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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 103184**

Prepared for Tyson Foods (10914)

1238 Market Street  
Clarksville AR 72830

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AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *RF97DRN100LN4/DH*

**1.0**

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*Printed on 7/3/2024*

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

## AC Inspection as Found

**Tyson Foods (10914)**


1238 Market Street  
Clarksville, AR 72830

FolderID: 103184  
FormID: 20888518

### AC Inspection - Rev. 2

**Location:** MOTOR SHOP LR  
**Serial Number:** RF97DRN100LN4/DH  
**Description:** 3HP SEW-EURODRIVE PUMP

<b>Hi-Speed Job Number:</b>	101384
<b>Manufacturer:</b>	SEW Eurodrive
<b>Serial Number:</b>	RF97DRN100LN4/DH
<b>HP/kW:</b>	3 (HP)
<b>RPM:</b>	1762 (RPM)
<b>Voltage:</b>	230 / 460
<b>Current:</b>	8.4/4.2
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b>Service Factor:</b>	1.15
<b>Enclosure:</b>	TEFC
<b># of Leads:</b>	9
<b>J-box Included:</b>	Half
<b>Coupling/Sheave:</b>	None
<b>Date Received:</b>	07/02/2024
<b>Bearing RTDs:</b>	No
<b>Stator RTDs:</b>	No
<b>Repair Stage:</b>	Final
<b>Rewind:</b>	No
<b>Shaft Machined Fit Repairs Required:</b>	No
<b>Bearing Housing Machined Fit Repairs Required:</b>	No
<b>Heaters:</b>	No
<b>Winding Type :</b>	Random Wound
<b>Bearing Type:</b>	Rolling Element

Priorities Found:  **10 - Good**

### Overall Condition

1. Report Date

**07/03/2024**

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## 2. Nameplate Picture



## 3. Photos of all six sides of the machine.





4. Describe the Overall Condition of the Equipment as Received

*Shaft rusted, flange rusted, motor and gearbox dirty*

#### Initial Mechanical/Electrical

5. Does Shaft Turn Freely?	(Y) Yes
6. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
7. Does Shaft Have Visible Damage?	(No) No
8. Assembled Shaft Runout	Inches
9. Assembled Shaft End Play	inches
10. Air Gap Variation <10%	
11. Lead Condition	(P) Pass
12. Lead Length	6 Inches
13. Does it have Lugs?, If so what is the Stud Size?	(No) No
14. Lead Numbers	1-9
15. Frame Condition	dirty
16. Fan Condition	(P) Pass

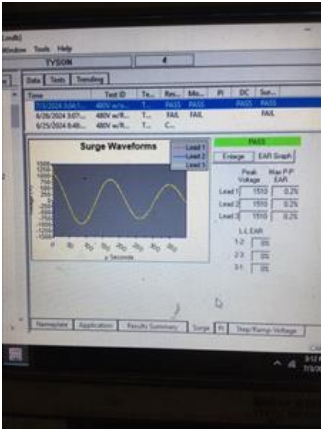


17. Broken or Missing Components

#### Initial Electrical Inspection

18. Insulation Resistance/Megger	24310 Megohms		
19. Winding Resistance			
1-2	1-3	2-3	
4.081	4.084	4.081	

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21. Number of Stator Slots

36

22. Stator Condition



23. Stator Thermistors/Ohms

24. Stator Overloads/Ohms

**Mechanical Inspection**

25. Drive End Bearing Brand

NSK

26. Drive End Bearing Number-

6306 2RS



27. Drive End Bearing Qty.

1

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28. Drive End Bearing Type	<b>(Ball) Ball Bearing</b>
29. Drive End Lubrication Type	<b>(Grease) Grease Lubricated</b>
30. Drive End Bearing Insulation or Grounding Device?	
31. Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>snap ring</b>
32. Drive End Bearing Condition	<b>normal wear</b>



33. Opposite Drive End Bearing Brand	<b>NSK</b>
34. Opposite Drive End Bearing Number-	<b>6205 2RS</b>




35. Opposite Drive End Bearing Qty.	<b>1</b>
36. Opposite Drive End Bearing Type	<b>(Ball) Ball Bearing</b>
37. Opposite Drive End Lubrication Type	<b>(Grease) Grease Lubricated</b>
38. Opposite Drive End Bearing Insulation or Grounding Device?	
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>wavy washer</b>
40. Opposite Drive End Bearing Condition	<b>normal wear</b>

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41. Drive End Seal	pass
42. Opposite Drive End Seal	pass
<b>Rotor Inspection</b>	
43. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast



44. Growler Test	(Pass) Pass
45. Number of Rotor Bars	28
46. Rotor Condition	pass
47. List the Parts needed for the Repair Below 6205 2 RS. 6306 2RS	
48. Signature of Technician that Disassembled Motor	RW
	

<b>Mechanical Fits- Rotor</b>		
49. Shaft Runout	0.0002 inches	
50. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing



51. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
52. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
53. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
1.1815	1.1815	1.1815



54.	Drive End Bearing Shaft Fit Condition	(P) Pass	
55.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	0.9848	0.9848	0.9848
56.	Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	
57.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
	pass	pass	
Mechanical Fits- Bearing Housings			
58.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	2.8348	2.8348	2.8348



59. Drive End - Endbell Bearing Fit Condition		(P) Pass
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60. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
<b>2.0476</b>	<b>2.0476</b>	<b>2.0476</b>
61. Opposite Drive End - Endbell Bearing Fit Condition		<b>(P) Pass</b>



62. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
63. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
<b>pass</b>	<b>pass</b>	
64. List Machine Work Needed Below		
<i>None</i>		

65. Technician

**RW**

*RW*

Witness: TRH

#### Root Cause of Failure

66. Failure locations	
<i>Output shaft rusted and flange rusted</i>	
67. Root cause of failure	
<i>Na</i>	

#### Dynamic Balance Report

68. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
69. Initial Balance Readings		
Drive End	Opposite Drive End	
70. Final Balance Readings		
Drive End	Opposite Drive End	
71. Technician		

#### Assembly

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72.	QC Check All Parts for Cleanliness Prior to Assembly		
73.	Photograph All Major Components prior to assembly		
74.	Final Insulation Resistance Test		
75.	Assembled Shaft Endplay		
76.	Assembled Shaft Runout		
77.	Test Run Voltage		
	Volts	Volts	Volts
78.	Test Run Amperage		
	Amps	Amps	Amps
79.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
80.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
81.	Ambient Temperature - Fahrenheit		
82.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
83.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
84.	Document Final Condition with Pictures after paint		
85.	Final Pics and QC Review		



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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.
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