

LR Motor Shop Repairs

Job Number 102939

Prepared for FUTURE FUEL CHEMICAL

2800 GAP RD HWY 394 SO BATESVILLE AR 72501

Table of Contents

AC Inspection as Found - MOTOR SHOP LR

AC Inspection - Rev. 2: C0709280042

1.0



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

> FolderID: 102939 FormID: 20391327

AC Inspection as Found FUTURE FUEL CHEMICAL

2800 GAP RD HWY 394 SO BATESVILLE, AR 72501

AC Inspection - Rev. 2

Location: MOTOR SHOP LR Serial Number: C0709280042

Description: 25HP BALDOR UL LISTED

Hi-Speed Job Number:	102939
Manufacturer:	Baldor
Spec/ID #:	I0E25IX350HI
Serial Number:	C0709280042
HP/kW:	25 (HP)
RPM:	1775 (RPM)
Frame:	224TC
Voltage:	230 / 460
Current:	61.1/30.8 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.0
Enclosure:	XP
# of Leads:	9
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	05/15/2024
Bearing RTDs:	No
Repair Stage:	Final
Rewind:	No
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **a** 2 - High

9 - Good

Overall Condition

05/24/2024 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		
		Dirty		
Ir	nitial Mechanical/Electrical			
	5.	Does Shaft Turn Freely?	(Y) Yes	
	6.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No	
	7.	Does Shaft Have Visible Damage?	(No) No	
	8.	Assembled Shaft Runout	Inches	
	-	Na		
	9.	Assembled Shaft End Play	inches	
	-	Na		
	10.	Air Gap Variation <10%		
	-	Na		
	11.	Lead Condition	(P) Pass	
	12.	Lead Length	18 Inches	
	13.	Does it have Lugs?, If so what is the Stud Size?		
		Yes		



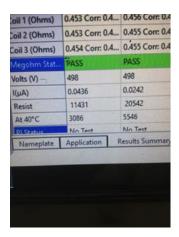
14.	Lead Numbers			1-9
15.	Stator Temperature Detector Rating a	and Function		
	Quantity	Rating	Quantity Passed	
-	Na			
16.	Frame Condition			pass

) 17. Fan Condition (P) Pass

18. Broken or Missing Components fan cover bolt

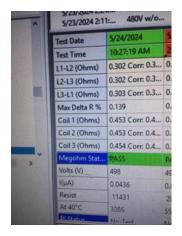
Initial Electrical Inspection

19. Insulation Resistance/Megger Megohms

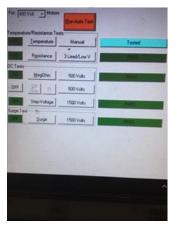


20. Winding Resistance

1-2 1-3 2-3



21. Perform Surge Test



22. Number of Stator Slots 48

(P) Pass

23. Stator Condition pass needs washed

24. Stator Thermistors/Ohms

Na

25. Stator Overloads/Ohms pass 0.4

Mechanical Inspection

26. Drive End Bearing Brand

na



27. Drive End Bearing Number-	6311
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?	spanner nut
33. Drive End Bearing Condition	



34.	Opposite Drive End Bearing Brand	skf
35.	Opposite Drive End Bearing Number-	6309
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?	wavy washer
41.	Opposite Drive End Bearing Condition	



Na

43. Opposite Drive End Seal

Na

Rotor Inspection

	moposition.	
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
4 8.	List the Parts needed for the Repair Below	
	6311 6309 Need 4.5 inch OD and 6inch length brass for sleeving	

 Cw

Mein

49. Signature of Technician that Disassembled Motor

Mechanical Fits- Rotor

Na

50.	Shaft Runout		inches		
-	0.002				
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				
00.	3				

	54.	Drive End Bearing Shaft Fit			
		0 Degrees	60 Degrees	120 Degrees	
		2.1654	2.1654	5.1655	
	55.	Drive End Bearing Shaft Fit Condition			(P) Pass
	56.	Opposite Drive End Bearing Shaft Fit			
		0 Degrees	60 Degrees	120 Degrees	
		1.772	1.7721	1.7721	
	57.	Opposite Drive End Bearing Shaft Fit	Condition		(P) Pass
	58.	Shaft Air Seal Fits			
		Drive End Air Seal	Opposite Drive End Air Seal		
	7	Na			
M	echa	anical Fits- Bearing Housings			
	59.	Drive End - Endbell Bearing Fit			
		0 Degrees	60 Degrees	120 Degrees	
		4.7253	4.7252	4.7252	
	60.	Drive End - Endbell Bearing Fit Condi	tion		(P) Pass
	61.	Opposite Drive End - Endbell Bearing	Fit		
		0 Degrees	60 Degrees	120 Degrees	
	-	Unable to provide proper measurement			
	62.	Opposite Drive End - Endbell Bearing	Fit Condition		(F) Fail
	63.	Bearing Cap Condition			
		Drive End Bearing Cap	Opposite Drive End Bearing Cap		
		Pass			
	-				
	64.		Opposite Drive End Air Seel		
		Drive End Air Seal	Opposite Drive End Air Seal		
	-	Na			
	65.	List Machine Work Needed Below			
		ODE end bell bearing fit			
	66.	Technician			Cw
		· / / ·			
		(Muy	/		
		(//			
R		Cause of Failure			
	67.	Failure locations			
		Bearings			
	68.	Root cause of failure			
		Contamination and fluting			
D	-	nic 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	
	2.110 2.10		
71.	Final Balance Readings		
	Drive End	Opposite Drive End	
	Technician		
	anical Fits- Rotor - Post Repair		
	Shaft Runout Post Repair		
74.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
75	Coupling Fit Closest to Bearing Hous	ing Poet Repair	
70.	0 Degrees	90 Degrees	120 Degrees
	0 Degrees	30 Degrees	120 Degrees
76.	Coupling Fit Closest to the end of the	Shaft Post Repair	
	0 Degrees	60 Degrees	120 Degrees
	Ţ	Ţ	_
77.	Drive End Bearing Shaft Fit Post Rep	air	
	0 Degrees	60 Degrees	120 Degrees
70	Opposite Drive End Decring Chaft Fit	Doct Donois	
70.	Opposite Drive End Bearing Shaft Fit		120 Dograda
	0 Degrees	60 Degrees	120 Degrees
79.	Shaft Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
	Shaft Repair Sign-off		
Mecha	anical Fits- Bearing Housings - P	•	
Mecha	anical Fits- Bearing Housings - P Drive End - Endbell Bearing Fit Post I	Repair	
Mecha	anical Fits- Bearing Housings - P	•	120 Degrees
Mecha 81.	anical Fits- Bearing Housings - F Drive End - Endbell Bearing Fit Post I 0 Degrees	Repair 60 Degrees	120 Degrees
Mecha 81.	anical Fits- Bearing Housings - Porive End - Endbell Bearing Fit Post In O Degrees Opposite Drive End - Endbell Bearing	Repair 60 Degrees Fit Post Repair	_
Mecha 81.	anical Fits- Bearing Housings - F Drive End - Endbell Bearing Fit Post I 0 Degrees	Repair 60 Degrees	120 Degrees 120 Degrees
81. 82.	anical Fits- Bearing Housings - Porive End - Endbell Bearing Fit Post In O Degrees Opposite Drive End - Endbell Bearing	Repair 60 Degrees Fit Post Repair	_
81. 82.	anical Fits- Bearing Housings - P Drive End - Endbell Bearing Fit Post I 0 Degrees Opposite Drive End - Endbell Bearing 0 Degrees	Repair 60 Degrees Fit Post Repair	_
81. 82. 83.	anical Fits- Bearing Housings - P Drive End - Endbell Bearing Fit Post I 0 Degrees Opposite Drive End - Endbell Bearing 0 Degrees Bearing Cap Condition Post Repair Drive End Bearing Cap	Repair 60 Degrees Fit Post Repair 60 Degrees	_
81. 82. 83.	anical Fits- Bearing Housings - P Drive End - Endbell Bearing Fit Post I 0 Degrees Opposite Drive End - Endbell Bearing 0 Degrees Bearing Cap Condition Post Repair Drive End Bearing Cap End Bell Air Seal Fits Post Repair	Repair 60 Degrees Fit Post Repair 60 Degrees Opposite Drive End Bearing Cap	_
81. 82. 83.	anical Fits- Bearing Housings - P Drive End - Endbell Bearing Fit Post I 0 Degrees Opposite Drive End - Endbell Bearing 0 Degrees Bearing Cap Condition Post Repair Drive End Bearing Cap	Repair 60 Degrees Fit Post Repair 60 Degrees	_
81. 82. 83.	Drive End - Endbell Bearing O Degrees Opposite Drive End - Endbell Bearing O Degrees Bearing Cap Condition Post Repair Drive End Bearing Cap End Bell Air Seal Fits Post Repair Drive End Air Seal	Repair 60 Degrees Fit Post Repair 60 Degrees Opposite Drive End Bearing Cap	_
81. 82. 83. 84.	anical Fits- Bearing Housings - P Drive End - Endbell Bearing Fit Post I 0 Degrees Opposite Drive End - Endbell Bearing 0 Degrees Bearing Cap Condition Post Repair Drive End Bearing Cap End Bell Air Seal Fits Post Repair Drive End Air Seal End Bell Repair Sign-off	Repair 60 Degrees Fit Post Repair 60 Degrees Opposite Drive End Bearing Cap	_
81. 82. 83. 84. 85.	Drive End - Endbell Bearing O Degrees Opposite Drive End - Endbell Bearing O Degrees Bearing Cap Condition Post Repair Drive End Bearing Cap End Bell Air Seal Fits Post Repair Drive End Air Seal End Bell Repair Sign-off	Repair 60 Degrees Fit Post Repair 60 Degrees Opposite Drive End Bearing Cap Opposite Drive End Air Seal	_
81. 82. 83. 84. 85.	Drive End - Endbell Bearing O Degrees Opposite Drive End - Endbell Bearing O Degrees Bearing Cap Condition Post Repair Drive End Bearing Cap End Bell Air Seal Fits Post Repair Drive End Air Seal End Bell Repair Sign-off mbly QC Check All Parts for Cleanliness P	Repair 60 Degrees Fit Post Repair 60 Degrees Opposite Drive End Bearing Cap Opposite Drive End Air Seal	_
81. 82. 83. 84. 85. Assen	Drive End - Endbell Bearing Opposite Drive End Fits Post Repair Drive End Bell Air Seal Fits Post Repair Oprive End Air Seal End Bell Repair Sign-off Opposite Drive End Fits Post Repair Opposite Drive End - Endbell Bearing Opposite Drive	Repair 60 Degrees Fit Post Repair 60 Degrees Opposite Drive End Bearing Cap Opposite Drive End Air Seal	_
81. 82. 83. 84. 85. Assen 86. 87.	Drive End - Endbell Bearing O Degrees Opposite Drive End - Endbell Bearing O Degrees Bearing Cap Condition Post Repair Drive End Bearing Cap End Bell Air Seal Fits Post Repair Drive End Air Seal End Bell Repair Sign-off mbly QC Check All Parts for Cleanliness P Photograph All Major Components pr	Repair 60 Degrees Fit Post Repair 60 Degrees Opposite Drive End Bearing Cap Opposite Drive End Air Seal	_

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91.	Test Run Voltage		
	Volts	Volts	Volts
92.	Test Run Amperage		
	Amps	Amps	Amps
93.	Drive End Vibration Readings - Inches	Per Second	
	Horizontal	Vertical	Axial
94.	Opposite Drive End Vibration Reading	s - Inches Per Second	
	Horizontal	Vertical	Axial
95.	Ambient Temperature - Fahrenheit		
96.	Drive End Bearing Temps - Fahrenhei	t	
	5 Minutes	10 Minutes	15 Minutes
97.	Opposite Drive End Bearing Temps - I	ahrenheit	
	5 Minutes	10 Minutes	15 Minutes
98.	Document Final Condition with Picture	es after paint	
99.	Final Pics and QC Review		

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- 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.
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- 5. <u>DELIVERY OF GOODS AND/OR SERVICES.</u> 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.
- **DELIVERY SITE AND TIME FOR PERFORMANCE.** Hi-Speed and Buver 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. <u>SEVERABILITY.</u> 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, earth quake, 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. <u>NONWAIVER.</u> 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.
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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.