



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

LR Motor Shop Repairs

Job Number 102518

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

1.0

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Printed on 5/29/2024

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Millington, Tn 38053
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AC Inspection as Found
Saint Jean Industries, Inc. (11653)
424 Industrial Park Road
Heber Springs, AR 72543

FolderID: 102518
FormID: 19474261

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: Blower

Hi-Speed Job Number: 102518

of Leads: Other

J-box Included: None

Coupling/Sheave: Sheave

Date Received: 05/29/2024

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: No

Shaft Machined Fit Repairs
Required: Yes

Bearing Housing Machined
Fit Repairs Required: Yes

Heaters: No

Bearing Type: Rolling Element

Priorities Found: ● 3 - High ● 5 - Good

Overall Condition

1. Report Date
2. Nameplate Picture



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1.1





3. Photos of all six sides of the machine.



4. Describe the Overall Condition of the Equipment as Received

Filthy

5. Distance from the end of the shaft to the Coupling/Sheave


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?	(Yes) Yes
9. Assembled Shaft Runout	0 Inches
10. Assembled Shaft End Play	0 inches
11. Air Gap Variation <10%	na
12. Lead Condition	(NA) Not Applicable
13. Lead Length	0 Inches
14. Does it have Lugs?, If so what is the Stud Size?	(No) No
15. Lead Numbers	na
16. Frame Condition	good
17. Fan Condition	(F) Fail
2 blades damaged	
18. Broken or Missing Components	none

Initial Electrical Inspection

19. Insulation Resistance/Megger	Megohms
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20. Winding Resistance	1-2	1-3	2-3
21. Perform Surge Test			
22. Number of Stator Slots			
23. Stator Condition			
24. Stator Thermistors/Ohms			
25. Stator Overloads/Ohms			
Mechanical Inspection			
26. Drive End Bearing Brand			SKF
27. Drive End Bearing Number-			6318
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			failed
34. Opposite Drive End Bearing Brand			SKF
35. Opposite Drive End Bearing Number-			6318
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			dry wear
42. Drive End Seal			na
43. Opposite Drive End Seal			na
Rotor Inspection			
44. Rotor Type/Material			
45. Growler Test			
46. Number of Rotor Bars			
47. Rotor Condition			
48. List the Parts needed for the Repair Below			
			6318 2Z, 6318 2Z.
49. Signature of Technician that Disassembled Motor			David Maclin
			
Mechanical Fits- Rotor			
50. Shaft Runout			inches
51. Rotor Runout			
Drive End Bearing Fit	Rotor Body		Opposite Drive End Bearing
52. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees		120 Degrees

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53. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
54. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
55. Drive End Bearing Shaft Fit Condition		
56. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
57. Opposite Drive End Bearing Shaft Fit Condition		
58. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings		
59. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
7.4803	7.4804	7.4803
60. Drive End - Endbell Bearing Fit Condition		(P) Pass
61. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
7.484	7.486	7.487
62. Opposite Drive End - Endbell Bearing Fit Condition		(F) Fail
63. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	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>Machine new shaft, sleeve ODE bearing housing, repair or replace 2 fan blades.</i>		



Replaced broken support bar.



Repaired bent blades.



Root Cause of Failure

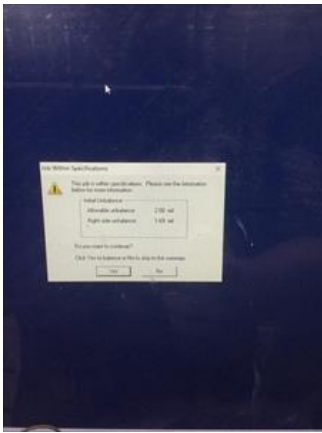
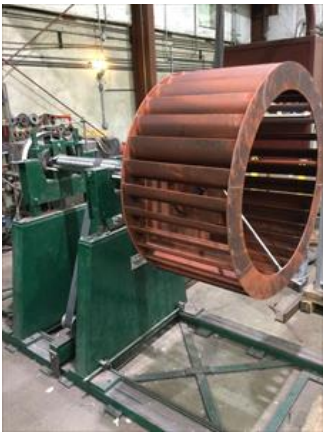
67. Failure locations
De bearing

68. Root cause of failure
Heat, loss of lubrication.

Dynamic Balance Report

69. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade
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70. Initial Balance Readings

Drive End	Opposite Drive End
1.69	

71. Final Balance Readings

Drive End	Opposite Drive End
1.69	




Mechanical Fits- Rotor - Post Repair

73. Shaft Runout Post Repair

0.001 inches



74. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

75. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

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

0 Degrees

60 Degrees

120 Degrees

77. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

3.544

3.544

3.5439

78. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees


120 Degrees

3.544


3.544

3.544

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79. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
3.540	3.540	
80. Shaft Repair Sign-off		
		
Mechanical Fits- Bearing Housings - Post Repair		
81. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
82. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
7.481	7.481	7.481



83. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
84. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
85. End Bell Repair Sign-off		
		
Assembly		
86. QC Check All Parts for Cleanliness Prior to Assembly		
		
87. Photograph All Major Components prior to assembly		
(Complete) Complete		

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88.	Final Insulation Resistance Test			Megohms
	Na			
89.	Assembled Shaft Endplay			inches
	Na			
90.	Assembled Shaft Runout			inches
	Na			
91.	Test Run Voltage			
	Volts	Volts	Volts	
	0			
92.	Test Run Amperage			
	Amps	Amps	Amps	
	0			
93.	Drive End Vibration Readings - Inches Per Second			
	Horizontal	Vertical	Axial	
	Na			
94.	Opposite Drive End Vibration Readings - Inches Per Second			
	Horizontal	Vertical	Axial	
	Na			
95.	Ambient Temperature - Fahrenheit			
	Na			
96.	Drive End Bearing Temps - Fahrenheit			
	5 Minutes	10 Minutes	15 Minutes	
	Na			
97.	Opposite Drive End Bearing Temps - Fahrenheit			
	5 Minutes	10 Minutes	15 Minutes	
	Na			
98.	Stator Temperatures- Fahrenheit			
	5 Minutes	10 Minutes	15 Minutes	
	Na			
99.	Document Final Condition with Pictures after paint			



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100. Final Pics and QC Review

RW



Co witness CRW



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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.
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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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.
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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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