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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 103445

Prepared for PRODUCERS RICE STUTTGART

603 N. PARK AVE
STUTTGART AR 72160

Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *NO N/P*

1.0

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

AC Inspection as Found
PRODUCERS RICE STUTTGART
603 N. PARK AVE
STUTTGART, AR 72160

FolderID: 103445
FormID: 21433787

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: NO N/P

Description: 40hp- no nameplate

Hi-Speed Job Number: 103445

Manufacturer: Baldor

HP/kW: 40 (HP)

Voltage: 230 / 460

Phase: Three

Enclosure: TEFC

of Leads: 9

J-box Included: Complete

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 ● 5 - Good

Overall Condition

- | | |
|--|------------|
| 1. Report Date | 09/03/2024 |
| 2. Nameplate Picture | na |
| 3. Photos of all six sides of the machine. | |



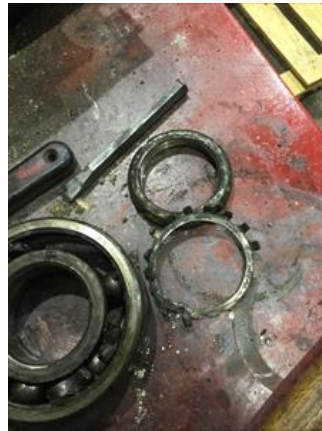
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4.	Describe the Overall Condition of the Equipment as Received	
	<i>Dirty but serviceable</i>	
5.	Report Date [COPY]	09/03/2024
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	(N) No
7.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(Yes) Yes
8.	Does Shaft Have Visible Damage?	(No) No
9.	Assembled Shaft Runout	Inches
	<i>Na</i>	
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	16 Inches
14.	Does it have Lugs?, If so what is the Stud Size?	(No) No
15.	Lead Numbers	1-9

16. Frame Condition

pass



17. Fan Condition

(P) Pass



18. Broken or Missing Components

connection box bolts

Initial Electrical Inspection

19. Insulation Resistance/Megger

0 Megohms

20. Winding Resistance

1-2

1-3

2-3

21. Perform Surge Test

(F) Fail

22. Number of Stator Slots

48



24. Stator Thermistors/Ohms

na

25. Stator Overloads/Ohms

na

Mechanical Inspection

26. Drive End Bearing Brand

SKF

27. Drive End Bearing Number-

6312 C3



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?

na

33. Drive End Bearing Condition

grease contamination



34. Opposite Drive End Bearing Brand

SKF

35. Opposite Drive End Bearing Number-

6311 C3



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

Grease contamination




42. Drive End Seal

pass

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43. Opposite Drive End Seal	pass
Rotor Inspection	
44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
45. Growler Test	(Pass) Pass
46. Number of Rotor Bars	41
47. Rotor Condition	wash



48. List the Parts needed for the Repair Below <i>1-6312 Bearing and 1-6311 Bearing</i>	
49. Signature of Technician that Disassembled Motor	RW
	
Mechanical Fits- Rotor	
50. Shaft Runout	inches
Na	
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	
0 Degrees	60 Degrees
	120 Degrees
Na	
54. Drive End Bearing Shaft Fit	
0 Degrees	60 Degrees
	120 Degrees
Na	

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55. Drive End Bearing Shaft Fit Condition

(F) Fail



56. Opposite Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
2.1655	2.1655	2.1655



57. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass

58. Shaft Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal
pass	pass

Mechanical Fits- Bearing Housings

59. Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
5.1191	5.1186	5.1186

60. Drive End - Endbell Bearing Fit Condition

(P) Pass



61. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

4.7258

4.7255

4.7263

62. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail

Resleeve



63. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

clean up

pass

64. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

pass

pass

65. List Machine Work Needed Below

Ode end bell bearing fit bad and De shaft bearing fit bad .

66. Technician

RW



Co sign: CRW

Root Cause of Failure

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67.	Failure locations <i>Bearings and ode end bell bearing fit .Also De shaft bearing fit and gland nut , locking ring</i>		
68.	Root cause of failure <i>Rotor drug the iron causing the winding to short in the slot . Mixed grease in bearings</i>		
Dynamic Balance Report			
69.	Rotor Weight and Balance Grade		
	Rotor Weight	Balance Grade	
70.	Initial Balance Readings		
	Drive End	Opposite Drive End	
71.	Final Balance Readings		
	Drive End	Opposite Drive End	
72.	Technician		
Rewind			
73.	Core Test Results - Watts loss per Pound		
	Pre-Burnout	Post Burnout	
74.	Core Hot Spot Test		
	Pre-Burnout	Post-Burnout	
75.	Post Rewind Electrical Test- Insulation Resistance		
76.	Post Rewind Polarization Index		
77.	Post Rewind Winding Resistance		
	1-2	1-3	2-3
78.	Post Rewind Surge Test		
79.	Post Rewind Hi-Pot		
80.	Technician		
Mechanical Fits- Rotor - Post Repair			
81.	Shaft Runout Post Repair		
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
85.	Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
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		
88. Shaft Repair Sign-off			
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	
91. Bearing Cap Condition Post Repair			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
92. End Bell Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
93. End Bell Repair Sign-off			
Assembly			
94. QC Check All Parts for Cleanliness Prior to Assembly			
95. Photograph All Major Components prior to assembly			
96. Final Insulation Resistance Test			
97. Assembled Shaft Endplay			
98. Assembled Shaft Runout			
99. Test Run Voltage			
Volts	Volts	Volts	
100. Test Run Amperage			
Amps	Amps	Amps	
101. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
102. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
103. Ambient Temperature - Fahrenheit			
104. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
105. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
106. Document Final Condition with Pictures after paint			
107. Final Pics and QC Review			



STANDARD TERMS AND CONDITIONS FOR PURCHASE OF GOOD AND/OR SERVICES

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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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.
7. **INSPECTION/ACCEPTANCE.** All goods and services ordered pursuant to any quotation shall be subject to inspection by Buyer after delivery or performance to determine conformity with the quotation and/or purchase order and Hi-Speed's advertised or published specifications. Buyer shall have a period of thirty (30) days from shipment of goods at the delivery destination specified in the quotation within which to inspect the goods for conformity with the quotation, order and/or Hi-Speed's advertised and published specifications and to provide Hi-Speed with written notice of any discrepancy or rejection. Buyer shall have a period of thirty (30) days following completion of any services within which to inspect the services for conformity with the quotation, purchase order and/or Hi-Speed's advertised and published specifications and to provide Hi-Speed with written notice of any discrepancy or rejection. If the goods delivered or services performed do not so conform, upon delivery of notice to Hi-Speed of any discrepancy, nonconformance or rejection, Hi-Speed shall have sixty (60) days to cure the alleged discrepancy and/or nonconformance. If Hi-Speed fails to cure in this time period, Buyer shall have the right to reject such goods or services. After the cure period, goods that have been delivered and rejected, in whole or in part, shall be returned to Hi-Speed. Buyer shall notify Hi-Speed and arrange for the return of the goods as required. Should such non-conforming services be rejected Hi-Speed shall, at its sole cost, re-perform the non-conforming services. Inspection or failure to inspect on any occasion shall not affect Buyer's rights under the warranty provisions herein.
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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