

LR Motor Shop Repairs

Job Number 102385

Prepared for Sage V Foods

5901 SLOAN DRIVE LITTLE ROCK AR 72206

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AC Inspection as Found - MOTOR SHOP LR

AC Inspection - Rev. 2: NO SN

1.0



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AC Inspection as Found

Sage V Foods 5901 SLOAN DRIVE LITTLE ROCK, AR 72206

AC Inspection - Rev. 2

Location: MOTOR SHOP LR Serial Number: NO SN

Description: 25HP BALDOR 1800RPM 284T

Hi-Speed Job Number:	102385
Manufacturer:	Baldor
Product Number:	10-0000-0086
Spec/ID #:	10-0000-0086
HP/kW:	25 (HP)
RPM:	1775 (RPM)
Frame:	284T
Voltage:	230 / 460
Current:	62/31
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:	Yes
Bearing Housing Machined Fit Repairs Required:	Yes
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: 2 - High

8 - Good

Overall Condition

1. Report Date 05/21/2024

Nameplate Picture 2.

Missing

3. Photos of all six sides of the machine.







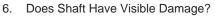


4. Describe the Overall Condition of the Equipment as Received Broken shaft and has rust

Initial Mechanical/Electrical

5. Does Shaft Turn Freely?

(Yes) Yes



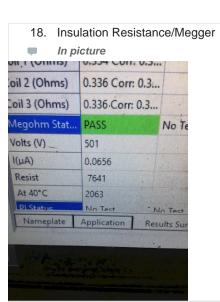


7.	Assembled Shaft Runout	Inches
8.	Assembled Shaft End Play	inches
9.	Air Gap Variation <10%	na
1 0.	Lead Condition	(P) Pass

(Yes) Yes



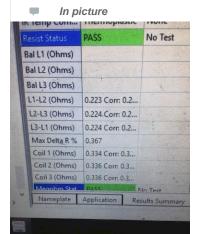
	11.	Lead Length	14 Inches
	12.	Lead Numbers	1-9
	13.	Frame Condition	pass
	14.	Fan Condition	(N) NA
	15.	Broken or Missing Components	shaft is broken
	16.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
	17.	Does it have Lugs?, If so what is the Stud Size?	(No) No
In	Initial Electrical Inspection		



Megohms

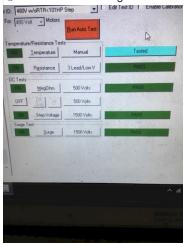
19. Winding Resistance

1-2 1-3 2-3



20. Perform Surge Test





information, reports, opinions and analysis by the Customer.

21. Number of Stator Slots22. Stator Condition48

23. Stator Thermistors/Ohms

24. Stator Overloads/Ohms

Mechanical Inspection

25. Drive End Bearing Brand

Na



26. Drive End Bearing Number-	6311
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?	na
31. Drive End Wavy Washer/Snap-Ring Other Retention Device?	na
32. Drive End Bearing Condition	signs of frosting



33. Opposite Drive End Bearing Brand

koyo

na



34. Opposite Drive End Bearing Number-	6309
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?	na
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
40. Opposite Drive End Bearing Condition	signs of frosting



200	Miles of The		
	41.	Drive End Seal	labyrinth seal
	42.	Opposite Drive End Seal	na
R	otor	Inspection	
	43.	Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
	44.	Growler Test	(Pass) Pass
	45.	Number of Rotor Bars	41
	46.	Rotor Condition	pass
	47.	List the Parts needed for the Repair Below	
		6311 6309 New shaft Aegis ring- 2.7132	

	48. Signature of Technician that Disassembled Motor Cw				
M	lecha	nical Fits- Rotor			
	49.	Shaft Runout		inches	
	7	Broke shaft			
	50.	Rotor Runout			
		Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
	-	Na			
	51.	Coupling Fit Closest to Bearing Housi	ng		
		0 Degrees	90 Degrees	120 Degrees	
	-	Na			
	52.	Coupling Fit Closest to the end of the	Shaft		
		0 Degrees	60 Degrees	120 Degrees	
		•	•	•	
	7	Na			
	53.	Drive End Bearing Shaft Fit			
		0 Degrees	60 Degrees	120 Degrees	
	-	Shaft broke			
	54.	Drive End Bearing Shaft Fit Condition		(F) Fail	
	55.	Opposite Drive End Bearing Shaft Fit			
		0 Degrees	60 Degrees	120 Degrees	
	-	Shaft broke			
	56.	Opposite Drive End Bearing Shaft Fit	Condition	(F) Fail	
	57.	Shaft Air Seal Fits			
		Drive End Air Seal	Opposite Drive End Air Seal		
	_	Na			
B.//					
IVI		nnical Fits- Bearing Housings Drive End - Endbell Bearing Fit			
	50.	0 Degrees	60 Degrees	120 Degrees	
		4.7252	4.7249	4.725	
	59.	Drive End - Endbell Bearing Fit Condi		(P) Pass	
_		Opposite Drive End - Endbell Bearing		(.)	
		0 Degrees	60 Degrees	120 Degrees	
		3.9373	3.9375	3.9374	
		0	Et a Pet	45 \ 5	

(P) Pass

61. Opposite Drive End - Endbell Bearing Fit Condition

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62. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Pass



63. End Bell Air Seal Fits

Drive End Air Seal Opposite Drive End Air Seal

Na

64. List Machine Work Needed Below

Shaft

65. Technician Cw

Root Cause of Failure

66. Failure locations

Bearings and shaft

67. Root cause of failure

Frosting and possible imbalance of what the motor is connected to

Dynamic Balance Report

68. Rotor Weight and Balance Grade

Rotor Weight Balance Grade

Na

69. Initial Balance Readings

Drive End

Opposite Drive End



70. Final Balance Readings

Drive End

Opposite Drive End



71. Technician Cw

Mechanical Fits- Rotor - Post Repair

72. Shaft Runout Post Repair inches

Na

73. Rotor Runout Post Repair

Drive End Bearing Fit Rotor Body Opposite Drive End Bearing

Na

74. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees 90 Degrees 120 Degrees

Na

75.	75. Coupling Fit Closest to the end of the Shaft Post Repair			
	0 Degrees	60 Degrees	120 Degrees	
70	Na			
76.	Drive End Bearing Shaft Fit Post Rep		100 B	
	0 Degrees	60 Degrees	120 Degrees	
-	Na			
77.	Opposite Drive End Bearing Shaft Fit	Post Repair		
	0 Degrees	60 Degrees	120 Degrees	
		-		
-	Na			
78.	Shaft Air Seal Fits Post Repair			
	Drive End Air Seal	Opposite Drive End Air Seal		
-	Na			
79.	Shaft Repair Sign-off			
-	Na			
Mecha	anical Fits- Bearing Housings - P	ost Repair		
80.	Drive End - Endbell Bearing Fit Post I	Repair		
	0 Degrees	60 Degrees	120 Degrees	
04	Na	Fit Doot Domain		
81.	Opposite Drive End - Endbell Bearing		120 Dograda	
	0 Degrees	60 Degrees	120 Degrees	
-	Na			
82.	Bearing Cap Condition Post Repair			
	Drive End Bearing Cap	Opposite Drive End Bearing Cap		
_	M-			
92	Na End Bell Air Seal Fits Post Repair			
83.	Drive End Air Seal	Opposite Drive End Air Seal		
	Drive Erid Ali Seai	Opposite Drive End All Seal		
-	Na			
84.	End Bell Repair Sign-off			
-	Na			
Asser	nbly			
85.	QC Check All Parts for Cleanliness P	rior to Assembly		Cw
	/			
	/ prin	/		









87.	Final Insulation Resistance Test Pass		Megohms
88.	Assembled Shaft Endplay		inches
89.	Assembled Shaft Runout Na		inches
90.	Test Run Voltage		
	Volts	Volts	Volts





Witnessed by David M.



92.	Drive End Vibration Readings - Inches	Per Second	
	Horizontal	Vertical	Axial
	0.03	0.01	0.03
93.	Opposite Drive End Vibration Reading	s - Inches Per Second	
	Horizontal	Vertical	Axial
	0.04	0.01	0.03
94.	Ambient Temperature - Fahrenheit		
-	Na		
95.	. Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
-	Na		
96. Opposite Drive End Bearing Temps - Fahrenheit		Fahrenheit	
	5 Minutes	10 Minutes	15 Minutes
-	Na		
97. Document Final Condition with Pictures after paint			



98. Final Pics and QC Review Cw



Co sign: David M.



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- 8. <u>WARRANTIES.</u> 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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