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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 103598

Prepared for Tyson Foods (10914)

1238 Market Street
Clarksville AR 72830

Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: 22020075507

1.0

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Hi-Speed Industrial Service
7030 Ryburn Dr
Millington, Tn 38053
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AC Inspection as Found

Tyson Foods (10914)

1238 Market Street
Clarksville, AR 72830

FolderID: 103598
FormID: 21832512

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: 22020075507

Description: 75HP TOSHIBA 3550RPM

Hi-Speed Job Number: 103598

Manufacturer: Toshiba

Serial Number: 22020075507

HP/kW: 75 (HP)

RPM: 3550 (RPM)

Frame: 365TSC

Voltage: 230 / 460

Current: 172/86 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

of Leads: 12

J-box Included: None

Coupling/Sheave: None

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

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 5 - High ● 9 - Good

Overall Condition

1. Report Date

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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	
5.	Report Date [COPY]	
Initial Mechanical/Electrical		
<input checked="" type="radio"/>	6. Does Shaft Turn Freely?	(N) No
<input checked="" type="radio"/>	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	Inches
10.	Assembled Shaft End Play	inches
11.	Air Gap Variation <10%	
<input checked="" type="radio"/>	12. Lead Condition	(P) Pass
13.	Lead Length	14 Inches
<input checked="" type="radio"/>	14. Does it have Lugs?, If so what is the Stud Size?	(No) No
15.	Lead Numbers	1-12
16.	Frame Condition	pass
<input checked="" type="radio"/>	17. Fan Condition	(P) Pass
18.	Broken or Missing Components	j-box is missing
Initial Electrical Inspection		

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20. Winding Resistance

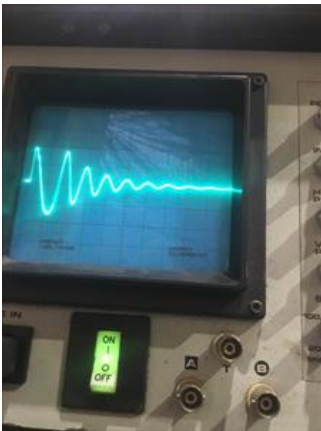
1-2

1-3

2-3

21. Perform Surge Test

(P) Pass



22. Number of Stator Slots

48

23. Stator Condition

dirty

24. Stator Thermistors/Ohms

25. Stator Overloads/Ohms

Mechanical Inspection

26. Drive End Bearing Brand

C&U

27. Drive End Bearing Number-

6312

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?

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

na



34. Opposite Drive End Bearing Brand	C&U
35. Opposite Drive End Bearing Number-	6312
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?	
40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
41. Opposite Drive End Bearing Condition	


 **Frosting and contamination**



42. Drive End Seal
43. Opposite Drive End Seal

Rotor Inspection

44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
45. Growler Test	(Pass) Pass
46. Number of Rotor Bars	42
47. Rotor Condition	pass

-  48. List the Parts needed for the Repair Below
- 6312x2
New shaft or weld
Sleeving material for DE end bell air gap and bearing fit

49. Signature of Technician that Disassembled Motor

Cw



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

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

 *Bearing welded to shaft*

55. Drive End Bearing Shaft Fit Condition

(F) Fail

56. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.3621

2.3621

2.3621

57. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass

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

 *Lip worn into fit*

60. Drive End - Endbell Bearing Fit Condition

(F) Fail

61. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

5.1186

5.1187

5.1186

62. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass

63. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

64. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

65. List Machine Work Needed Below

Shaft, DE end bell bearing fit and air gap



Co sign:

Root Cause of Failure

67. Failure locations

Bearings, shaft, DE end bell bearing fit and air gap

68. Root cause of failure

DE bearing cage failed causing bearing to lock up and spin on shaft and housing taking down the bearing fits and air gap

Dynamic Balance Report

69. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

70. Initial Balance Readings

Drive End

Opposite Drive End

71. Final Balance Readings

Drive End

Opposite Drive End

72. Technician

Mechanical Fits- Rotor - Post Repair

73. Shaft Runout Post Repair

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

78. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

79. Shaft Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

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



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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.
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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.
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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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