



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

LR Motor Shop Repairs

**Job Number 102905**

Prepared for Kroger

20820 interstate 30 N  
Benton AR 72019

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AC Inspection as Found - *Motor Shop*

AC Inspection - Rev. 2: 32-12-200A

1.0

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

## AC Inspection as Found

Kroger

20820 interstate 30 N  
Benton, AR 72019

FolderID: 102905  
FormID: 20326512

### AC Inspection - Rev. 2

Location: Motor Shop

Serial Number: 32-12-200A

Description: 6HP ILG IND

Hi-Speed Job Number: 102905

Manufacturer: Other

Serial Number: 32-12-200A

HP/kW: 6 (HP)

RPM: 855 (RPM)

Frame: 32

Voltage: Other

Phase: Three

Enclosure: TENV

# of Leads: 3

J-box Included: None

Coupling/Sheave: None

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 ● 4 - Good

### Overall Condition

- |                      |            |
|----------------------|------------|
| 1. Report Date       | 05/20/2024 |
| 2. Nameplate Picture |            |



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3. Photos of all six sides of the machine.





4. Describe the Overall Condition of the Equipment as Received

*Serviceable*

### Initial Mechanical/Electrical

5. Does Shaft Turn Freely?	(N) No
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?	(No) No
14. Lead Numbers	none
15. Frame Condition	pass
16. Fan Condition	(N) NA
17. Broken or Missing Components	none

### Initial Electrical Inspection

18.	Insulation Resistance/Megger	0 Megohms	
19.	Winding Resistance		
	1-2	1-3	2-3
	Na		
20.	Perform Surge Test	(F) Fail	
21.	Number of Stator Slots	54	
22.	Stator Condition	rewind and core repair	
23.	Stator Thermistors/Ohms		
	Na		
24.	Stator Overloads/Ohms		
	Na		

### Mechanical Inspection

25. Drive End Bearing Brand	Fag
26. Drive End Bearing Number-	6208ZZ

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27. Drive End Bearing Qty.	1
28. Drive End Bearing Type	(Ball) Ball Bearing
29. Drive End Lubrication Type	(Grease) Grease Lubricated
30. Drive End Bearing Insulation or Grounding Device?	na
31. Drive End Wavy Washer/Snap-Ring Other Retention Device?	na
32. Drive End Bearing Condition	normal wear



33. Opposite Drive End Bearing Brand	NTN
34. Opposite Drive End Bearing Number-	63206ZZC3



35. Opposite Drive End Bearing Qty.	1
36. Opposite Drive End Bearing Type	(Ball) Ball Bearing
37. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
38. Opposite Drive End Bearing Insulation or Grounding Device?	na
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer



40. Opposite Drive End Bearing Condition



41. Drive End Seal	na
42. Opposite Drive End Seal	na

**Rotor Inspection**

43. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
44. Growler Test	(Pass) Pass
45. Number of Rotor Bars	66



46. Rotor Condition	dirty
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47. List the Parts needed for the Repair Below

6208ZZ 63206ZZ

48. Signature of Technician that Disassembled Motor

RW



#### Mechanical Fits- Rotor

49. Shaft Runout

0.001 inches

50. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

Na

51. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

Na

52. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

Na

53. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.5752

1.5752

1.5752



54. Drive End Bearing Shaft Fit Condition

(P) Pass

55. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
1.1809	1.1809	1.1809



56. Opposite Drive End Bearing Shaft Fit Condition	(F) Fail
57. Shaft Air Seal Fits	
Drive End Air Seal	Opposite Drive End Air Seal
Na	

Mechanical Fits- Bearing Housings


58. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
3.1506	3.1506	3.1506



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

60. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
2.4448	2.4448	2.4448



61.	Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail
	Resleeve	
62.	Bearing Cap Condition	
	Drive End Bearing Cap	Opposite Drive End Bearing Cap
	Na	
63.	End Bell Air Seal Fits	
	Drive End Air Seal	Opposite Drive End Air Seal
	Na	
64.	List Machine Work Needed Below	
	Both end bell bearing fits are bad and the ode shaft bearing fit bad	
65.	Technician	RW
		
	Co witness TRH	
Root Cause of Failure		
66.	Failure locations	
	Both end bell bearing fits are bad ode shaft bearing fit bad	

67. Root cause of failure

*Bearing fits went down and rotor drag the iron causing the winding to short out*



### Dynamic Balance Report

68. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

69. Initial Balance Readings

Drive End

Opposite Drive End

70. Final Balance Readings

Drive End

Opposite Drive End

71. Technician

### Rewind

72. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

73. Core Hot Spot Test

Pre-Burnout

Post-Burnout

74. Post Rewind Electrical Test- Insulation Resistance

75. Post Rewind Polarization Index

76. Post Rewind Winding Resistance

1-2

1-3

2-3

77. Post Rewind Surge Test

78. Post Rewind Hi-Pot

79. Technician

### Mechanical Fits- Rotor - Post Repair

80. Shaft Runout Post Repair

81. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

82. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

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83. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
84. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
85. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
86. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
87. Shaft Repair Sign-off		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
88. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
89. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
90. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
91. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
92. End Bell Repair Sign-off		
<b>Assembly</b>		
93. QC Check All Parts for Cleanliness Prior to Assembly		
94. Photograph All Major Components prior to assembly		
95. Final Insulation Resistance Test		
96. Assembled Shaft Endplay		
97. Assembled Shaft Runout		
98. Test Run Voltage		
Volts	Volts	Volts
99. Test Run Amperage		
Amps	Amps	Amps
100. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
101. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
102. Ambient Temperature - Fahrenheit		
103. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes

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104. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes		10 Minutes	15 Minutes
105. Document Final Condition with Pictures after paint			
106. Final Pics and QC Review			



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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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