



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

LR Motor Shop Repairs

Job Number 102641

Prepared for Riceland Foods (11100-RLF)

Hwy 79 & N. Park Ave.
Stuttgart AR 72160

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AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *A1908222045*

1.0

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AC Inspection as Found
Riceland Foods (11100-RLF)
Hwy 79 & N. Park Ave.
Stuttgart, AR 72160

FolderID: 102641
FormID: 19747969

AC Inspection - Rev. 2

Location: MOTOR SHOP LR
Serial Number: A1908222045
Description: 400HP 1785RPM BALDOR

Hi-Speed Job Number:	102641
Manufacturer:	Baldor
Spec/ID #:	A44-7128-4239
Serial Number:	A1908222045
HP/kW:	400 (HP)
RPM:	1785 (RPM)
Frame:	L449T
Voltage:	460
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
Enclosure:	TEFC
# of Leads:	12
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	03/14/2024
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	No
Shaft Machined Fit Repairs Required:	No
Bearing Housing Machined Fit Repairs Required:	Yes
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● **3 - High** ● **9 - Good**

Overall Condition

1. Report Date	03/14/2024
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2. Nameplate Picture



3. Photos of all six sides of the machine.





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1.2





4. Describe the Overall Condition of the Equipment as Received

Bearings have fluting

Initial Mechanical/Electrical

● 5. Does Shaft Turn Freely?	(Y) Yes
● 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	0.001 Inches
9. Assembled Shaft End Play	inches
■ Na	
10. Air Gap Variation <10%	
■ Na	
● 11. Lead Condition	(P) Pass
12. Lead Length	48 Inches
● 13. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
■ Na	
14. Lead Numbers	123456
15. Frame Condition	good
● 16. Fan Condition	(P) Pass
17. Broken or Missing Components	no

Initial Electrical Inspection

18. Insulation Resistance/Megger	2000 Megohms
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19. Winding Resistance		
1-2	1-3	2-3
Na		
20. Perform Surge Test		(P) Pass
21. Number of Stator Slots		72
22. Stator Condition		pass
23. Stator Thermistors/Ohms		
Na		
24. Stator Overloads/Ohms		
Na		
Mechanical Inspection		
25. Drive End Bearing Brand		nacho
26. Drive End Bearing Number-		6222 c3
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?		no
31. Drive End Wavy Washer/Snap-Ring Other Retention Device?		snap ring
32. Drive End Bearing Condition		bad
Has fluting		
33. Opposite Drive End Bearing Brand		skf
34. Opposite Drive End Bearing Number-		6318 c3
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?		no
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?		wavy washer
40. Opposite Drive End Bearing Condition		bad
Has fluting		
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		58
46. Rotor Condition		good
47. List the Parts needed for the Repair Below		
6222 c3		
6318 c3		

48. Signature of Technician that Disassembled Motor

Trevor Hall


Mechanical Fits- Rotor49. 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

3.375**3.375****3.375**

52. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

3.3751**3.3751****3.375**

53. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

4.3315**4.3315****4.3315**54. Drive End Bearing Shaft Fit Condition **(P) Pass**

55. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.5435**3.5435****3.5435**56. Opposite Drive End Bearing Shaft Fit Condition **(P) Pass**

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

7.874**7.8741****7.874**

Tight

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

Tight

60. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

7.4819**7.4818****7.4818**61. Opposite Drive End - Endbell Bearing Fit Condition **(F) Fail**


Pitted

62. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass**pass**

63. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
<div> <div></div> <div>Na</div> </div>		
64. List Machine Work Needed Below <i>Sleeve OD endbell</i>		
65. Technician		Trevor Hall
		
<div> <div></div> <div>Co-sign: David Maclin</div> </div>		
Root Cause of Failure		
66. Failure locations <i>Bearings. Endbell.</i>		
67. Root cause of failure <i>Fluting in bearings from motor ran off of a VFD.. Pitting in bearing housing</i>		
Dynamic Balance Report		
68. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
<div> <div></div> <div>Na</div> </div>		
69. Initial Balance Readings		
Drive End	Opposite Drive End	



70. Final Balance Readings

Drive End

Opposite Drive End



71. Technician

Cw

Mechanical Fits- Bearing Housings - Post Repair

72. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

Na

73. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

7.4804

7.4805

7.4805

Installed insulated sleeve.



74. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Na

75. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

Na

76. End Bell Repair Sign-off

Gary



Assembly

77. QC Check All Parts for Cleanliness Prior to Assembly

78. Photograph All Major Components prior to assembly





79. Final Insulation Resistance Test	Megohms		
Pass			
80. Assembled Shaft Endplay	inches		
Na			
81. Assembled Shaft Runout	inches		
Na			
82. Test Run Voltage			
Volts	Volts	Volts	



83. Test Run Amperage

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witness RRW



84. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.02	0.02	0.01
85. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.01	0.03	0.02
86. Ambient Temperature - Fahrenheit		
Na		
87. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
88. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
89. Document Final Condition with Pictures after paint		



90. Final Pics and QC Review

Cw

Co sign: TRH



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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.
3. **SCOPE OF GOODS AND/OR SERVICES.** The goods and/or services provided by Hi-Speed pursuant to any quotation shall be limited exclusively to those goods and/or services expressly identified therein. Hi-Speed does not assume any responsibility and/or liability for the failure to provide any other goods and/or services not identified in any quotation. Modifications, additions or deletions to or from the scope referenced in any quotation shall only be effective if evidenced in writing and signed by Hi-Speed. The sale of any of all goods and/or services affected by such modification, addition or deletion shall be subject to these same Standard Terms and Conditions whether or not referenced therein.
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

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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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.