



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

LR Motor Shop Repairs

Job Number 103504

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: *CAT: UJ20P2BM*

1.0

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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: 103504
FormID: 21599284

AC Inspection - Rev. 2

Location: MOTOR SHOP LR
Serial Number: CAT: UJ20P2BM
Description: 20HP NIDEC W/ PENTAIR PUMP

Hi-Speed Job Number:	103504
Manufacturer:	US Motors/Nidec
Product Number:	M: G29316
Serial Number:	CAT: UJ20P2BM
HP/kW:	20 (HP)
RPM:	1770 (RPM)
Frame:	256JM
Voltage:	230 / 460
Current:	47.0/23.7 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.25
Enclosure:	TEFC
# 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:  12 - Good

Overall Condition

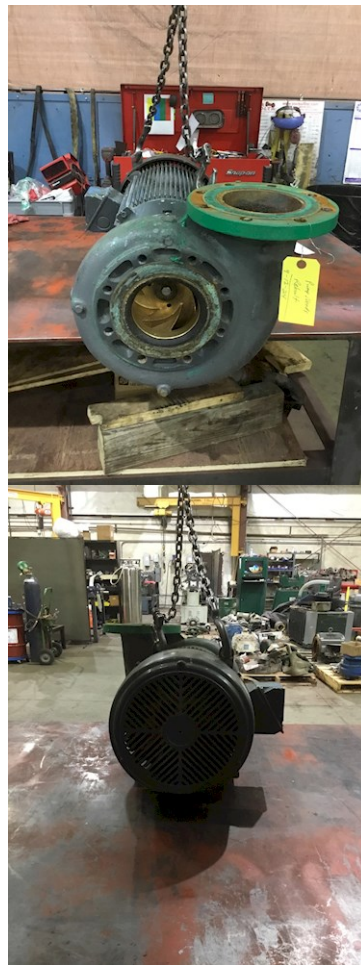
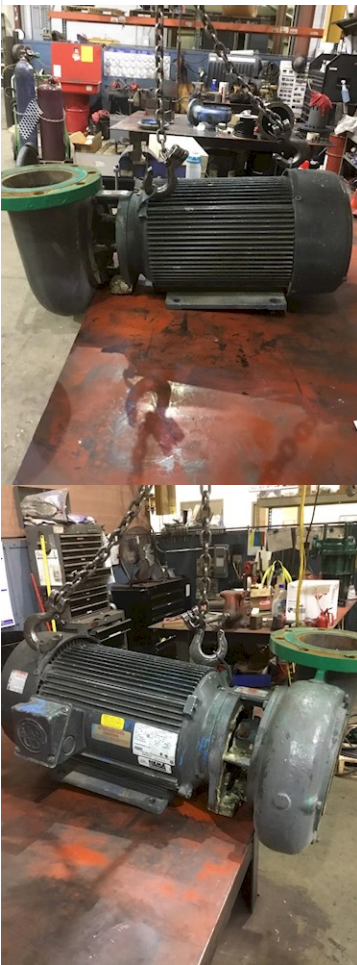
1. Report Date	09/16/2024
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2. Nameplate Picture



3. Photos of all six sides of the machine.





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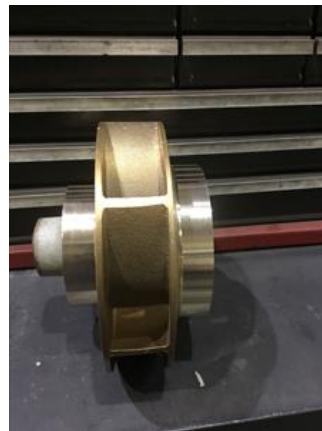
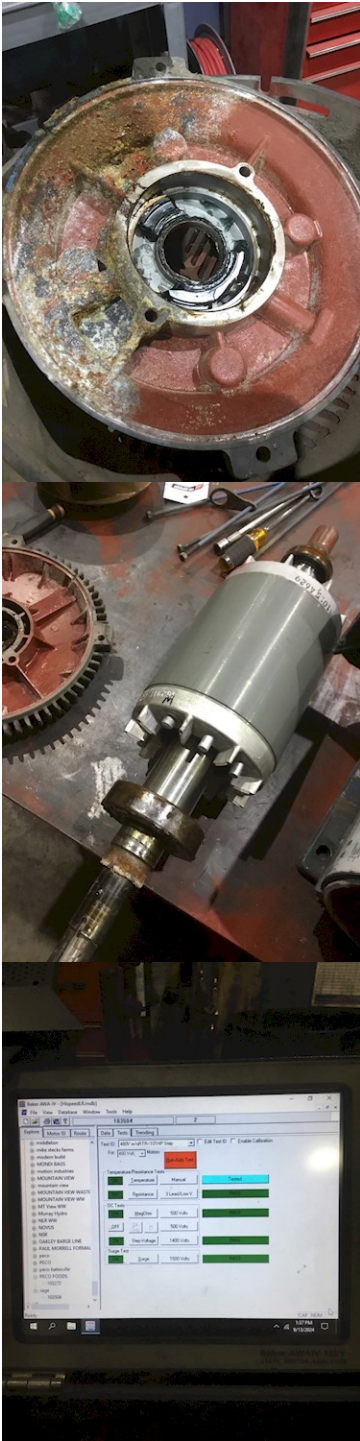
1.2



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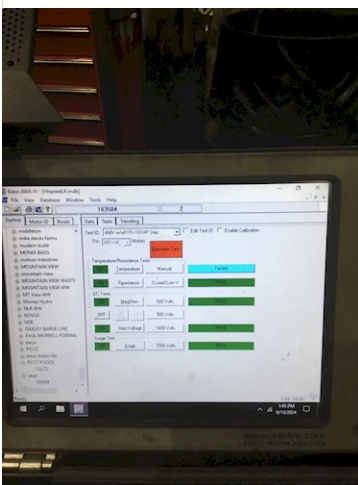
Turned impeller true.
Gary





Installed upper wear ring. Clearance .03"

Sleeved bowl wear ring.
Gary

4. Describe the Overall Condition of the Equipment as Received	
<i>Dirty</i>	
5. Report Date [COPY]	09/16/2024
Initial Mechanical/Electrical	
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	0 Inches
10. Assembled Shaft End Play	0 inches
11. Air Gap Variation <10%	none
12. Lead Condition	(P) Pass
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	good
17. Fan Condition	(P) Pass
18. Broken or Missing Components	none
Initial Electrical Inspection	
19. Insulation Resistance/Megger	2000 Megohms



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20. Winding Resistance		
1-2	1-3	2-3
.393	.393	.393
21. Perform Surge Test		(P) Pass
22. Number of Stator Slots		36
23. Stator Condition		good
24. Stator Thermistors/Ohms		na
25. Stator Overloads/Ohms		na
Mechanical Inspection		
26. Drive End Bearing Brand		FAG
 		
27. Drive End Bearing Number-		6310
28. Drive End Bearing Qty.		1
29. Drive End Bearing Type		(Ball) Ball Bearing
30. Drive End Lubrication Type		(Grease) Grease Lubricated
31. Drive End Bearing Insulation or Grounding Device?		none
32. Drive End Wavy Washer/Snap-Ring Other Retention Device?		snap ring
33. Drive End Bearing Condition		normal
34. Opposite Drive End Bearing Brand		FAG
35. Opposite Drive End Bearing Number-		6207 2RS
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?		none
40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?		wavy
41. Opposite Drive End Bearing Condition		normal
42. Drive End Seal		1 1/2 * 2 1/16 carbon ceramic mechanical seal
43. Opposite Drive End Seal		none
Rotor Inspection		
44. Rotor Type/Material		(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
45. Growler Test		(Pass) Pass
46. Number of Rotor Bars		44
47. Rotor Condition		good

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48. List the Parts needed for the Repair Below <i>6310 2Z, 6207 2RS, 1 1/2 * 2 1/16 carbon ceramic mechanical seal</i>		
49. Signature of Technician that Disassembled Motor		David Maclin
		
Mechanical Fits- Rotor		
50. Shaft Runout		0 inches
51. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0	0	0
52. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
0	0	0
53. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
0	0	0
54. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
1.9685	1.9686	1.9686
55. Drive End Bearing Shaft Fit Condition		(P) Pass
56. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
1.3783	1.3783	1.3783
57. Opposite Drive End Bearing Shaft Fit Condition		(P) Pass
58. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
ok	ok	
Mechanical Fits- Bearing Housings		
59. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
4.3313	4.3312	4.3312
60. Drive End - Endbell Bearing Fit Condition		(P) Pass
61. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
2.835	2.835	2.835
62. Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
63. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
ok	ok	
64. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
ok	ok	
65. List Machine Work Needed Below <i>Upper wear ring, lower wear ring, machine impeller upper, machine impeller lower</i>		

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**Root Cause of Failure**

67. Failure locations

68. Root cause of failure

Dynamic Balance Report

69. Rotor Weight and Balance Grade

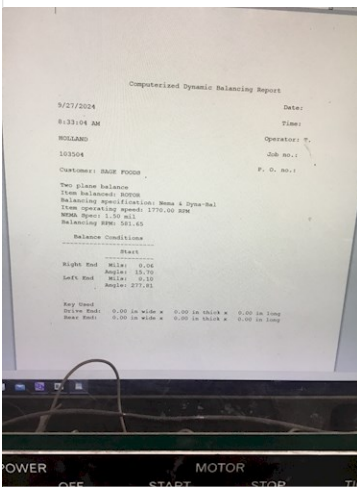
Rotor Weight

Balance Grade

70. Initial Balance Readings

Drive End

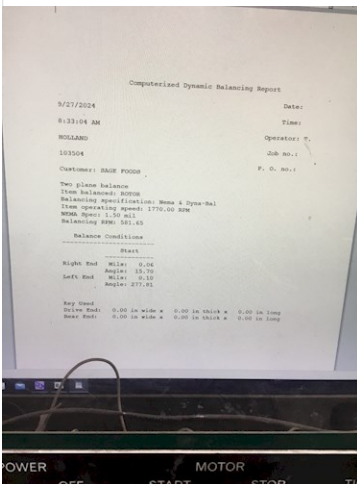
Opposite Drive End



71. Final Balance Readings

Drive End

Opposite Drive End



72. Technician

Assembly

73. QC Check All Parts for Cleanliness Prior to Assembly

Terrence Holland

Terrence Holland

74. Photograph All Major Components prior to assembly

(Complete) Complete



75. Final Insulation Resistance Test

Megohms

Pass the Hi pot

76. Assembled Shaft Endplay

inches

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1.9

77. Assembled Shaft Runout	0 inches	
78. Test Run Voltage		
Volts	Volts	Volts
456	456	457



Co sign DM

79. Test Run Amperage		
Amps	Amps	Amps
6.3	6.4	6.4



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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86. Final Pics and QC Review

RW

DM



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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.
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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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