



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

LR Motor Shop Repairs

Job Number 102314

Prepared for Saint Jean Industries, Inc. (11653)

424 Industrial Park Road
Heber Springs AR 72543

Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: 3693

1.0

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7030 Ryburn Dr
Millington, Tn 38053
901-873-5300

AC Inspection as Found
Saint Jean Industries, Inc. (11653)
424 Industrial Park Road
Heber Springs, AR 72543

FolderID: 102314
FormID: 18971882

AC Inspection - Rev. 2

Location: MOTOR SHOP LR
Serial Number: 3693
Description: 37KW NANJING BLOWER 900RPM
280

Hi-Speed Job Number:	102314
Manufacturer:	Other
Product Number:	YLF280-8T
Serial Number:	3693
HP/kW:	37 (kW)
RPM:	735 (RPM)
Frame:	280
Voltage:	460
Current:	72.8
Phase:	Three
Hz:	60 (Hz)
Enclosure:	TEFC
J-box Included:	None
Coupling/Sheave:	Propeller
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 10 - High ● 4 - Good

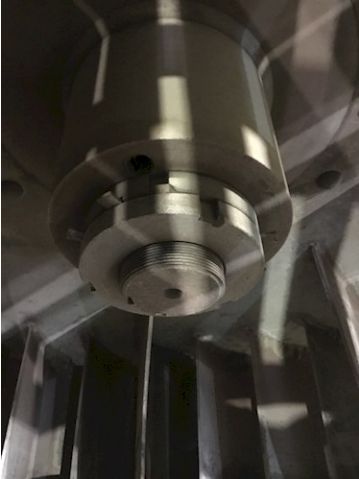
Overall Condition

1. Report Date
2. Nameplate Picture



3. Photos of all six sides of the machine.

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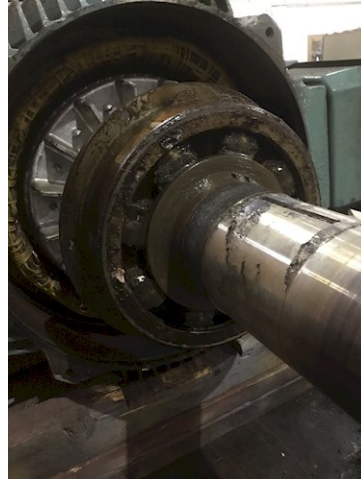
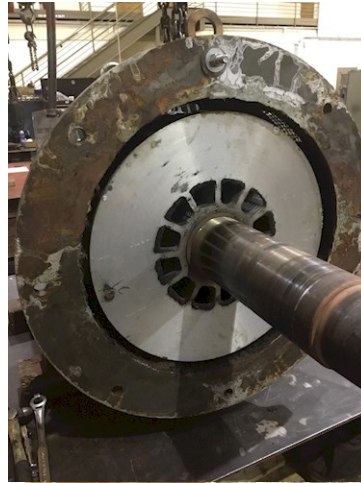


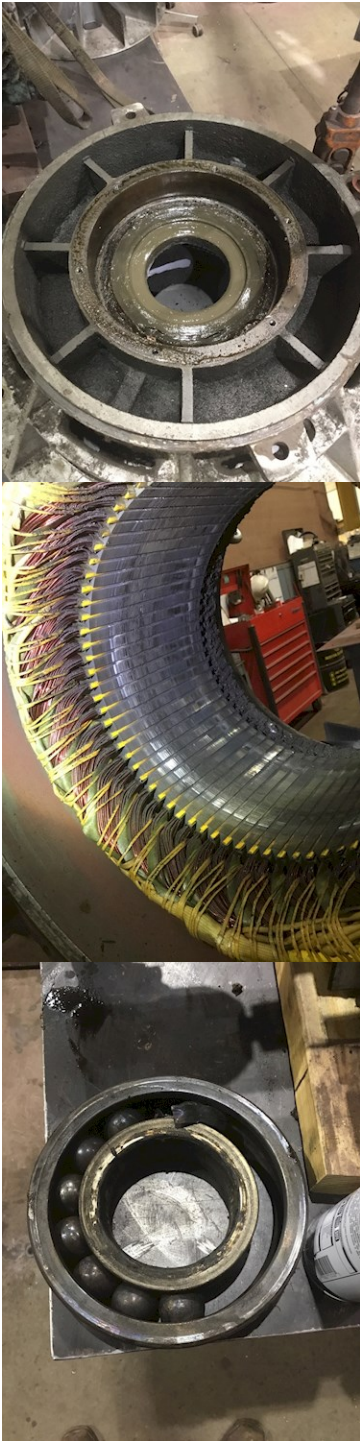
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1.2





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1.5



4.	Describe the Overall Condition of the Equipment as Received	
	<i>Dirty</i>	
5.	Distance from the end of the shaft to the Coupling/Sheave	inches
	<i>N/A</i>	
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	(No) No
7.	Does the shaft require T.I.R in Lathe to identify additional repairs?	
8.	Does Shaft Have Visible Damage?	(No) No
9.	Assembled Shaft Runout	Inches
	<i>N/A</i>	
10.	Assembled Shaft End Play	inches
	<i>N/A</i>	
11.	Air Gap Variation <10%	
	<i>N/A</i>	
12.	Lead Condition	(NA) Not Applicable
	<i>Rewind</i>	
13.	Lead Length	8 Inches
14.	Does it have Lugs?, If so what is the Stud Size?	
15.	Lead Numbers	w1-V1-U1/W2-V2-U2



16.	Frame Condition	pass
-----	-----------------	------

17. Fan Condition

(P) Pass



18. Broken or Missing Components

n/a

Initial Electrical Inspection

19. Insulation Resistance/Megger

Megohms

N/a

20. Winding Resistance

1-2

1-3

2-3

N/a

21. Perform Surge Test

(F) Fail

Windings blown

22. Number of Stator Slots

72

23. Stator Condition

core damage

24. Stator Thermistors/Ohms

N/a

25. Stator Overloads/Ohms

N/a

Mechanical Inspection

26. Drive End Bearing Brand

nsk

27. Drive End Bearing Number-

6324

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?

Na

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

Na

33. Drive End Bearing Condition

signs of contamination and frosting



- | | |
|--|---|
| 34. Opposite Drive End Bearing Brand | na |
| 35. Opposite Drive End Bearing Number- | 6317 |
| 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? | na |
| 40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? | na |
| 41. Opposite Drive End Bearing Condition | bearing cage failed causing bearing to wipe out |



- | | |
|-----------------------------|----|
| 42. Drive End Seal | na |
| 43. Opposite Drive End Seal | na |

Rotor Inspection

- | | |
|--|---|
| 44. Rotor Type/Material | (Squirrel Aluminum) Squirrel Cage Aluminum Die Cast |
| 45. Growler Test | (Pass) Pass |
| 46. Number of Rotor Bars | 58 |
| 47. Rotor Condition | needs cleaned |
| 48. List the Parts needed for the Repair Below | |
| 6324
6317
Bearing sleeves | |

49. Signature of Technician that Disassembled Motor

Cw



Mechanical Fits- Rotor

50. Shaft Runout 0.001 inches

51. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

Na

52. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

Na

53. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

Na

54. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

4.7251

4.725

4.7251

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

56. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.3472

3.3472

3.3471

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

58. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

Mechanical Fits- Bearing Housings

59. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

10.2384

10.238

10.2375

Severely pitted

60. Drive End - Endbell Bearing Fit Condition (F) Fail

61. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

Major lip worn in bearing fit un able to take accurate measurements

62. Opposite Drive End - Endbell Bearing Fit Condition (F) Fail

63. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

 Pass

64. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

 Na

65. List Machine Work Needed Below

Both end bell bearing fits and ODE shaft bearing fit needs polished

66. Technician

Cw

Root Cause of Failure

67. Failure locations

Bearings and end bell bearing fits and windings and core

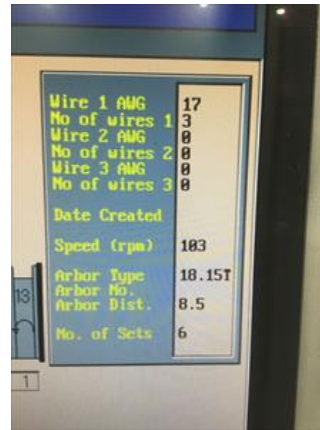
68. Root cause of failure

*ODE bearing cage failed causing bearing to lock up taking out the end bell bearing fit making rotor drag iron taking out the windings.**Possible cause of bearing failure is the mixing of incompatible greases*

Dynamic Balance Report

78. Post Rewind Surge Test

(Pass) Pass



79. Post Rewind Hi-Pot

micro-amps

Na

80. Technician

Mechanical Fits- Rotor - Post Repair

81. Shaft Runout Post Repair

0 inches

82. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0

0

0

83. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

0

0

0

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

0 Degrees

60 Degrees

120 Degrees

0

0

0

85. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

0

0

0

86. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees


120 Degrees

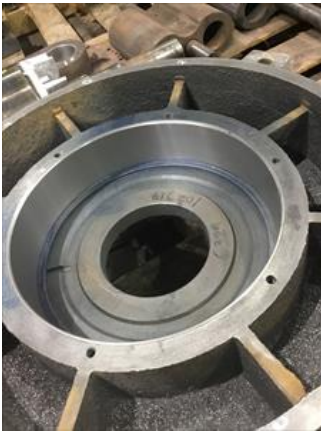
0

0

0

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87. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
ok	ok	
88. Shaft Repair Sign-off		David Maclin
		
Mechanical Fits- Bearing Housings - Post Repair		
89. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
10.2367	10.2366	1.2367



90. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
7.0867	7.0868	7.0868



91. Bearing Cap Condition Post Repair	
Drive End Bearing Cap	Opposite Drive End Bearing Cap
ok	ok
92. End Bell Air Seal Fits Post Repair	
Drive End Air Seal	Opposite Drive End Air Seal
ok	ok

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93. End Bell Repair Sign-off

Gary



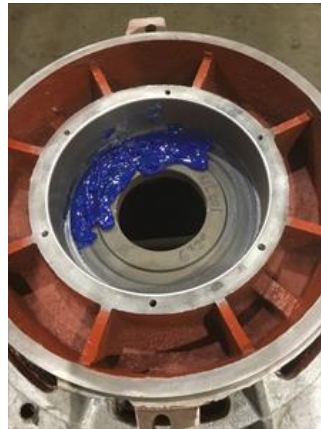
Assembly

94. QC Check All Parts for Cleanliness Prior to Assembly

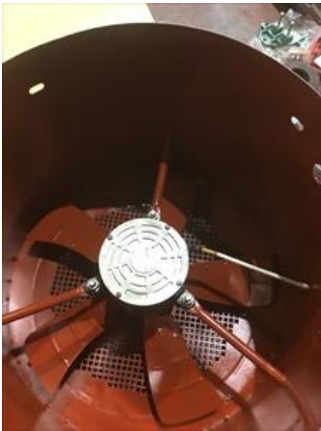
Davidmaclin



95. Photograph All Major Components prior to assembly







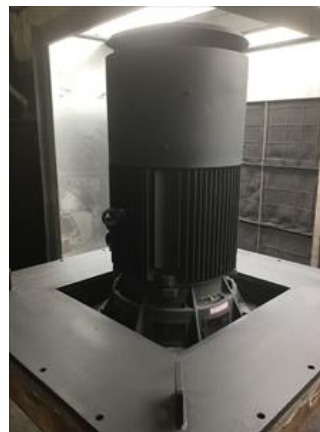
96. Final Insulation Resistance Test	2000 Megohms	
97. Assembled Shaft Endplay	0 inches	
98. Assembled Shaft Runout	0 inches	
99. Test Run Voltage		
Volts	Volts	Volts
460	460	460
Witnessed by Chris Wiley		
100. Test Run Amperage		
Amps	Amps	Amps
17.6	17.6	17.8
101. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.0545	0.0234	0.0182
102. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.0546	0.0675	0.0139
103. Ambient Temperature - Fahrenheit	70	
104. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
70	70	70
105. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes

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106. Document Final Condition with Pictures after paint

clean

107. Final Pics and QC Review







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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.
3. **SCOPE OF GOODS AND/OR SERVICES.** The goods and/or services provided by Hi-Speed pursuant to any quotation shall be limited exclusively to those goods and/or services expressly identified therein. Hi-Speed does not assume any responsibility and/or liability for the failure to provide any other goods and/or services not identified in any quotation. Modifications, additions or deletions to or from the scope referenced in any quotation shall only be effective if evidenced in writing and signed by Hi-Speed. The sale of any of all goods and/or services affected by such modification, addition or deletion shall be subject to these same Standard Terms and Conditions whether or not referenced therein.
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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9. **LIMITATION OF DAMAGES.** HI-SPEED SHALL HAVE NO LIABILITY TO BUYER WITH RESPECT TO THE SALE OR DELIVERY OF ANY GOODS OR THE REPAIR THEREOF OR WITH RESPECT TO THE SALE OR PERFORMANCE OF ANY SERVICES, FOR LOST PROFITS, SPECIAL, CONSEQUENTIAL, EXEMPLARY, PUNITIVE OR INCIDENTAL DAMAGES OF ANY KIND OR NATURE WHETHER ARISING IN CONTRACT, TORT, GOODS LIABILITY OR OTHERWISE, EVEN IF HI-SPEED WAS ADVISED OF THE POSSIBILITY OF SUCH LOSS OR DAMAGES. HI-SPEED SHALL NOT BE LIABLE FOR ANY DAMAGES OR DELAYS CAUSED BY ANY FAILURE TO MAKE ANY DELIVERY OF GOODS BY ANY EXPECTED TIME OR DATE OR THE FAILURE TO PROVIDE OR COMPLETE ANY SERVICES BY ANY EXPECTED DATE OR TIME. IN NO EVENT SHALL HI-SPEED BE LIABLE TO BUYER FOR ANY DAMAGES WHATSOEVER IN EXCESS OF THE TOTAL PRICE PAID FOR ALL GOODS AND/OR SERVICES HEREUNDER OR REFERENCED IN ANY QUOTATION OR THE PURCHASE ORDER.
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.
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.