



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

LR Motor Shop Repairs

Job Number 102524

Prepared for Georges Inc

1810 S. St. Louis Street
Batesville AR 72501

Table of Contents



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

AC Inspection as Found

Georges Inc
1810 S. St. Louis Street
Batesville, AR 72501

FolderID: 102524
FormID: 19473579

AC Inspection - Rev. 2

Location: Shop

Serial Number: Cannot read

Description: Chiller motor

Hi-Speed Job Number: 102524

Repair Stage: Final

Priorities Found: ● 6 - High ● 10 - Good

Overall Condition

1. Report Date

● 2. Nameplate Picture

■ Unreadable



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	inches
	<i>Na</i>	
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	
	<i>Yes</i>	
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	0.003 Inches
10.	Assembled Shaft End Play	inches
	<i>Na</i>	
11.	Air Gap Variation <10%	
	<i>Na</i>	
12.	Lead Condition	(P) Pass
13.	Lead Length	14 Inches
14.	Does it have Lugs?, If so what is the Stud Size?	(No) No
15.	Lead Numbers	1-9
16.	Stator Temperature Detector Rating and Function	
	Quantity	Rating
		Quantity Passed
	<i>Na</i>	
17.	Bearing Temperature Detector Rating and Function	
	Quantity	Rating
		Quantity Passed
	<i>Na</i>	
18.	Frame Condition	pass

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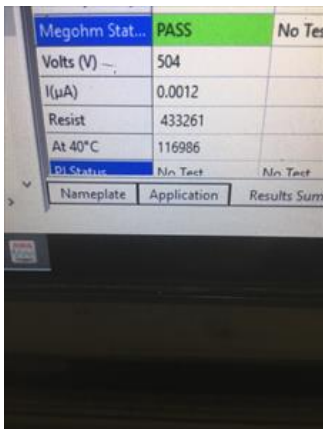
20. Heater Quantity, Ratings

Quantity	Volts/Watts	Pass/Fail
Na		
21. Broken or Missing Components		
A fan cover bolt is broke in end bell		

Initial Electrical Inspection

22. Insulation Resistance/Megger

Megohms



23. Winding Resistance

1-2

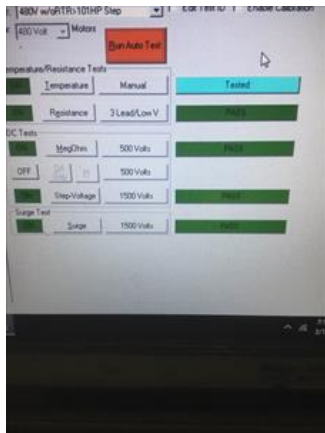
1-3

2-3

IR Temp Com...	Thermoplastic	Thermoplastic	Na
Resist Status	PASS	USER ABORT	No
Bal L1 (Ohms)			
Bal L2 (Ohms)			
Bal L3 (Ohms)			
L1-L2 (Ohms)	0.170 Corr: 0.1...	0.000 Corr: 0.0...	
L2-L3 (Ohms)	0.169 Corr: 0.1...	0.0 Corr: 0.0	
L3-L1 (Ohms)	0.172 Corr: 0.1...	0.0 Corr: 0.0	
Max Delta R %	1.433	0.000	
Coil 1 (Ohms)	0.255 Corr: 0.2...	0.000 Corr: 0.0...	
Coil 2 (Ohms)	0.252 Corr: 0.2...	0.0 Corr: 0.0	
Coil 3 (Ohms)	0.260 Corr: 0.2...	0.0 Corr: 0.0	
FF Protective Cov...	OK	Min Test	Min Test
Homeplate	Application	Results Summary	Surge

24. Perform Surge Test

(P) Pass



25. Number of Stator Slots

36

26. Stator Condition

pass

27. Stator Thermistors/Ohms

Na

28. Stator Overloads/Ohms

Na

Mechanical Inspection

29. Drive End Bearing Brand

Na



30. Drive End Bearing Number-	6312
31. Drive End Bearing Qty.	1
32. Drive End Bearing Type	(Ball) Ball Bearing
33. Drive End Lubrication Type	(Grease) Grease Lubricated
34. Drive End Bearing Insulation or Grounding Device?	na
35. Drive End Wavy Washer/Snap-Ring Other Retention Device?	spanner nut
36. Drive End Bearing Condition	
Signs of contamination and frosting	



37. Opposite Drive End Bearing Brand



38. Opposite Drive End Bearing Number-	6309
39. Opposite Drive End Bearing Qty.	1
40. Opposite Drive End Bearing Type	(Ball) Ball Bearing
41. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
42. Opposite Drive End Bearing Insulation or Grounding Device?	na
43. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	na
44. Opposite Drive End Bearing Condition	
<div> <div></div> <i>Signs of contamination and frosting</i> </div>	



45. Drive End Seal	
<div> <div></div> <i>Na</i> </div>	
46. Opposite Drive End Seal	
<div> <div></div> <i>Na</i> </div>	
47. DE Sleeve Bearing Inside Diameter	
0 degrees	120 degrees 240 degrees
<div> <div></div> <i>Na</i> </div>	
48. DE Sleeve Bearing Outside Diameter	
0 degrees	120 degrees 240 degrees
<div> <div></div> <i>Na</i> </div>	

49. DE Sleeve Bearing Housing Inside Diameter		
0 degrees	120 degrees	240 degrees
Na		
50. DE Sleeve Bearing to Housing Clearance		
0 degrees	120 degrees	240 degrees
Na		
51. ODE Sleeve Bearing Inside Diameter		
0 degrees	120 degrees	240 degrees
Na		
52. ODE Sleeve Bearing Outside Diameter		
0 degrees	120 degrees	240 degrees
Na		
53. ODE Sleeve Bearing Housing Inside Diameter		
0 degrees	120 degrees	240 degrees
Na		
54. ODE Sleeve Bearing to Housing Clearance		
0 degrees	120 degrees	240 degrees
Na		
Rotor Inspection		
55. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast	
56. Growler Test	(Pass) Pass	
57. Number of Rotor Bars	40	
58. Rotor Condition	Pass	



59. List the Parts needed for the Repair Below

6312
6309
Sleeve for ODE end bell bearing fit
Aegis ring- 2.3037

60. Signature of Technician that Disassembled Motor

Cw


Mechanical Fits- Rotor61. Shaft Runout **0.002 inches**

62. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

Na

63. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

Na

64. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

Na

65. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.3624**2.3623****2.3624**66. Drive End Bearing Shaft Fit Condition **(P) Pass**

67. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.7715**1.7716****1.7715**68. Opposite Drive End Bearing Shaft Fit Condition **(P) Pass**

69. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

Mechanical Fits- Bearing Housings

70. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

5.1188**5.1188****5.1189**71. Drive End - Endbell Bearing Fit Condition **(P) Pass**

72. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

3.9382**3.9385****3.9381**73. Opposite Drive End - Endbell Bearing Fit Condition **(F) Fail**

74. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
<div> <div></div> <div>Pass</div> </div>		
		
75. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
<div> <div></div> <div>Na</div> </div>		
<div> <div></div> <div>76. List Machine Work Needed Below</div> <div>ODE end bell bearing fit</div> </div>		
77. Technician		Cw
		
Root Cause of Failure		
78. Failure locations		
Bearings and ODE end bell bearing fit		
79. Root cause of failure		
Frosting and contamination in bearings Wear in ODE end bell bearing fit		
Dynamic Balance Report		
80. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
81. Initial Balance Readings		
Drive End	Opposite Drive End	
82. Final Balance Readings		
Drive End	Opposite Drive End	
83. Technician		
Rewind		
84. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	

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85. Core Hot Spot Test			
Pre-Burnout	Post-Burnout		
86. Post Rewind Electrical Test- Insulation Resistance			
87. Post Rewind Polarization Index			
88. Post Rewind Winding Resistance			
1-2	1-3	2-3	
89. Post Rewind Surge Test			
90. Post Rewind Hi-Pot			
91. Technician			
Mechanical Fits- Rotor - Post Repair			
92. Shaft Runout Post Repair			
93. Rotor Runout Post Repair			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
94. Coupling Fit Closest to Bearing Housing Post Repair			
0 Degrees	90 Degrees	120 Degrees	
95. Coupling Fit Closest to the end of the Shaft Post Repair			
0 Degrees	60 Degrees	120 Degrees	
96. Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
97. Opposite Drive End Bearing Shaft Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
98. Shaft Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
99. Shaft Repair Sign-off			
Mechanical Fits- Bearing Housings - Post Repair			
100. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
101. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
102. Bearing Cap Condition Post Repair			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
103. End Bell Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
104. DE Sleeve Bearing Inside ID Post Repair			
Measure 1	Measure 2	Measure 3	

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105. DE Sleeve Bearing Outside ID Post Repair		
Measure 1	Measure 2	Measure 3
106. DE Sleeve Bearing Inside OD Post Repair		
Measure 1	Measure 2	Measure 3
107. DE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
108. End Bell Repair Sign-off		
109. ODE Sleeve Bearing Inside ID Post Repair		
Measure 1	Measure 2	Measure 3
110. ODE Sleeve Bearing Outside ID Post Repair		
Measure 1	Measure 2	Measure 3
111. ODE Sleeve Bearing Inside OD Post Repair		
Measure 1	Measure 2	Measure 3
112. ODE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
Assembly		
113. QC Check All Parts for Cleanliness Prior to Assembly		
114. Photograph All Major Components prior to assembly		
115. Final Insulation Resistance Test		
116. Assembled Shaft Endplay		
117. Assembled Shaft Runout		
118. Test Run Voltage		
Volts	Volts	Volts
119. Test Run Amperage		
Amps	Amps	Amps
120. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
121. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
122. Ambient Temperature - Fahrenheit		
123. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
124. Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes

125. Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
126. Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
127. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
128. Opposite Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
129. Opposite Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
130. Opposite Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
131. Stator Temperatures- Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
132. Stator Temperatures- Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
133. Stator Temperatures- Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
134. Stator Temperatures- Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
135. Document Final Condition with Pictures after paint		
136. Final Pics and QC Review		



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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.
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. **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.
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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.
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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.