39. Lead Size	16
40. Number of Leads	
1-7 9	
25 50	
41. Megger Reading After Rewind	
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	
46. Surge Pattern After Rewind	
47. Service Technician	



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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.
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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

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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.
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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.
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.