



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

LR Motor Shop Repairs

Job Number 103526

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: *M910LT9ES0T-W22*

1.0

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Table of Contents



Hi-Speed Industrial Service
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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: 103526
FormID: 21670428

AC Inspection - Rev. 2

Location: MOTOR SHOP LR
Serial Number: M910LT9ES0T-W22
Description: 50HP Weg w/ Blower Assembly

Hi-Speed Job Number:	103526
Manufacturer:	WEG
Spec/ID #:	M: M910LT9ES20T-W22
HP/kW:	50 (HP)
RPM:	1775 (RPM)
Frame:	324/6T
Voltage:	230 / 460
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TEFC
# of Leads:	12
J-box Included:	Complete
Coupling/Sheave:	Sheave
Bearing RTDs:	No
Stator RTDs:	No
Rewind:	No
Shaft Machined Fit Repairs Required:	Yes
Bearing Housing Machined Fit Repairs Required:	No
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

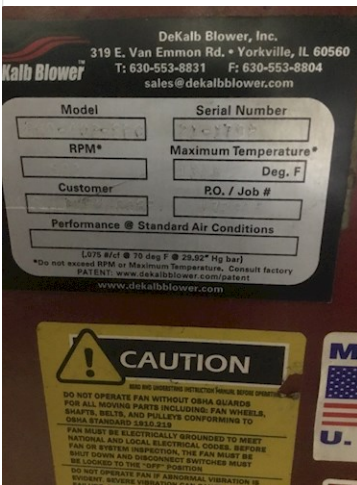
Priorities Found: 3 - High 3 - Low 11 - Good

Overall Condition

1. Report Date	09/26/2024
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2. Nameplate Picture



3. Photos of all six sides of the machine.



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1.2





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1.4





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1.6



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
6.	Report Date [COPY]	
Initial Mechanical/Electrical		
7.	Does Shaft Turn Freely?	
	<i>Stator shaft turns free</i> <i>Fan shaft does not turn free</i>	
8.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No

9. Does Shaft Have Visible Damage?

*Stator shaft has no visible damage
Fan shaft has visible damage*



10. Assembled Shaft Runout **Inches**

11. Assembled Shaft End Play **inches**

12. Air Gap Variation <10%

13. Lead Condition **(P) Pass**

14. Lead Length **8 Inches**

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

Yes



16. Lead Numbers **T1-T12**

17. Frame Condition **pass**

18. Fan Condition **(P) Pass**

19. Broken or Missing Components

Flange bolts are broke on pedestal



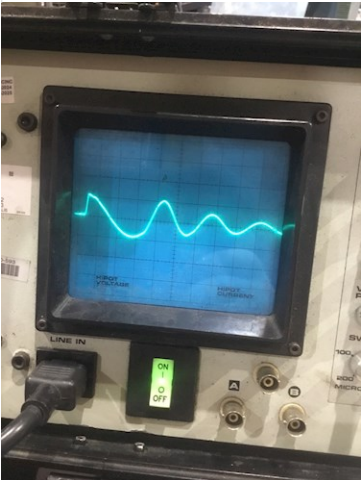
Initial Electrical Inspection

20. Insulation Resistance/Megger	Megohms
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21. Winding Resistance		
1-2	1-3	2-3

22. Perform Surge Test	(P) Pass
------------------------	----------



23. Number of Stator Slots	48
24. Stator Condition	pass
25. Stator Thermistors/Ohms	
26. Stator Overloads/Ohms	

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Mechanical Inspection

27. Drive End Bearing Brand	nsk
28. Drive End Bearing Number-	6312
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?	
33. Drive End Wavy Washer/Snap-Ring Other Retention Device?	
34. Drive End Bearing Condition	

Contamination




35. Opposite Drive End Bearing Brand	skf
36. Opposite Drive End Bearing Number-	6212
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?	
41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
42. Opposite Drive End Bearing Condition	


Frosting

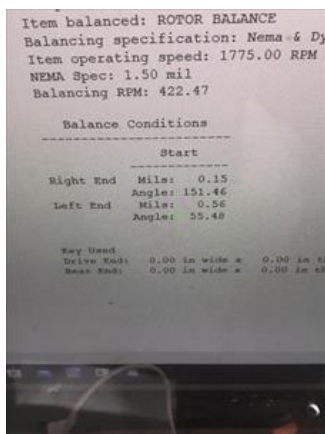


43. Drive End Seal	slinger
Fail	

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44. Opposite Drive End Seal	slinger		
Fail			
Rotor Inspection			
45. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast		
46. Growler Test	(Pass) Pass		
47. Number of Rotor Bars	40		
48. Rotor Condition	pass		
49. List the Parts needed for the Repair Below <i>Seal master: 9.145.920 B2 x2 bearings</i> <i>Fan shaft 3.1772" width, 64" long</i> 6312 6212 <i>Aegis ring: 2.8176</i>			
50. Signature of Technician that Disassembled Motor	Cw		
			
Mechanical Fits- Rotor			
51. Shaft Runout	millimeters		
Fan shaft is bent 0.040			
52. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
53. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
54. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
55. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.3628	2.3627	2.3627	
56. Drive End Bearing Shaft Fit Condition	(P) Pass		
57. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.3625	2.3625	2.3625	
58. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass		
59. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Mechanical Fits- Bearing Housings			
60. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.1187	5.1185	5.1186	
61. Drive End - Endbell Bearing Fit Condition	(P) Pass		

62. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
4.331	4.331	4.331
63. Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
64. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
65. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
66. List Machine Work Needed Below <i>New fan shaft</i>		
67. Technician		Cw
		
Co sign: RRW		
Root Cause of Failure		
68. Failure locations	<i>Fan shaft, fan bearings, and motor bearings</i>	
69. Root cause of failure	<i>Fan shaft bearing failed causing shaft to bounce in housing and bend. Motor bearings have contaminants and frosting</i>	
Dynamic Balance Report		
70. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
71. Initial Balance Readings		
Drive End	Opposite Drive End	



Rotor balance

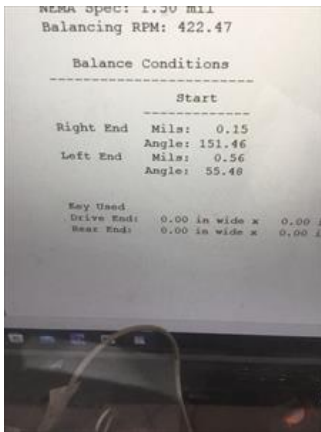


Fan balance

72. Final Balance Readings

Drive End

Opposite Drive End



Rotor balance

Fan balance

73. Technician

Cw

Mechanical Fits- Rotor - Post Repair

74. Shaft Runout Post Repair

inches



Machined new fan shaft.

75. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

76. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees


120 Degrees

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

0 Degrees

60 Degrees

120 Degrees

78. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
79. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
80. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
81. Shaft Repair Sign-off		Gary
<div>Assembly</div> <div>82. QC Check All Parts for Cleanliness Prior to Assembly</div> <div>Cw</div> <div>  </div>		
83. Photograph All Major Components prior to assembly		(Complete) Complete







84. Final Insulation Resistance Test	Megohms		
85. Assembled Shaft Endplay	inches		
86. Assembled Shaft Runout	inches		
87. Test Run Voltage			
Volts	Volts	Volts	



88. Test Run Amperage			
Amps	Amps	Amps	



89. Drive End Vibration Readings - Inches Per Second			
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Horizontal	Vertical	Axial
0.01	0.02	0.02
90. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.03	0.03	0.02
91. Ambient Temperature - Fahrenheit		
92. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
93. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
94. Document Final Condition with Pictures after paint		



95. Final Pics and QC Review

Crw

[Handwritten signature]

Co sign RRW



STANDARD TERMS AND CONDITIONS FOR PURCHASE OF GOOD AND/OR SERVICES

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

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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.
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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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