



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

LR Motor Shop Repairs

**Job Number 103595**

Prepared for Sage V Foods

5901 SLOAN DRIVE  
LITTLE ROCK AR 72206

# Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *E02C48051N-55-11/22*

**1.0**

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*Printed on 10/3/2024*

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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: 103595  
FormID: 21825271

### AC Inspection - Rev. 2

Location: MOTOR SHOP LR  
Serial Number: E02C48051N-55-11/22  
Description: 2.5HP SWECO

Hi-Speed Job Number:	103595
Manufacturer:	Other
Product Number:	TYPE: TENV
Serial Number:	E02C48051N-55-11/22
HP/kW:	2.5 (HP)
RPM:	1160 (RPM)
Frame:	213T
Voltage:	460
Current:	4.3 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
Enclosure:	TENV
# of Leads:	3
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:  12 - Good

### Overall Condition

1. Report Date	10/03/2024
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## 2. Nameplate Picture



## 3. Photos of all six sides of the machine.





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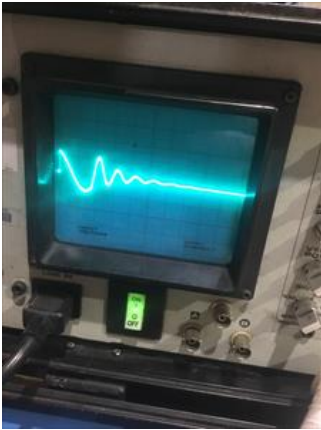
4. Describe the Overall Condition of the Equipment as Received		
<i>Dirty</i>		
5. Report Date [COPY]		
<b>Initial Mechanical/Electrical</b>		
6. Does Shaft Turn Freely?		(Y) Yes
7. Does the shaft require T.I.R in Lathe to identify additional repairs?		(No) No
8. Does Shaft Have Visible Damage?		(No) No
9. Assembled Shaft Runout		Inches
10. Assembled Shaft End Play		inches
11. Air Gap Variation <10%		
12. Lead Condition		(P) Pass
13. Lead Length		44 Inches
14. Does it have Lugs?, If so what is the Stud Size?		(No) No
15. Lead Numbers		1-3
16. Frame Condition		pass
17. Fan Condition		(N) NA
18. Broken or Missing Components		
<b>Initial Electrical Inspection</b>		
19. Insulation Resistance/Megger		Megohms



20. Winding Resistance		
1-2	1-3	2-3


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22. Number of Stator Slots	36
23. Stator Condition	pass
24. Stator Thermistors/Ohms	
25. Stator Overloads/Ohms	
<b>Mechanical Inspection</b>	
26. Drive End Bearing Brand	FAG
27. Drive End Bearing Number-	NU 2313
28. Drive End Bearing Qty.	1
29. Drive End Bearing Type	(Roller) Roller Bearing
30. Drive End Lubrication Type	(Grease) Grease Lubricated
31. Drive End Bearing Insulation or Grounding Device?	
32. Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
33. Drive End Bearing Condition	wear
34. Opposite Drive End Bearing Brand	FAG
35. Opposite Drive End Bearing Number-	22313
36. Opposite Drive End Bearing Qty.	1
37. Opposite Drive End Bearing Type	(Spherical) Spherical Roller 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?	snap ring
41. Opposite Drive End Bearing Condition	wear
42. Drive End Seal	
ⓘ <i>National: 471272 lip seal</i> <i>TCM: 29362 lip seal</i>	
43. Opposite Drive End Seal	
ⓘ <i>National: 471272 lip seal</i> <i>TCM: 29362 lip seal</i>	
<b>Rotor Inspection</b>	
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

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48. List the Parts needed for the Repair Below			
<i>National: 471272 lip seal x2</i> <i>TCM: 29362 lip seal x2</i> <i>22313 bearing</i> <i>NU2313 bearing</i>			
49. Signature of Technician that Disassembled Motor			Cw
			
<b>Mechanical Fits- Rotor</b>			
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	
2.5598	2.5597	2.5597	
55. Drive End Bearing Shaft Fit Condition			(P) Pass
56. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.5593	2.5594	2.5594	
57. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
58. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
<b>Mechanical Fits- Bearing Housings</b>			
59. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.5123	5.5122	5.5122	
60. Drive End - Endbell Bearing Fit Condition			(P) Pass
61. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.5122	5.5121	5.5121	
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: TH
**Root Cause of Failure**

67. Failure locations

*Bearings and seals*

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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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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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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