



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

LR Motor Shop Repairs

**Job Number 102290**

Prepared for Twin Rivers

1701 Jefferson Parkway  
White Hall AR 71602

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AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2

**1.0**

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

## AC Inspection as Found

Twin Rivers  
1701 Jefferson Parkway  
White Hall, AR 71602

FolderID: 102290  
FormID: 18944608

### AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: 250 HP TECO

Manufacturer: TECO Westinghouse

Product Number: AFHP-UW

Spec/ID #: KPF2504

Serial Number: ZG.FC21C525T1-1

HP/kW: 250 (HP)

RPM: 1781 (RPM)

Frame: 5009B

Voltage: 2300

Current: 57 / 32.8

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

J-box Included: Complete

Repair Stage: Final

Priorities Found: ● 1 - High ● 9 - Good

### Overall Condition

1. Report Date
2. Nameplate Picture

01/09/2024

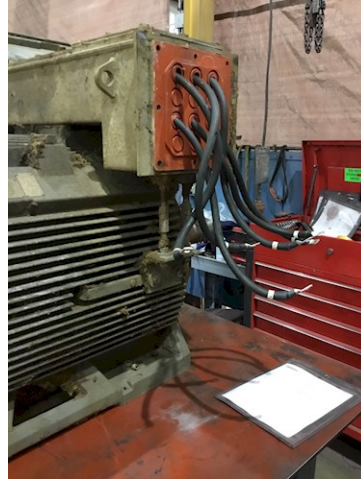
Na



3. Photos of all six sides of the machine.

Na

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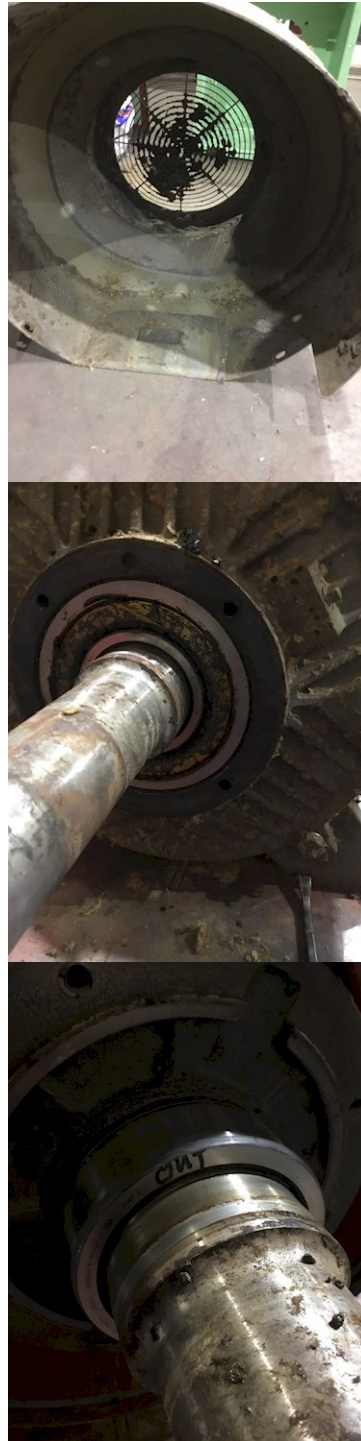
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1.1





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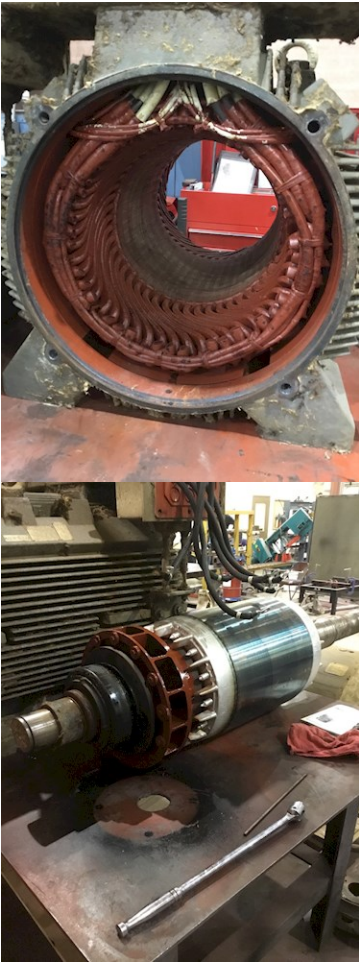


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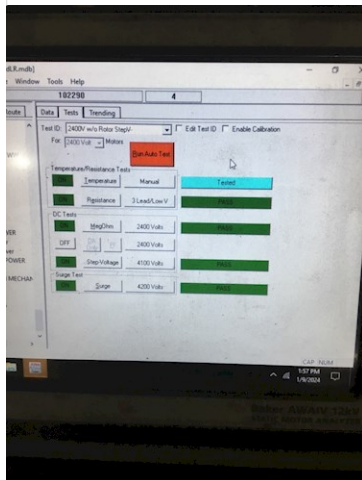




4.	Describe the Overall Condition of the Equipment as Received	
	Na	
5.	Distance from the end of the shaft to the Coupling/Sheave	inches
	Na	
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	(Yes) Yes
	Rough to turn	
7.	Does Shaft Have Visible Damage?	(No) No
8.	Assembled Shaft Runout	0 Inches

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9.	Assembled Shaft End Play	0 inches
10.	Air Gap Variation <10%	none
	11. Lead Condition	(P) Pass
12.	Lead Length	30 Inches
13.	Lead Numbers	1-6
14.	Stator Temperature Detector Rating and Function	
	Quantity	Rating
	0	Quantity Passed
15.	Bearing Temperature Detector Rating and Function	
	Quantity	Rating
	0	Quantity Passed
16.	Frame Condition	good
	17. Fan Condition	(P) Pass
18.	Heater Quantity, Ratings	
	Quantity	Volts/Watts
	0	Pass/Fail
19.	Broken or Missing Components	none
Initial Electrical Inspection		
20.	Insulation Resistance/Megger	2000 Megohms



21. Winding Resistance			
1-2	1-3	2-3	
.454	.454	.454	
22. Perform Surge Test			(P) Pass
23. Number of Stator Slots			0
24. Stator Condition			good
25. Stator Thermistors/Ohms			0
26. Stator Overloads/Ohms			0
Mechanical Inspection			

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## 27. Drive End Bearing Brand

FAG



28. Drive End Bearing Number-	NU 324	
29. Drive End Bearing Qty.	1	
30. Drive End Bearing Type	(Roller) Roller Bearing	
31. Drive End Lubrication Type	(Grease) Grease Lubricated	
32. Drive End Bearing Insulation or Grounding Device?	none	
33. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none	
34. Drive End Bearing Condition	normal	
35. Opposite Drive End Bearing Brand	FAG	
36. Opposite Drive End Bearing Number-	6320	
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?	none	
41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring	
42. Opposite Drive End Bearing Condition	fatigue	
43. Drive End Seal	none	
44. Opposite Drive End Seal	none	
45. DE Sleeve Bearing Inside Diameter		
0 degrees	120 degrees	240 degrees
0	0	0
46. DE Sleeve Bearing Outside Diameter		
0 degrees	120 degrees	240 degrees
0	0	0
47. DE Sleeve Bearing Housing Inside Diameter		
0 degrees	120 degrees	240 degrees
0	0	0
48. DE Sleeve Bearing to Housing Clearance		
0 degrees	120 degrees	240 degrees
0	0	0
49. ODE Sleeve Bearing Inside Diameter		
0 degrees	120 degrees	240 degrees
0	0	0

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50. ODE Sleeve Bearing Outside Diameter		
0 degrees	120 degrees	240 degrees
0	0	0
51. ODE Sleeve Bearing Housing Inside Diameter		
0 degrees	120 degrees	240 degrees
0	0	0
52. ODE Sleeve Bearing to Housing Clearance		
0 degrees	120 degrees	240 degrees
0	0	0
<b>Rotor Inspection</b>		
53. Rotor Type/Material		(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
54. Growler Test		(Pass) Pass
55. Number of Rotor Bars		70
56. Rotor Condition		good
57. List the Parts needed for the Repair Below <i>NU324, 6320</i>		
58. Signature of Technician that Disassembled Motor		David Maclin
		
<b>Mechanical Fits- Rotor</b>		
59. Shaft Runout		0 inches
60. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0	0	0
61. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
3.8744	3.8744	3.8743
62. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
3.8742	3.8743	3.8743
63. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
4.3315	4.3316	4.3316
64. Drive End Bearing Shaft Fit Condition	(P) Pass	
65. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
3.9375	3.9376	3.9375
66. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	
67. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
0	0	
<b>Mechanical Fits- Bearing Housings</b>		

68.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	10.237	10.2371	10.237
69.	Drive End - Endbell Bearing Fit Condition		(P) Pass
70.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	8.465	8.465	8.465
71.	Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
72.	Bearing Cap Condition		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	0	0	
73.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
	0	0	
74.	List Machine Work Needed Below		
	None		
75.	Technician		David Maclin
			
Root Cause of Failure			
76.	Failure locations		
	Fatigue in ode bearing		
77.	Root cause of failure		
	Sitting idle/ contamination		
Dynamic Balance Report			
78.	Rotor Weight and Balance Grade		
	Rotor Weight	Balance Grade	
	Na		
79.	Initial Balance Readings		
	Drive End	Opposite Drive End	
	0.92	0.74	



## 80. Final Balance Readings

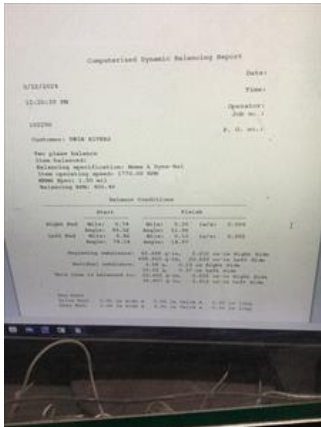
Drive End

Opposite Drive End

0.1

0.28

0.36



Without Fan

With Fan

## 81. Technician

RW

RW

## Rewind

## 82. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

Nw

## 83. Core Hot Spot Test

Pre-Burnout

Post-Burnout

Na

## 84. Post Rewind Electrical Test- Insulation Resistance

Megohms

Na

## 85. Post Rewind Polarization Index

Polarization Index

Na

## 86. Post Rewind Winding Resistance

1-2

1-3

2-3

Na

## 87. Post Rewind Surge Test

(Pass) Pass

## 88. Post Rewind Hi-Pot

micro-amps

Na

## 89. Technician










Na

## Mechanical Fits- Rotor - Post Repair

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90.	Shaft Runout Post Repair		inches
	Na		
91.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
	Na		
92.	Coupling Fit Closest to Bearing Housing Post Repair		
	0 Degrees	90 Degrees	120 Degrees
	Na		
93.	Coupling Fit Closest to the end of the Shaft Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	Na		
94.	Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	Na		
95.	Opposite Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	Na		
96.	Shaft Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
	Na		
97.	Shaft Repair Sign-off		
	Na		
Mechanical Fits- Bearing Housings - Post Repair			
98.	Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	Na		
99.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
	Na		
100.	Bearing Cap Condition Post Repair		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	Na		
101.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
	Na		
102.	DE Sleeve Bearing Inside ID Post Repair		
	Measure 1	Measure 2	Measure 3
	Na		

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103. DE Sleeve Bearing Outside ID Post Repair		
Measure 1	Measure 2	Measure 3
<div>  Na </div>		
104. DE Sleeve Bearing Inside OD Post Repair		
Measure 1	Measure 2	Measure 3
<div>  Na </div>		
105. DE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
<div>  Na </div>		
106. End Bell Repair Sign-off		
<div>  Na </div>		
107. ODE Sleeve Bearing Inside ID Post Repair		
Measure 1	Measure 2	Measure 3
<div>  Na </div>		
108. ODE Sleeve Bearing Outside ID Post Repair		
Measure 1	Measure 2	Measure 3
<div>  Na </div>		
109. ODE Sleeve Bearing Inside OD Post Repair		
Measure 1	Measure 2	Measure 3
<div>  Na </div>		
110. ODE Sleeve Bearing Outside OD Post Repair		
Measure 1	Measure 2	Measure 3
<div>  Na </div>		
<b>Assembly</b>		
111. QC Check All Parts for Cleanliness Prior to Assembly		<b>RW</b>
		



112. Photograph All Major Components prior to assembly

(Complete) Complete



113. Final Insulation Resistance Test

14,280 Megohms

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114. Assembled Shaft Endplay	inches	
Na		
115. Assembled Shaft Runout	0 inches	
116. Test Run Voltage		
Volts	Volts	Volts
2288	2290	2304



With fan



117. Test Run Amperage		
Amps	Amps	Amps

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16.5



16.1

16.3



With fan



118. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
<b>0.05</b>	<b>0.05</b>	<b>0.03</b>
119. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
<b>0.05</b>	<b>0.04</b>	<b>0.04</b>
120. Ambient Temperature - Fahrenheit		
Na		
121. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
122. Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
Na		
123. Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
Na		
124. Drive End Bearing Temps - Fahrenheit 50-60 Minutes		

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50 Minutes	55 Minutes	60 Minutes
Na		
125. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
126. Opposite Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
Na		
127. Opposite Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
Na		
128. Opposite Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
Na		
129. Stator Temperatures- Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
130. Stator Temperatures- Fahrenheit 20-30 Minutes		
20 Minutes	25 Minutes	30 Minutes
Na		
131. Stator Temperatures- Fahrenheit 35-45 Minutes		
35 Minutes	40 Minutes	45 Minutes
Na		
132. Stator Temperatures- Fahrenheit 50-60 Minutes		
50 Minutes	55 Minutes	60 Minutes
Na		
133. Document Final Condition with Pictures after paint		



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134. Final Pics and QC Review

RW

hW



Co witness TRH



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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.
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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.
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.