



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

LR Motor Shop Repairs

Job Number 103382

Prepared for Peco Foods

625 S. Allen Street
Batesville AR 72501

Table of Contents

AC Inspection as Found - *Shop*

AC Inspection - Rev. 2: *BN 10380291 001*

1.0

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Printed on 8/29/2024

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Hi-Speed Industrial Service
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AC Inspection as Found

Peco Foods

625 S. Allen Street
Batesville, AR 72501

FolderID: 103382
FormID: 21311575

AC Inspection - Rev. 2

Location: Shop

Serial Number: BN 10380291 001

Description: 12.6KW GARDNER
DENVER/SIEMENS MOTOR AND VACUUM
PUMP EVAL

Hi-Speed Job Number: 103382

Manufacturer: Siemens

Serial Number: BN 10380291 001

HP/kW: 12.6 (kW)

RPM: 1765 (RPM)

Voltage: 220-240

Current: 44.0

Phase: Three

Hz: 60 (Hz)

Enclosure: TEFC

of Leads: 9

J-box Included: None

Date Received: 08/15/2024

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: No

Shaft Machined Fit Repairs
Required: Yes

Bearing Housing Machined
Fit Repairs Required: No

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 2 - High ● 9 - Good

Overall Condition

1. Report Date

08/29/2024

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1.0

2. Nameplate Picture



3. Photos of all six sides of the machine.







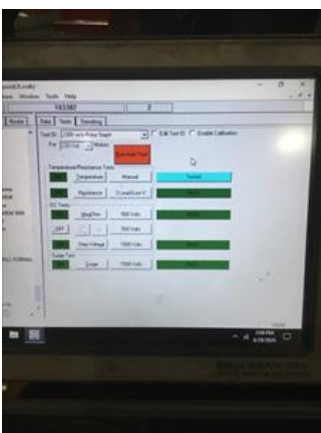
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4. Describe the Overall Condition of the Equipment as Received	
<i>Dirty</i>	
5. Distance from the end of the shaft to the Coupling/Sheave	0 inches
6. Report Date [COPY]	08/29/2024
Initial Mechanical/Electrical	
7. Does Shaft Turn Freely?	(Y) Yes
8. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
9. Does Shaft Have Visible Damage?	(No) No
10. Assembled Shaft Runout	0 Inches
11. Assembled Shaft End Play	0 inches
12. Air Gap Variation <10%	none
13. Lead Condition	(P) Pass
14. Lead Length	6 Inches
15. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
16. Lead Numbers	1-9
17. Frame Condition	ok
18. Fan Condition	(P) Pass
19. Broken or Missing Components	none
Initial Electrical Inspection	
20. Insulation Resistance/Megger	4580 Megohms



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21. Winding Resistance		
1-2	1-3	2-3
.4544	.4544	.4544
22. Perform Surge Test		(P) Pass
23. Number of Stator Slots		36
24. Stator Condition		good
25. Stator Thermistors/Ohms		none
26. Stator Overloads/Ohms		none
Mechanical Inspection		
27. Drive End Bearing Brand		ORS



28. Drive End Bearing Number-	6211
29. Drive End Bearing Qty.	1
30. Drive End Bearing Type	(Ball) Ball Bearing
31. Drive End Lubrication Type	(Grease) Grease Lubricated
32. Drive End Bearing Insulation or Grounding Device?	none
33. Drive End Wavy Washer/Snap-Ring Other Retention Device?	shims
34. Drive End Bearing Condition	normal
35. Opposite Drive End Bearing Brand	ORS
36. Opposite Drive End Bearing Number-	6208
37. Opposite Drive End Bearing Qty.	1
38. Opposite Drive End Bearing Type	(Ball) Ball Bearing
39. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
40. Opposite Drive End Bearing Insulation or Grounding Device?	none
41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy
42. Opposite Drive End Bearing Condition	normal
43. Drive End Seal	52mm* 73mm mechanical seal
44. Opposite Drive End Seal	na

Rotor Inspection

45. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
46. Growler Test	(Pass) Pass
47. Number of Rotor Bars	26
48. Rotor Condition	good
49. List the Parts needed for the Repair Below	
	6211 6208 52mm * 73mm mech seal

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50. Signature of Technician that Disassembled Motor

David Maclin


Mechanical Fits- Rotor51. Shaft Runout **0 inches**

52. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0**0****0**

53. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

0

54. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

0

55. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.1657**2.1657****2.1657**56. Drive End Bearing Shaft Fit Condition **(P) Pass**

57. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.5751**1.5751****1.5751**58. Opposite Drive End Bearing Shaft Fit Condition **(P) Pass**

59. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

ok**ok****Mechanical Fits- Bearing Housings**

60. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

3.9375**3.9374****3.9374**61. Drive End - Endbell Bearing Fit Condition **(P) Pass**

62. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

3.15**3.15****3.15**63. Opposite Drive End - Endbell Bearing Fit Condition **(P) Pass**

64. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

ok**ok**

65. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

ok**ok**

66. List Machine Work Needed Below

Weld and machine shaft seal fit


Root Cause of Failure

68. Failure locations

Seal

69. Root cause of failure

*Unknown***Dynamic Balance Report**

70. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

71. Initial Balance Readings

Drive End

Opposite Drive End

72. Final Balance Readings

Drive End

Opposite Drive End

73. Technician

Mechanical Fits- Rotor - Post Repair

74. Shaft Runout Post Repair

75. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

76. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

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

0 Degrees

60 Degrees

120 Degrees

78. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

79. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

80. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

81. Shaft Repair Sign-off

Assembly

82. QC Check All Parts for Cleanliness Prior to Assembly

83. Photograph All Major Components prior to assembly

84. Final Insulation Resistance Test

85. Assembled Shaft Endplay

86. Assembled Shaft Runout

87. Test Run Voltage			
Volts	Volts	Volts	
88. Test Run Amperage			
Amps	Amps	Amps	
89. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
90. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
91. Ambient Temperature - Fahrenheit			
92. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
93. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
94. Document Final Condition with Pictures after paint			
95. 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.
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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

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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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