



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

LR Motor Shop Repairs

Job Number 103535

Prepared for Riceland Foods (11100-RLF)

Hwy 79 & N. Park Ave.
Stuttgart AR 72160

Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *C0304210199*

1.0

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

FolderID: 103535
FormID: 21696236

AC Inspection - Rev. 2

Location: MOTOR SHOP LR
Serial Number: C0304210199
Description: 75/60HP BALDOR 1780/1450RPM

Hi-Speed Job Number:	103535
Manufacturer:	Baldor
Spec/ID #:	14P024W982H1
Serial Number:	C0304210199
HP/kW:	75 (HP)
RPM:	1780 (RPM)
Frame:	365T
Voltage:	230 / 460
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
Enclosure:	TENV
# of Leads:	9
J-box Included:	Complete
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	No
Shaft Machined Fit Repairs Required:	No
Bearing Housing Machined Fit Repairs Required:	No
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● **3 - High** ● **10 - Good**

Overall Condition

1. Report Date 09/23/2024

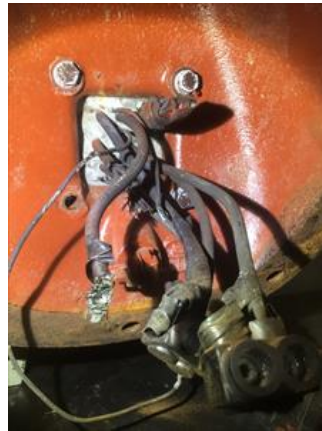
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2. Nameplate Picture



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.	Report Date [COPY]	
Initial Mechanical/Electrical		
<input checked="" type="radio"/>	6. Does Shaft Turn Freely?	(Y) Yes
<input checked="" type="radio"/>	7. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
	8. Does Shaft Have Visible Damage?	(No) No
	9. Assembled Shaft Runout	Inches
	10. Assembled Shaft End Play	inches
	11. Air Gap Variation <10%	

12. Lead Condition

(F) Fail



13. Lead Length	12 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	
1 j-box mounting bolt is broke and 2 j-box cover bolts broke	



Initial Electrical Inspection

 Pass

1-2

2-3

(P) Pass



pass

Over load leads are bad needs new leads

SKF

6313

11

(Ball) Ball Bearing

(Grease) Grease Lubricated

 Na

spanner nut

1.6

33. Drive End Bearing Condition

 *Wear*

34. Opposite Drive End Bearing Brand	SKF
35. Opposite Drive End Bearing Number-	6312
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?	
40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
41. Opposite Drive End Bearing Condition	

 *Wear*

42. Drive End Seal
43. Opposite Drive End Seal

Rotor Inspection

44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
45. Growler Test	(Pass) Pass
46. Number of Rotor Bars	
47. Rotor Condition	pass
48. List the Parts needed for the Repair Below	

6313
6312
New over load

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49. Signature of Technician that Disassembled Motor

Cw



Mechanical Fits- Rotor

50. Shaft Runout inches

51. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

52. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

53. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

54. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.5593

2.5593

2.5593

55. Drive End Bearing Shaft Fit Condition

(P) Pass

56. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.362

2.3622

2.3622

57. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass

58. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

59. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

5.5125

5.5125

5.5124

60. Drive End - Endbell Bearing Fit Condition

(P) Pass

61. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

5.1184

5.1185

5.1184

62. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass

63. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

64. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

65. List Machine Work Needed Below

66. Technician

Cw


 Co sign: DM
Root Cause of Failure

67. Failure locations

Bearings, leads, and some bolts are broke from j-box

68. Root cause of failure

*Wear***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

Assembly

73. QC Check All Parts for Cleanliness Prior to Assembly

74. Photograph All Major Components prior to assembly

75. Final Insulation Resistance Test

76. Assembled Shaft Endplay

77. Assembled Shaft Runout

78. Test Run Voltage

Volts

Volts

Volts

79. Test Run Amperage

Amps

Amps

Amps

80. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

81. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

82. Ambient Temperature - Fahrenheit

83. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

84. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

85. Document Final Condition with Pictures after paint

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