



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

LR Motor Shop Repairs

Job Number 103093

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: 103093
FormID: 20688967

AC Inspection - Rev. 2

Location: MOTOR SHOP LR
Serial Number: NO NAMEPLATE
Description: 25HP-NO NAMEPLATE

Hi-Speed Job Number:	103093
Spec/ID #:	UL LISTED
HP/kW:	25 (HP)
RPM:	1800 (RPM)
Voltage:	460
Phase:	Three
Hz:	60 (Hz)
Enclosure:	TEFC
# of Leads:	6
J-box Included:	Complete
Date Received:	06/13/2024
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	Yes
Shaft Machined Fit Repairs Required:	Yes
Bearing Housing Machined Fit Repairs Required:	Yes
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 5 - High ● 7 - Good

Overall Condition

- | | |
|----------------------|------------|
| 1. Report Date | 06/26/2024 |
| 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.	Distance from the end of the shaft to the Coupling/Sheave	0 inches
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 Inches
10.	Assembled Shaft End Play	0 inches
11.	Air Gap Variation <10%	none
12.	Lead Condition	(P) Pass
13.	Lead Length	12 Inches
14.	Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
	<i>1/4 stud</i>	
15.	Lead Numbers	1-6
16.	Frame Condition	good
17.	Fan Condition	(P) Pass
	<i>Slightly damaged but reusable</i>	
18.	Broken or Missing Components	none
Initial Electrical Inspection		
19.	Insulation Resistance/Megger	0 Megohms

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20. Winding Resistance			
1-2	1-3	2-3	
0	0	0	
21. Perform Surge Test			(F) Fail
22. Number of Stator Slots			36
23. Stator Condition			rewind
24. Stator Thermistors/Ohms			none
25. Stator Overloads/Ohms			.1
Mechanical Inspection			
26. Drive End Bearing Brand			




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



Incompatible grease

31. Drive End Bearing Insulation or Grounding Device?	none
32. Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
33. Drive End Bearing Condition	excessive wear
34. Opposite Drive End Bearing Brand	na
35. Opposite Drive End Bearing Number-	6211
36. Opposite Drive End Bearing Qty.	1

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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?	wavy
41. Opposite Drive End Bearing Condition	normal wear
42. Drive End Seal	na
Customer will provide	
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	46
47. Rotor Condition	good
48. List the Parts needed for the Repair Below 6211 6311 rewind	
49. Signature of Technician that Disassembled Motor	David Maclin
	
Mechanical Fits- Rotor	
50. Shaft Runout	0 inches
51. Rotor Runout	
Drive End Bearing Fit	Rotor Body
0	0
0	0
52. Coupling Fit Closest to Bearing Housing	
0 Degrees	90 Degrees
0	0
0	0
53. Coupling Fit Closest to the end of the Shaft	
0 Degrees	60 Degrees
0	0
0	0
54. Drive End Bearing Shaft Fit	
0 Degrees	60 Degrees
2.1645	2.164
2.1643	2.1643
55. Drive End Bearing Shaft Fit Condition	(F) Fail
56. Opposite Drive End Bearing Shaft Fit	
0 Degrees	60 Degrees
2.1656	2.1658
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
fail	fail
Weld and machine both air fits for XP specs	
Mechanical Fits- Bearing Housings	

59. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
4.7246	2.7246	2.7246
60. Drive End - Endbell Bearing Fit Condition		(P) Pass
61. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
3.939	3.939	3.939
62. Opposite Drive End - Endbell Bearing Fit Condition		(F) Fail
63. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
fail	fail	
Sleeve both air seal fits to XP specs		
64. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
ok	ok	
65. List Machine Work Needed Below		
Sleeve both bearing cap air fits, sleeve ODE bearing fit, weld and machine both shaft bearing cap air fits AND DE bearing fit.		
66. Technician		David Maclin



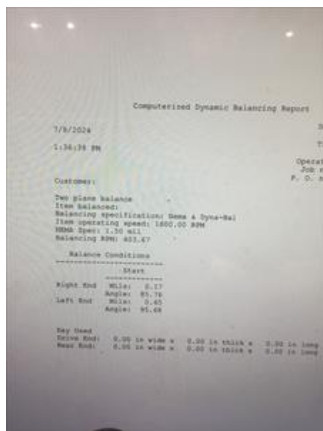
Root Cause of Failure



67. Failure locations
Bearings, fits, windings
68. Root cause of failure
Contaminated lubrication

Dynamic Balance Report

69. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade
0	0



70. Initial Balance Readings			
Drive End		Opposite Drive End	
.17		.65	
71. Final Balance Readings			
Drive End		Opposite Drive End	
.17		.65	
72. Technician			David Maclin
			
Rewind			
73. Core Test Results - Watts loss per Pound			
Pre-Burnout		Post Burnout	
na		na	
74. Core Hot Spot Test			
Pre-Burnout		Post-Burnout	
na		na	
75. Post Rewind Electrical Test- Insulation Resistance			2000 Megohms
76. Post Rewind Polarization Index			0 Polarization Index
77. Post Rewind Winding Resistance			
1-2	1-3	2-3	
0	0	0	
78. Post Rewind Surge Test			(Pass) Pass
79. Post Rewind Hi-Pot			0 micro-amps
80. Technician			David Maclin
			
Mechanical Fits- Rotor - Post Repair			
81. Shaft Runout Post Repair			inches
82. Rotor Runout Post Repair			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
83. Coupling Fit Closest to Bearing Housing Post Repair			
0 Degrees	90 Degrees	120 Degrees	

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

0 Degrees

60 Degrees

120 Degrees



Repaired broken fan.
Gary

85. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

2.166

2.166

2.166



86. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

87. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

2.4955

2.4834

88. Shaft Repair Sign-off

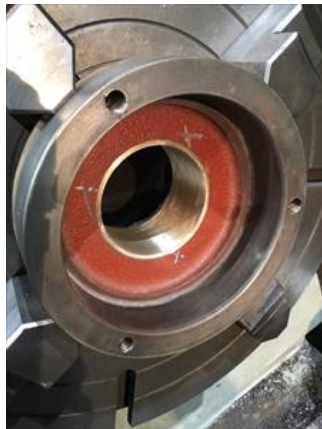
RW

Mechanical Fits- Bearing Housings - Post Repair


89. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
90. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
3.9375	3.9375	3.9375



91. Bearing Cap Condition Post Repair	
Drive End Bearing Cap	Opposite Drive End Bearing Cap
2.5130	2.5131



92. End Bell Air Seal Fits Post Repair	
Drive End Air Seal	Opposite Drive End Air Seal

93. End Bell Repair Sign-off	RW
	
Assembly	

94. QC Check All Parts for Cleanliness Prior to Assembly

David Maclin



95. Photograph All Major Components prior to assembly



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1.11





96. Final Insulation Resistance Test	2000 Megohms	
97. Assembled Shaft Endplay	0 inches	
98. Assembled Shaft Runout	0 inches	
99. Test Run Voltage		
Volts	Volts	Volts
460	460	462
Witnessed by Robert Wiley		




High speed



Low speed

100. Test Run Amperage

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Amps	Amps	Amps
8.1	7.7	7.8
101. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.0365	0.0582	0.0114
102. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.0344	0.0512	0.0209
103. Ambient Temperature - Fahrenheit		75
104. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
0	0	0
105. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
0	0	0
106. Document Final Condition with Pictures after paint		looks good
 <i>Witnessed by Chris Wiley</i>		





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

AC Random Coil Rewind Report

FolderID: 103093
FormID: 20842085

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

MOTOR SHOP LR

Priorities Found: 1 - High 4 - Good

General	
1. Job Number	103093
2. Report Date	
3. Customer	Future Fuel
Stator Winding	
4. Core Length	6 "
5. Core ID	7.5 "
6. Back Iron Depth	1 "
7. Slot Depth	1 "
8. Tooth Width	0.522 "
9. Number of Vents	0
10. Vent Width	0 "
11. Before Burnout Core loss	(P) Pass
12. Flux Before Burnout	
13. Watts before burnout	
14. Watts loss per lb. before burnout	
15. After Burnout Core Loss	(P) Pass
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	
19. Core Iron Condition	(P) Pass
20. RTD's	(Y) Yes
Has overload	
21. RTD's Reading	0 Ohm's
22. Motor Heaters	(N) No
23. Heater Qty.	0
24. Heater Voltage	0 Volts
25. Heater Wattage	
26. Thermistors	
27. Number of Poles	48
28. Slots	36
29. Number of Coils	
30. Coil Weight	Lbs.
31. Lead Markings	
32. Grouping	
33. Multiple Wires	
34. Wire Size	

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35. Turns per coil	
36. Pitch 1 to:	
37. Connection	
38. Lead Length	
39. Lead Size	14
40. Number of Leads	6



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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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.
3. **SCOPE OF GOODS AND/OR SERVICES.** The goods and/or services provided by Hi-Speed pursuant to any quotation shall be limited exclusively to those goods and/or services expressly identified therein. Hi-Speed does not assume any responsibility and/or liability for the failure to provide any other goods and/or services not identified in any quotation. Modifications, additions or deletions to or from the scope referenced in any quotation shall only be effective if evidenced in writing and signed by Hi-Speed. The sale of any of all goods and/or services affected by such modification, addition or deletion shall be subject to these same Standard Terms and Conditions whether or not referenced therein.
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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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.
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.
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