



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

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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*Printed on 5/21/2024*

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

## AC Inspection as Found

Sage V Foods  
5901 SLOAN DRIVE  
LITTLE ROCK, AR 72206

FolderID: 102385  
FormID: 19130208

### 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 |
| 2. Nameplate Picture                       | Missing    |
| 3. Photos of all six sides of the machine. |            |

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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

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6. Does Shaft Have Visible Damage?

(Yes) Yes



7. Assembled Shaft Runout

Inches

Na

8. Assembled Shaft End Play

inches

Na

9. Air Gap Variation <10%

na

10. Lead Condition

(P) Pass



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

### Initial Electrical Inspection

## 18. Insulation Resistance/Megger

Megohms

In picture

Coil 2 (Ohms)	0.336 Corr: 0.3...
Coil 3 (Ohms)	0.336 Corr: 0.3...
Megohm Stat...	PASS No Test
Volts (V)	501
I(μA)	0.0656
Resist	7641
At 40°C	2063
DI Status	No Test No Test
Nameplate	Application Results Summary

## 19. Winding Resistance

1-2

1-3

2-3

In picture

Resist Status	PASS No Test
Bal L1 (Ohms)	
Bal L2 (Ohms)	
Bal L3 (Ohms)	
L1-L2 (Ohms)	0.223 Corr: 0.2...
L2-L3 (Ohms)	0.224 Corr: 0.2...
L3-L1 (Ohms)	0.224 Corr: 0.2...
Max Delta R %	0.367
Coil 1 (Ohms)	0.334 Corr: 0.3...
Coil 2 (Ohms)	0.336 Corr: 0.3...
Coil 3 (Ohms)	0.336 Corr: 0.3...
Megohm Stat	PASS No Test
Nameplate	Application Results Summary

## 20. Perform Surge Test

(P) Pass

ID: 480V w/oRTTc101HP Step	Edit Test ID	Enable Lancer
For: 480 Volt Motors	Run Auto Test	
Temperature/Resistance Tests	Manual	Tested
Resistance	3 Lead/Low V	PASS
DC Tests	MegOhm 500 Volts	PASS
OFF	500 Volts	PASS
Step-Voltage	1500 Volts	PASS
Surge Test	Surge 1500 Volts	PASS

## 21. Number of Stator Slots

48

## 22. Stator Condition



pass

## 23. Stator Thermistors/Ohms

na

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24. Stator Overloads/Ohms	na
<b>Mechanical Inspection</b>	
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





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



41. Drive End Seal	labyrinth seal
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	41
46. Rotor Condition	pass
47. List the Parts needed for the Repair Below	
	6311
	6309
	New shaft
	Aegis ring- 2.7132

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48. Signature of Technician that Disassembled Motor	Cw	
		
<b>Mechanical Fits- Rotor</b>		
49. Shaft Runout	inches	
 <i>Broke shaft</i>		
50. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
 <i>Na</i>		
51. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
 <i>Na</i>		
52. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
 <i>Na</i>		
53. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
 <i>Shaft broke</i>		
54. Drive End Bearing Shaft Fit Condition	(F) Fail	
55. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
 <i>Shaft broke</i>		
56. Opposite Drive End Bearing Shaft Fit Condition	(F) Fail	
57. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
 <i>Na</i>		
<b>Mechanical Fits- Bearing Housings</b>		
58. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
4.7252	4.7249	4.725
59. Drive End - Endbell Bearing Fit Condition	(P) Pass	
60. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
3.9373	3.9375	3.9374
61. Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass	

## 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

Atom Operating Speed: 1775  
NEMA Spec: 1.50 mil  
Balancing RPM: 424.12

Balance Co

-----

Start

Right End Mils: 0.77 M  
Angle: 313.12 An  
Left End Mils: 1.47 M  
Angle: 73.22 Ang

Beginning unbalance: 31.08  
Residual unbalance: 29.99  
3.67  
This item is balanced to: 12.828  
10.659

Key Used  
Drive End: 0.00 in wide x 0.00  
Bearing End: 0.00 in wide x 0.00

## 70. Final Balance Readings

Drive End

Opposite Drive End

00 RPM

Conditions

-----

Finish

Mils: 0.32 in/s: 0.007  
Angle: 263.64  
Mils: 0.52 in/s: 0.012  
Angle: 112.29

31.080 g-in, 1.096 oz-in Right Side  
29.995 g-in, 1.058 oz-in Left Side  
3.67 g, 0.13 oz Right Side  
3.05 g, 0.11 oz Left Side  
12.828 g-in, 0.452 oz-in Right Side  
10.659 g-in, 0.378 oz-in Left Side

wide x 0.00 in thick x 0.00 in long  
wide x 0.00 in thick x 0.00 in long

## 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

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75. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
<div> <div></div> Na </div>		
76. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
<div> <div></div> Na </div>		
77. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
<div> <div></div> Na </div>		
78. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
<div> <div></div> Na </div>		
79. Shaft Repair Sign-off		
<div> <div></div> Na </div>		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
80. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
<div> <div></div> Na </div>		
81. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
<div> <div></div> Na </div>		
82. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
<div> <div></div> Na </div>		
83. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
<div> <div></div> Na </div>		
84. End Bell Repair Sign-off		
<div> <div></div> Na </div>		
<b>Assembly</b>		
85. QC Check All Parts for Cleanliness Prior to Assembly		Cw
		

86. Photograph All Major Components prior to assembly

(Complete) Complete



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



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## 91. Test Run Amperage

Amps

Amps

Amps

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 Readings - 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

5 Minutes

10 Minutes

15 Minutes

Na

## 97. Document Final Condition with Pictures after paint



## 98. Final Pics and QC Review

Cw

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Choir



Co sign: David M.





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