



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

LR Motor Shop Repairs

**Job Number 102676**

Prepared for Sage V Foods

5901 SLOAN DRIVE  
LITTLE ROCK AR 72206

# Table of Contents



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: 102676  
FormID: 19820374

### AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: 100 HP DP RUSH NO O.T.

Hi-Speed Job Number: 102676

Manufacturer: Baldor

Spec/ID #: P668771

Serial Number: A1712192068

HP/kW: 100 (HP)

RPM: 3555 (RPM)

Frame: 365TSC

Voltage: 230 / 460

Current: 224 / 112

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.25

Enclosure: DP

J-box Included: None

Coupling/Sheave: None

Date Received: 03/20/2024

Repair Stage: Final

Priorities Found: ● 2 - High ● 8 - Good

### Overall Condition

- |                      |            |
|----------------------|------------|
| 1. Report Date       | 03/22/2024 |
| 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  
*Dirty*

#### Initial Mechanical/Electrical

- |                                  |  |         |
|----------------------------------|--|---------|
| <input checked="" type="radio"/> | 5. Does Shaft Turn Freely?   | (Y) Yes |
| <input checked="" type="radio"/> | 6. Does the shaft require T.I.R in Lathe to identify additional repairs? | (No) No |

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7. Does Shaft Have Visible Damage?

(No) No



8. Assembled Shaft Runout

0 Inches

9. Assembled Shaft End Play

inches

Na

10. Air Gap Variation <10%

Na

11. Lead Condition

(P) Pass



12. Lead Length

16 Inches



13. Does it have Lugs?, If so what is the Stud Size?

(Yes) Yes

14. Lead Numbers

1-12

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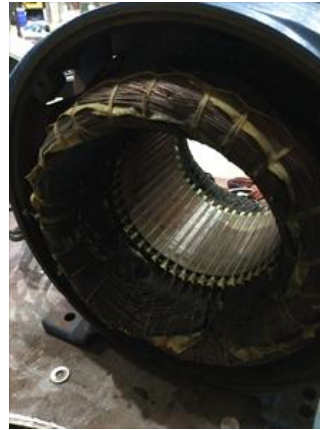
15. Stator Temperature Detector Rating and Function		
Quantity	Rating	Quantity Passed
<div> <div></div> Na </div>		
16. Bearing Temperature Detector Rating and Function		
Quantity	Rating	Quantity Passed
<div> <div></div> Na </div>		
17. Frame Condition		pass
18. Fan Condition		(N) NA
19. Heater Quantity, Ratings		
Quantity	Volts/Watts	Pass/Fail
<div> <div></div> Na </div>		
20. Broken or Missing Components		
<div> <div></div> None </div>		
Initial Electrical Inspection		
21. Insulation Resistance/Megger		15 Megohms
22. Winding Resistance		
1-2	1-3	2-3
0.1018	0.144	0.246
23. Perform Surge Test		(F) Fail
<div> <div></div> Rewind </div>		



24. Number of Stator Slots	48
----------------------------	----

25. Stator Condition

Rewind turn to turn short



26. Stator Thermistors/Ohms

Na

27. Stator Overloads/Ohms

Na

### Mechanical Inspection

28. Drive End Bearing Brand

Peer

29. Drive End Bearing Number-

6313

30. Drive End Bearing Qty.

1

31. Drive End Bearing Type

(Ball) Ball Bearing

32. Drive End Lubrication Type

(Grease) Grease Lubricated

33. Drive End Bearing Insulation or Grounding Device?

Na

34. Drive End Wavy Washer/Snap-Ring Other Retention Device?

na

35. Drive End Bearing Condition

axial load







37. Opposite Drive End Bearing Number-	<b>6313</b>
38. Opposite Drive End Bearing Qty.	<b>1</b>
39. Opposite Drive End Bearing Type	<b>(Ball) Ball Bearing</b>
40. Opposite Drive End Lubrication Type	<b>(Grease) Grease Lubricated</b>
41. Opposite Drive End Bearing Insulation or Grounding Device?	
<b>Na</b>	
42. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>no</b>
43. Opposite Drive End Bearing Condition	<b>axial load</b>



44. Drive End Seal

**Na**

45. Opposite Drive End Seal

**Na**

46. DE Sleeve Bearing Inside Diameter

0 degrees

120 degrees

240 degrees

**Na**

47. DE Sleeve Bearing Outside Diameter

0 degrees

120 degrees

240 degrees

**Na**

48. DE Sleeve Bearing Housing Inside Diameter		
0 degrees	120 degrees	240 degrees
Na		
49. DE Sleeve Bearing to Housing Clearance		
0 degrees	120 degrees	240 degrees
Na		
50. ODE Sleeve Bearing Inside Diameter		
0 degrees	120 degrees	240 degrees
Na		
51. ODE Sleeve Bearing Outside Diameter		
0 degrees	120 degrees	240 degrees
Na		
52. ODE Sleeve Bearing Housing Inside Diameter		
0 degrees	120 degrees	240 degrees
Na		
53. ODE Sleeve Bearing to Housing Clearance		
0 degrees	120 degrees	240 degrees
Na		
<b>Rotor Inspection</b>		
54. Rotor Type/Material	<b>(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast</b>	



55. Growler Test	<b>(Pass) Pass</b>
56. Number of Rotor Bars	<b>38</b>
57. Rotor Condition	<b>dirty needs washed</b>
58. List the Parts needed for the Repair Below <i>2-6313 bearings</i>	
59. Signature of Technician that Disassembled Motor	
<b>Mechanical Fits- Rotor</b>	
60. Shaft Runout	<b>0.0003 inches</b>

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61. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
Na			
62. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
Na			
63. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
Na			
64. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.5594	2.5594	2.5594	
65. Drive End Bearing Shaft Fit Condition			(P) Pass



66. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.5592	2.5592	2.5592	
67. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass



68. Shaft Air Seal Fits			
Drive End Air Seal		Opposite Drive End Air Seal	
Na			
Mechanical Fits- Bearing Housings			
69. Drive End - Endbell Bearing Fit			
0 Degrees		60 Degrees	120 Degrees
5.5135		5.5135	5.5135
70.	Drive End - Endbell Bearing Fit Condition		
	(F) Fail		



71. Opposite Drive End - Endbell Bearing Fit			
0 Degrees		60 Degrees	120 Degrees
5.513		5.513	5.513
72. Opposite Drive End - Endbell Bearing Fit Condition			(P) Pass



73.	Bearing Cap Condition	
	Drive End Bearing Cap	Opposite Drive End Bearing Cap
	pass	pass
74.	End Bell Air Seal Fits	
	Drive End Air Seal	Opposite Drive End Air Seal
	Na	
75.	List Machine Work Needed Below	
	De end bell bearing fit bad	

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76. Technician

RW



Co witness: CRW

**Root Cause of Failure**

77. Failure locations

*Connection end bottom side of winding close to the iron*

78. Root cause of failure

*Dirty***Dynamic Balance Report**

79. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

80. Initial Balance Readings

Drive End

Opposite Drive End

81. Final Balance Readings

Drive End

Opposite Drive End

82. Technician

**Rewind**

83. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

84. Core Hot Spot Test

Pre-Burnout

Post-Burnout

85. Post Rewind Electrical Test- Insulation Resistance

86. Post Rewind Polarization Index

87. Post Rewind Winding Resistance

1-2

1-3

2-3

88. Post Rewind Surge Test

89. Post Rewind Hi-Pot

90. Technician

**Mechanical Fits- Rotor - Post Repair**

91. Shaft Runout Post Repair

92. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

93. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

94. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

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95. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
96. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
97. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
98. Shaft Repair Sign-off		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
99. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
100. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
101. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
102. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
103. DE Sleeve Bearing Inside ID Post Repair		
Measure 1	Measure 2	Measure 3
104. DE Sleeve Bearing Outside ID Post Repair		
Measure 1	Measure 2	Measure 3
105. DE Sleeve Bearing Inside OD Post Repair		
Measure 1	Measure 2	Measure 3
106. DE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
107. End Bell Repair Sign-off		
108. ODE Sleeve Bearing Inside ID Post Repair		
Measure 1	Measure 2	Measure 3
109. ODE Sleeve Bearing Outside ID Post Repair		
Measure 1	Measure 2	Measure 3
110. ODE Sleeve Bearing Inside OD Post Repair		
Measure 1	Measure 2	Measure 3
111. ODE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
<b>Assembly</b>		
112. QC Check All Parts for Cleanliness Prior to Assembly		

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113. Photograph All Major Components prior to assembly			
114. Final Insulation Resistance Test			
115. Assembled Shaft Endplay			
116. Assembled Shaft Runout			
117. Test Run Voltage			
Volts	Volts	Volts	
118. Test Run Amperage			
Amps	Amps	Amps	
119. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
120. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
121. Ambient Temperature - Fahrenheit			
122. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
123. Drive End Bearing Temps - Fahrenheit 20-30 Minutes			
20 Minutes	25 Minutes	30 Minutes	
124. Drive End Bearing Temps - Fahrenheit 35-45 Minutes			
35 Minutes	40 Minutes	45 Minutes	
125. Drive End Bearing Temps - Fahrenheit 50-60 Minutes			
50 Minutes	55 Minutes	60 Minutes	
126. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
127. Opposite Drive End Bearing Temps - Fahrenheit 20-30 Minutes			
20 Minutes	25 Minutes	30 Minutes	
128. Opposite Drive End Bearing Temps - Fahrenheit 35-45 Minutes			
35 Minutes	40 Minutes	45 Minutes	
129. Opposite Drive End Bearing Temps - Fahrenheit 50-60 Minutes			
50 Minutes	55 Minutes	60 Minutes	
130. Stator Temperatures- Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
131. Stator Temperatures- Fahrenheit 20-30 Minutes			
20 Minutes	25 Minutes	30 Minutes	
132. Stator Temperatures- Fahrenheit 35-45 Minutes			
35 Minutes	40 Minutes	45 Minutes	

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133. Stator Temperatures- Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
134. Document Final Condition with Pictures after paint		
135. Final Pics and QC Review		



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1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
2. **PRICE.** All quoted prices shall remain firm and binding for a period of thirty (30) days from the date of quotation or for the period specifically stated in the quotation. The price for any and all goods and/or services ordered or approved by Buyer after thirty (30) days from the date of any quotation are subject to any increase in price that may occur after the expiration of thirty (30) days from the issuance of the quotation and the date the Buyer releases any shipment.
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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

replace any defective or non-conforming goods in accordance with the applicable manufacturer's warranty. Warranty for any defective or incorrect parts is limited to the repair or replacement of those parts. Hi-Speed warrants that all services will conform in all material respects to the description of services identified in the quotation and will be performed in a good and workmanlike manner in accordance with industry practices and standards. Should the services be reasonably rejected or not conform with the foregoing warranties, Hi-Speed shall, at its sole cost, re-perform the defective or nonconforming services. Notwithstanding the foregoing, these warranties do not extend to goods or services to the extent that such goods have been subject to misuse, neglect or abuse not caused by Hi-Speed or have been used in violation of the approved written instructions furnished to Buyer. THE FOREGOING REPRESENTS THE SOLE AND EXCLUSIVE WARRANTY GIVEN BY HI-SPEED WITH RESPECT TO ALL GOODS SOLD AND IS IN LIEU OF ALL OTHER WARRANTIES EITHER EXPRESS OR IMPLIED. HI-SPEED EXPRESSLY DISCLAIMS ALL OTHER WARRANTIES INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR USE OR PURPOSE. BUYER WAIVES ANY CLAIM THAT THESE EXCLUSIONS OR LIMITATIONS DEPRIVE IT OF AN ADEQUATE REMEDY AT EQUITY OR LAW OR CAUSE THIS AGREEMENT TO FAIL IN ITS ESSENTIAL PURPOSE. BUYER SHALL BE ENTITLED TO NO OTHER REMEDY OTHER THAN AS SET FORTH HEREIN, REGARDLESS OF THE CLAIM OR CAUSE OF ACTION, WHETHER BASED IN CONTRACT, TORT, NEGLIGENCE, GOODS LIABILITY, STRICT LIABILITY OR OTHERWISE.

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10. **SEVERABILITY.** The partial or complete invalidity of any provision of these Standard Terms and Conditions shall not affect the enforceability of the remainder of these Standard Terms and Conditions. If any provision is found to be invalid or unenforceable, that portion shall be modified to make it enforceable or shall be stricken and the remainder of these Standard Terms and Conditions shall enforced.
11. **GOVERNING LAW AND JURISDICTION.** Any controversy arising out of any quotation, the purchase order, the goods sold or delivered, repair or replacement thereof, or any services provided pursuant to any quotation or any purchase order, or these Standard Terms and Conditions shall be governed by the laws of the state of Tennessee without regard to any choice of law provisions and any cause of action related in any manner thereto shall be brought only in the state or federal courts of Shelby County, Tennessee.
12. **ABANDONED EQUIPMENT.** Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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.
14. **NONWAIVER.** No course of dealing or failure of either party to strictly enforce any term, right, or condition of these Standard Terms and Conditions will be construed as a waiver of such term, right or condition. Any waiver by Hi-Speed will only be in writing and will waive no succeeding breach of a term, right or condition.
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16. **NO INDIVIDUAL LIABILITY.** Notwithstanding any other agreement to the contrary, the Buyer agrees that in no event will the Buyer hold and Hi-Speed owner, director, officer or employee personally liable for unintentional tortious conduct or conduct that constitutes the breach of any contract between Hi-Speed and the Buyer, even if the Hi-Speed owner, director, officer or employee is or could be construed to be a party to such contract.