



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

LR Motor Shop Repairs

Job Number 103444

Prepared for PRODUCERS RICE STUTTGART

603 N. PARK AVE
STUTTGART AR 72160

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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: 103444
FormID: 21428665

AC Inspection - Rev. 2

Location: MOTOR SHOP LR
Serial Number: A1203272009
Description: 100HP BALDOR 1785RPM

Hi-Speed Job Number:	103444
Manufacturer:	Baldor
Spec/ID #:	P40G332
Serial Number:	A1203272009
HP/kW:	100 (HP)
RPM:	1785 (RPM)
Frame:	405T
Voltage:	230 / 460
Current:	112 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
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

08/30/2024

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1.0

2. Nameplate Picture



3. Photos of all six sides of the machine.





4.	Describe the Overall Condition of the Equipment as Received	
	<i>Dirty and locked up</i>	
5.	Report Date [COPY]	08/30/2024
Initial Mechanical/Electrical		
<input checked="" type="radio"/>	6. Does Shaft Turn Freely?	(N) No
<input checked="" type="radio"/>	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
<input type="checkbox"/>	Na	
	10. Assembled Shaft End Play	inches
<input type="checkbox"/>	Na	
	11. Air Gap Variation <10%	na

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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	(F) Fail
Fan has a crack	



18. Broken or Missing Components	fan
Initial Electrical Inspection	
19. Insulation Resistance/Megger	0 Megohms
20. Winding Resistance	
1-2	1-3 2-3
Failed	
21. Perform Surge Test	(F) Fail
22. Number of Stator Slots	60



24. Stator Thermistors/Ohms

Na

25. Stator Overloads/Ohms

Na

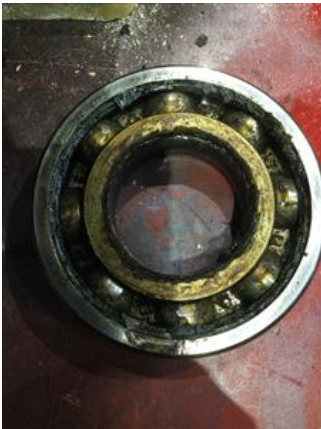
Mechanical Inspection

26. Drive End Bearing Brand

SKF

27. Drive End Bearing Number-

6316 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

normal wear



34. Opposite Drive End Bearing Brand

SKF

35. Opposite Drive End Bearing Number-

6316 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

contamination in the grease




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1.5

42. Drive End Seal	Na		
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	48		
47. Rotor Condition	pass wash		
48. List the Parts needed for the Repair Below	1-6316 Bearing 2-6316 Bearing		
49. Signature of Technician that Disassembled Motor	RW		
			
Witness: TRH			
Mechanical Fits- Rotor			
50. Shaft Runout	inches		
A			
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	
2.875	2.875	2.875	
53. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
2.875	2.875	2.875	
54. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
3.1501	3.1501	3.1501	
55. Drive End Bearing Shaft Fit Condition	(P) Pass		
56. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
Na			

57. Opposite Drive End Bearing Shaft Fit Condition

(F) Fail



58. Shaft Air Seal Fits

Drive End Air Seal
pass

Opposite Drive End Air Seal
bad



Mechanical Fits- Bearing Housings

59. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

6.6934

6.6934

6.6934

60. Drive End - Endbell Bearing Fit Condition (P) Pass

61. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

6.6939

6.6938

6.6939

62. Opposite Drive End - Endbell Bearing Fit Condition (P) Pass

63. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass

repair

64. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

pass

needs repair

65. List Machine Work Needed Below

Ode shaft bearing fit bad ode end bell air seal bad ode bearing cap air seal bad

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66. Technician

RW


Root Cause of Failure

67. Failure locations

Ode

68. Root cause of failure

*Ode shaft bearing fit undersized and causing the rotor to drag the iron shorting the winding***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

3.75**1.34**

74. Core Hot Spot Test

Pre-Burnout

Post-Burnout

 *Na*

75. Post Rewind Electrical Test- Insulation Resistance

9999999 Megohms

76. Post Rewind Polarization Index

Polarization Index
 *Na*

77. Post Rewind Winding Resistance

1-2

1-3

2-3

.0492**.0490****.0493**

78. Post Rewind Surge Test

(Pass) Pass

79. Post Rewind Hi-Pot

0.028 micro-amps

Sen Car




Mechanical Fits- Rotor - Post Repair

81. Shaft Runout Post Repair	0.0005 inches	
82. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0.001	0.001	0.001
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
3.1502	3.1502	3.1502



87. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
 A		

88. Shaft Repair Sign-off		
 Na		

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
6.693	6.693	6.6931



91. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap



Sleeved 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

Gary

Assembly

94. QC Check All Parts for Cleanliness Prior to Assembly

RW

95. Photograph All Major Components prior to assembly

(Complete) Complete





96. Final Insulation Resistance Test	Megohms	
Pass the Hi pot		
97. Assembled Shaft Endplay	inches	
Na		
98. Assembled Shaft Runout		
99. Test Run Voltage		
Volts	Volts	Volts
457	455	458






Co sign TRH

100. Test Run Amperage		
Amps	Amps	Amps
35.8	34.3	34.8

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101. Drive End Vibration Readings - Inches Per Second			
Horizontal		Vertical	Axial
0.03		0.070000000000000001	0.04
102. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal		Vertical	Axial
0.01		0.03	0.02
103. Ambient Temperature - Fahrenheit			
	Na		
104. Drive End Bearing Temps - Fahrenheit			
5 Minutes		10 Minutes	15 Minutes
	Na		
105. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes		10 Minutes	15 Minutes
	Na		

106. Document Final Condition with Pictures after paint



107. Final Pics and QC Review

RW

A handwritten signature in black ink, consisting of stylized letters, likely representing the initials TRH.

Co sign TRH



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

AC Random Coil Rewind Report

FolderID: 103444
FormID: 21514872

PRODUCERS RICE STUTT GART

603 N. PARK AVE
STUTT GART, AR 72160

MOTOR SHOP LR

Performed By: Motor Shop LR 2

Date Completed: 9/12/2024

Priorities Found: 4 - High 4 - Good

General

1. Job Number	103444
2. Report Date	09/05/2024
3. Customer	Producers Rice

Stator Winding

4. Core Length	8.25 "
5. Core ID	11.5 "
6. Back Iron Depth	1.6875 "
7. Slot Depth	1.5625 "
8. Tooth Width	0.3125 "
9. Number of Vents	
10. Vent Width	"
11. Before Burnout Core loss	(P) Pass
12. Flux Before Burnout	
13. Watts before burnout	

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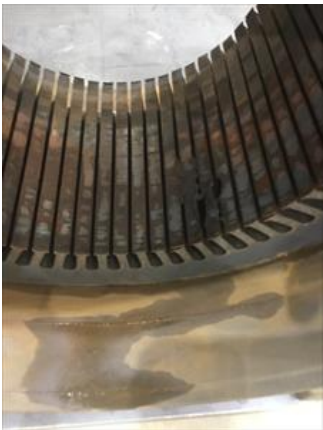
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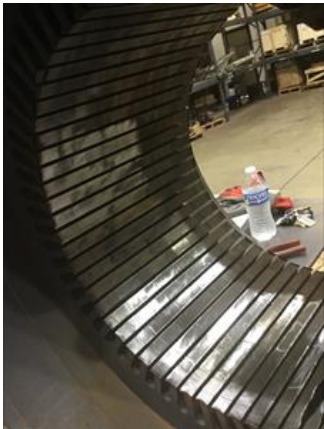
2.0

14. Watts loss per lb. before burnout

3.75 W/lbs.



15. After Burnout Core Loss	(P) Pass
16. Flux After burnout	
17. Watts After Burnout	Watts
18. Watts loss per lb After Burnout	1.34 W/lbs.




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19. Core Iron Condition	(F) Fail
Multiple Failures to Ground Rub from Bearing Failure	
20. RTD's	(N) No
21. RTD's Reading	Ohm's
22. Motor Heaters	(N) No
23. Heater Qty.	0
24. Heater Voltage	Volts
Na	
25. Heater Wattage	Watts
Na	
26. Thermistors	(N) No
27. Number of Poles	4
28. Slots	60
29. Number of Coils	60
30. Coil Weight	90 Lbs.
31. Lead Markings	
1-9	
32. Grouping	
12g of 5 c Concentric wound	
33. Multiple Wires	(Y) Yes
34. Wire Size	
16 # 17 3 # 18	
35. Turns per coil	
1-9 11 13 15 17 5. 4. 4. 4. 4.	
36. Pitch 1 to:	
1-9 11 13 15 17	
37. Connection	
1 delta @ 460 2 delta @ 230	
38. Lead Length	11 "
39. Lead Size	1
40. Number of Leads	9
41. Megger Reading After Rewind	9999999 Mohms

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42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	0.028 Ua
46. Surge Pattern After Rewind	(P) Pass
47. Service Technician	
<div><div><div></div><div>90 lbs wire</div><div>10' #1 EPDM lead wire</div><div>20' #6 EPDM lead wire</div></div><div></div></div>	





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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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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.
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.
15. **ASSIGNMENT.** The rights and obligations of the parties shall neither be assigned nor delegated without the prior written consent of the other party. However, any party may assign or delegate its respective rights and obligations, in whole or in part, (i) to any subsidiary, (ii) pursuant to other financing, merger or reorganization or (iii) pursuant to any sale or transfer of substantially all of the assets of the assigning party. These Standard Terms and Conditions shall bind the heirs, successors and assigns of the parties hereto.
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.