



**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

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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: 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

Rewind: Yes

Shaft Machined Fit Repairs  
Required: No

Bearing Housing Machined  
Fit Repairs Required: Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 2 - High ● 9 - Good

### Overall Condition

1. Report Date

04/12/2024

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1.0

## 2. Nameplate Picture



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





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1.2



4. Describe the Overall Condition of the Equipment as Received

*Dirty*

#### Initial Mechanical/Electrical

5. Does Shaft Turn Freely?	(Y) Yes
6. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
7. Does Shaft Have Visible Damage?	(No) No



8. Assembled Shaft Runout	0 Inches
9. Assembled Shaft End Play	inches
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

15. Stator Temperature Detector Rating and Function

Quantity

Rating

Quantity Passed

Na

16. Bearing Temperature Detector Rating and Function

Quantity

Rating

Quantity Passed

Na

17. Frame Condition

pass

18. Fan Condition

(N) NA

19. Broken or Missing Components

None

### Initial Electrical Inspection

20. Insulation Resistance/Megger

15 Megohms

21. Winding Resistance

1-2

1-3

2-3

0.1018

0.144

0.246




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22. Perform Surge Test	(F) Fail
 <b>Rewind</b>	



23. Number of Stator Slots	48
24. Stator Condition	Rewind turn to turn short



25. Stator Thermistors/Ohms	
 <b>Na</b>	
26. Stator Overloads/Ohms	
 <b>Na</b>	
<b>Mechanical Inspection</b>	
27. Drive End Bearing Brand	Peer
28. Drive End Bearing Number-	6313
29. Drive End Bearing Qty.	1
30. Drive End Bearing Type	(Ball) Ball Bearing
31. Drive End Lubrication Type	(Grease) Grease Lubricated
32. Drive End Bearing Insulation or Grounding Device?	
 <b>Na</b>	
33. Drive End Wavy Washer/Snap-Ring Other Retention Device?	na

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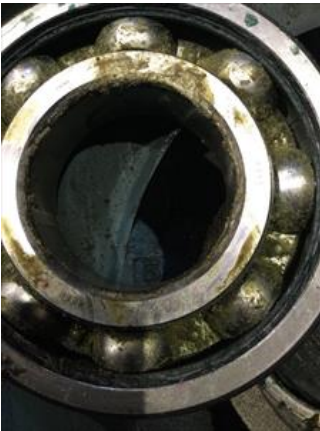
34. Drive End Bearing Condition


axial load



35. Opposite Drive End Bearing Brand

Peer



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



43. Drive End Seal

Na

44. Opposite Drive End Seal

Na

### Rotor Inspection

45. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast



46. Growler Test

(Pass) Pass

47. Number of Rotor Bars

38

48. Rotor Condition

dirty needs washed

49. List the Parts needed for the Repair Below

2-6313 bearings

50. Signature of Technician that Disassembled Motor

### Mechanical Fits- Rotor

51. Shaft Runout

0.0003 inches

52. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

Na

53. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

Na

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54. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
Na			
55. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.56	2.56559	2.56	
56. Drive End Bearing Shaft Fit Condition			(P) Pass



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



59. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Na			
<b>Mechanical Fits- Bearing Housings</b>			
60. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.5135	5.5135	5.5135	

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61. Drive End - Endbell Bearing Fit Condition

(F) Fail



62. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

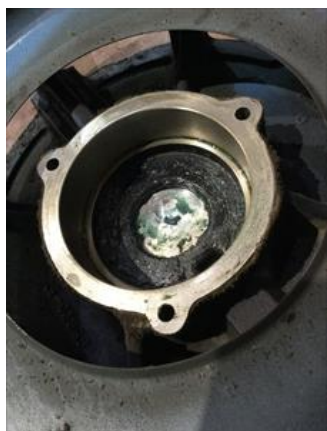
5.513

5.513

5.513

63. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass



64. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass

pass

65. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

66. List Machine Work Needed Below

*De end bell bearing fit bad*

67. Technician

RW



Co witness: CRW

Root Cause of Failure

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68. Failure locations  
*Connection end bottom side of winding close to the iron*

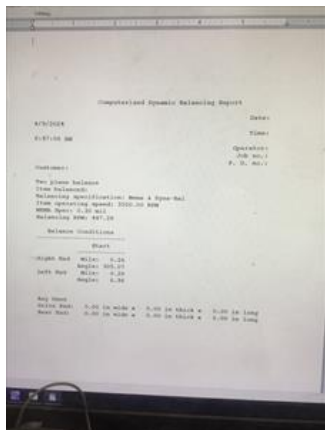
69. Root cause of failure  
*Dirty*

### Dynamic Balance Report

70. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



71. Initial Balance Readings

Drive End

Opposite Drive End

.26

.20

72. Final Balance Readings

Drive End

Opposite Drive End

.26

.20

73. Technician

David Maclin

### Rewind

74. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

na

na

75. Core Hot Spot Test

Pre-Burnout

Post-Burnout

na

na

76. Post Rewind Electrical Test- Insulation Resistance

2000 Megohms

77. Post Rewind Polarization Index

0 Polarization Index

78. Post Rewind Winding Resistance

1-2

1-3

2-3

0

0

0

79. Post Rewind Surge Test

(Pass) Pass

80. Post Rewind Hi-Pot

0 micro-amps

81. Technician

David Maclin



### Mechanical Fits- Bearing Housings - Post Repair

82. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

0

0

0

83. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

0

0

0

84. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

0

0

85. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

0

0

86. End Bell Repair Sign-off

David Mackin



### Assembly

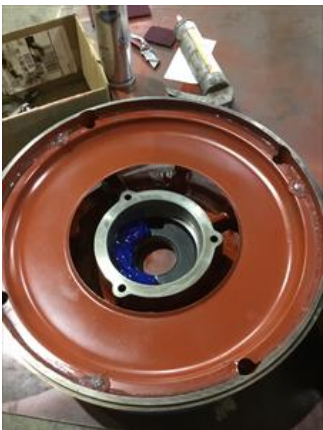
87. QC Check All Parts for Cleanliness Prior to Assembly

David Maclin





88. Photograph All Major Components prior to assembly



89. Final Insulation Resistance Test	2000 Megohms
90. Assembled Shaft Endplay	0 inches
91. Assembled Shaft Runout	0 inches

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## 92. Test Run Voltage

Volts

461

Volts

459

Volts

460

Y test witnessed by G Moore Delta test witnessed by David Williams



## 93. Test Run Amperage

Amps

25.2

Amps

26.5

Amps

25.6

## 94. Drive End Vibration Readings - Inches Per Second

Horizontal

0.04

Vertical

0.05

Axial

0.02

BRGDW

## 95. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

0.04

Vertical

0.04

Axial

0.01

## 96. Ambient Temperature - Fahrenheit

70

## 97. Drive End Bearing Temps - Fahrenheit

5 Minutes

70

10 Minutes

70

15 Minutes

70

## 98. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

70

10 Minutes

70

15 Minutes

70

## 99. Document Final Condition with Pictures after paint

looks new

## 100. Final Pics and QC Review

David Maclin

Checked by Chris Wiley





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

## AC Random Coil Rewind Report

FolderID: 102676  
FormID: 19918113

Sage V Foods  
5901 SLOAN DRIVE  
LITTLE ROCK, AR 72206  
MOTOR SHOP LR  
Priorities Found: ● 1 - Good

### General

1. Job Number	102676
2. Report Date	
3. Customer	sage foods



### Stator Winding

4. Core Length	6.875 "
5. Core ID	8.625 "
6. Back Iron Depth	2 "
7. Slot Depth	1.25 "
8. Tooth Width	0.228 "
9. Number of Vents	0
10. Vent Width	0 "
11. Before Burnout Core loss	<span style="color: gray;">■</span> Na
12. Flux Before Burnout	<span style="color: gray;">■</span> Na
13. Watts before burnout	Watts
<span style="color: gray;">■</span> Na	
14. Watts loss per lb. before burnout	W/lbs.
<span style="color: gray;">■</span> Na	
15. After Burnout Core Loss	<span style="color: gray;">■</span> Na
16. Flux After burnout	<span style="color: gray;">■</span> Na

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17. Watts After Burnout	Watts
Na	
18. Watts loss per lb After Burnout	W/lbs.
Na	
19. Core Iron Condition	
20. RTD's	
Na	
21. RTD's Reading	Ohm's
Na	
22. Motor Heaters	
Na	
23. Heater Qty.	
Na	
24. Heater Voltage	Volts
Na	
25. Heater Wattage	Watts
Na	
26. Thermistors	
Na	
27. Number of Poles	2
28. Slots	48
29. Number of Coils	36
30. Coil Weight	Lbs.
98	
31. Lead Markings	
1-12	
32. Grouping	
6of6	
33. Multiple Wires	
2	
34. Wire Size	
9#16 4#17	
35. Turns per coil	
4-5-4-5-9-8	
36. Pitch 1 to:	
14-16-18-20-22-24	
37. Connection	
1&2cir	
38. Lead Length	14 "
39. Lead Size	4
40. Number of Leads	12
41. Megger Reading After Rewind	Mohms





42. Coil Machine Slot

Na

43. Coil Machine Tip

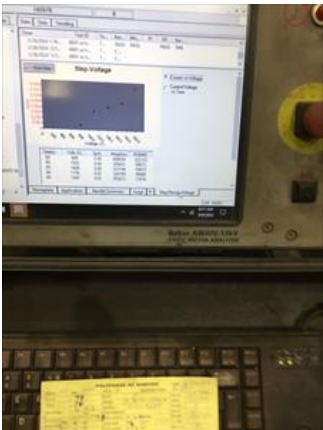
Na

44. Coil Machine Pitch

Na

45. Hi Pot Reading After Rewind

Ua



46. Surge Pattern After Rewind





47. Service Technician

RHR ZTW

A handwritten signature in black ink, appearing to read 'RHR ZTW', is written across the top of the page.



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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.
15. **ASSIGNMENT.** The rights and obligations of the parties shall neither be assigned nor delegated without the prior written consent of the other party. However, any party may assign or delegate its respective rights and obligations, in whole or in part, (i) to any subsidiary, (ii) pursuant to other financing, merger or reorganization or (iii) pursuant to any sale or transfer of substantially all of the assets of the assigning party. These Standard Terms and Conditions shall bind the heirs, successors and assigns of the parties hereto.
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.