



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

LR Motor Shop Repairs

Job Number 103036

Prepared for Sage V Foods

5901 SLOAN DRIVE
LITTLE ROCK AR 72206

Table of Contents

AC Inspection as Found - <i>MOTOR SHOP LR</i>	AC Inspection - Rev. 2	1.0
AC Random Coil Rewind Report - <i>MOTOR SHOP LR</i>		2.0



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: 103036
FormID: 20513811

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: 25HP BALDOR- NO NAMEPLATE DATA

Hi-Speed Job Number: 103036

Manufacturer: Baldor

Serial Number: EM4108T

HP/kW: 25 (HP)

Frame: 284T

Voltage: 230 / 460

Current: 62/31 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

of Leads: 9

J-box Included: Complete

Coupling/Sheave: None

Date Received: 05/29/2024

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: Yes

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: ● 4 - High

● 1 - Low

● 7 - Good

Overall Condition

1. Report Date

06/07/2024

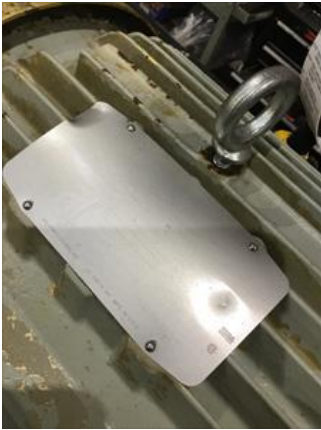
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1.0

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






Weathered

Initial Mechanical/Electrical

<input checked="" type="radio"/>	5. Does Shaft Turn Freely?	(N) No
<input checked="" type="radio"/>	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	Inches
<input type="checkbox"/>	<i>Na</i>	
	9. Assembled Shaft End Play	inches
<input type="checkbox"/>	<i>Na</i>	
	10. Air Gap Variation <10%	
<input type="checkbox"/>	<i>Na</i>	
<input checked="" type="radio"/>	11. Lead Condition	(NA) Not Applicable
<input type="checkbox"/>	<i>Rewind</i>	
	12. Lead Length	14 Inches
<input checked="" type="radio"/>	13. Does it have Lugs?, If so what is the Stud Size?	(No) No
	14. Lead Numbers	1-9
	15. Frame Condition	pass
<input checked="" type="radio"/>	16. Fan Condition	(P) Pass
<input checked="" type="radio"/>	17. Broken or Missing Components	
<input type="checkbox"/>	<i>Two fan cover bolts are missing and the two that are still in place has wear recommend replacing</i>	

Initial Electrical Inspection

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18.	Insulation Resistance/Megger	Megohms	
	Na		
19.	Winding Resistance		
	1-2	1-3	2-3
	Na		
	20.	Perform Surge Test	(NA) Not Applicable
	Shored in slot		
21.	Number of Stator Slots	48	
	22.	Stator Condition	minor core damage possible
23.	Stator Thermistors/Ohms	na	
24.	Stator Overloads/Ohms	na	
Mechanical Inspection			
25.	Drive End Bearing Brand	SKF	
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	cage failed



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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	
<input type="checkbox"/> <i>Signs of frosting</i>	



41. Drive End Seal	
<input type="checkbox"/> <i>Na</i>	
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	42
46. Rotor Condition	pass
47. List the Parts needed for the Repair Below	
6311 6309 <i>Recommend aegis ring</i>	

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48. Signature of Technician that Disassembled Motor

Cw



Mechanical Fits- Rotor

49. Shaft Runout 0.03 inches

50. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

Na

51. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

Na

52. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

Na

53. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.1658

2.1656

2.1657

54. Drive End Bearing Shaft Fit Condition (P) Pass

55. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.7722

1.7722

1.7722

56. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

57. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

Mechanical Fits- Bearing Housings

58. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

4.7254

4.725

4.7249

59. Drive End - Endbell Bearing Fit Condition (P) Pass

60. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

3.9379

3.9375

3.9377

61. Opposite Drive End - Endbell Bearing Fit Condition (P) Pass

62. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

Pass

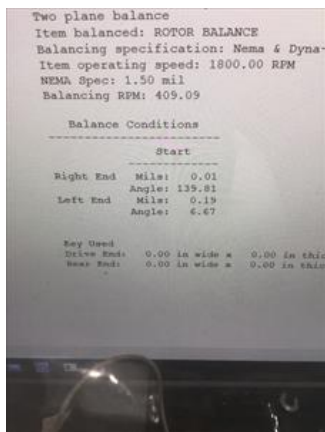
63.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
	<div>Na</div>		
64.	List Machine Work Needed Below		
	Na		
65.	Technician		Cw
	<div></div>		
	<div>Co sign:TH</div>		
Root Cause of Failure			
66.	Failure locations		
	Windings and bearings		
67.	Root cause of failure		
	DE bearing cage failed causing rotor to drop and drag iron and damaging windings causing windings to short to ground		
Dynamic Balance Report			
68.	Rotor Weight and Balance Grade		
	Rotor Weight	Balance Grade	
69.	Initial Balance Readings		
	Drive End	Opposite Drive End	

Item operating speed: 1800.00 RPM			
NEMA Spec: 1.50 mil			
Balancing RPM: 409.09			
Balance Conditions			
Start			
Right End	Mils:	0.01	
	Angle:	139.81	
Left End	Mils:	0.19	
	Angle:	6.67	
Key Used			
Drive End:	0.00 in wide x	0.00 in	
Rest End:	0.00 in wide x	0.00 in	

70. Final Balance Readings

Drive End

Opposite Drive End



71. Technician

Cw

Rewind

72. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

73. Core Hot Spot Test

Pre-Burnout

Post-Burnout

74. Post Rewind Electrical Test- Insulation Resistance

Megohms

75. Post Rewind Polarization Index

Polarization Index

76. Post Rewind Winding Resistance

1-2

1-3

2-3

77. Post Rewind Surge Test

78. Post Rewind Hi-Pot

micro-amps

79. Technician

Assembly

80. QC Check All Parts for Cleanliness Prior to Assembly

Cw

81. Photograph All Major Components prior to assembly



82. Final Insulation Resistance Test

Megohms

Pass

83. Assembled Shaft Endplay

inches

84. Assembled Shaft Runout

inches

85. Test Run Voltage

Volts

Volts

Volts



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86. Test Run Amperage

Amps

Amps

Amps



87. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.03**0.04****0.01**

88. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.03**0.03****0.04**

89. Ambient Temperature - Fahrenheit

90. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

91. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

92. Document Final Condition with Pictures after paint



93. Final Pics and QC Review

Cw



Co sign: David M.




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

AC Random Coil Rewind Report

FolderID: 103036
FormID: 20721715

Sage V Foods
5901 SLOAN DRIVE
LITTLE ROCK, AR 72206

MOTOR SHOP LR

Priorities Found:  **2 - Good**

General

1. Job Number
2. Report Date
3. Customer

Stator Winding

4. Core Length
5. Core ID
6. Back Iron Depth
7. Slot Depth
8. Tooth Width
9. Number of Vents
10. Vent Width
11. Before Burnout Core loss
12. Flux Before Burnout
13. Watts before burnout
14. Watts loss per lb. before burnout
15. After Burnout Core Loss
16. Flux After burnout
17. Watts After Burnout
18. Watts loss per lb After Burnout
-  19. Core Iron Condition
20. RTD's
21. RTD's Reading
22. Motor Heaters
23. Heater Qty.
24. Heater Voltage
25. Heater Wattage
26. Thermistors
27. Number of Poles **4**
28. Slots **48**
29. Number of Coils **48**
30. Coil Weight **48 Lbs.**
31. Lead Markings
1-9
32. Grouping
12-4

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33. Multiple Wires	(Y) Yes
6	
34. Wire Size	
17	
35. Turns per coil	9
36. Pitch 1 to:	12
37. Connection	
1&2d	
38. Lead Length	12 "
39. Lead Size	10
40. Number of Leads	
41. Megger Reading After Rewind	
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	
46. Surge Pattern After Rewind	
47. Service Technician	
	



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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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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.
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.
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