



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

LR Motor Shop Repairs

Job Number 104211

Prepared for American Kraft Paper

1701 Jefferson Parkway
White Hall AR 71602

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

AC Inspection as Found

American Kraft Paper
1701 Jefferson Parkway
White Hall, AR 71602

FolderID: 104211
FormID: 23551128

AC Inspection - Rev. 2

Location: LR MOTOR SHOP
Serial Number: KM8406914
Description: 350 HP GENERAL ELECTRIC

Hi-Speed Job Number:	104211
Manufacturer:	GE
Product Number:	5K826641C56
Serial Number:	KM8406914
HP/kW:	350 (HP)
RPM:	885 (RPM)
Frame:	8266S
Voltage:	2300
Current:	84 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1
Enclosure:	ODP
# of Leads:	3
J-box Included:	None
Coupling/Sheave:	None
Date Received:	03/05/2025
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	Yes
Shaft Machined Fit Repairs Required:	No
Bearing Housing Machined Fit Repairs Required:	Yes
Heaters:	No
Winding Type :	Form Coil
Bearing Type:	Rolling Element

Priorities Found: ● 3 - High ● 9 - Good

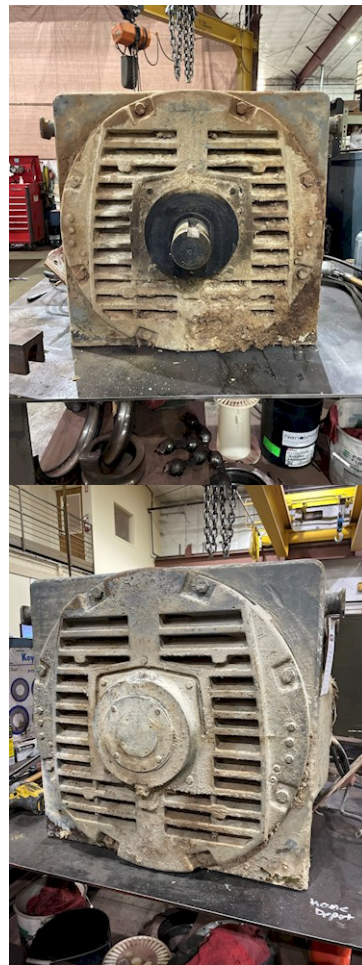
Overall Condition

1. Report Date	03/05/2025
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[illegible]

A collage of three photographs documenting the restoration of a large industrial machine. The top photo shows the machine's front panel being removed. The middle photo shows the machine's internal components. The bottom photo shows the machine's motor and fan assembly.



Printed on 5/21/2025



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1.4



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1.5











4. Describe the Overall Condition of the Equipment as Received

Rewind stator. Need new bearings, sleeve OD endbell


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	0.002 Inches
9.	Assembled Shaft End Play	0 inches

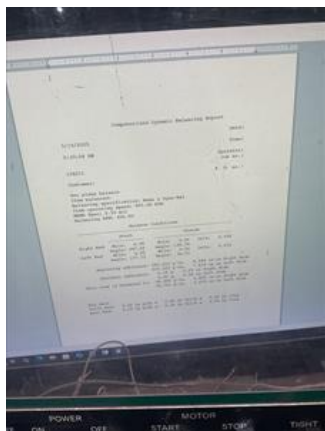
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10.	Air Gap Variation <10%			
	 Na			
	11. Lead Condition			(P) Pass
	12. Lead Length			21 Inches
	13. Does it have Lugs?, If so what is the Stud Size?			(Yes) Yes
	 Same as leads			
	14. Lead Numbers			1 2 3
	15. Frame Condition			Good
	16. Fan Condition			(N) NA
	17. Does motor have internal fan?			(No) No
	18. Broken or Missing Components			No
Initial Electrical Inspection				
	19. Insulation Resistance/Megger			0 Megohms
	20. Winding Resistance			
	1-2	1-3	2-3	
	0	0	0	
	21. Perform Surge Test			(NA) Not Applicable
	22. Number of Stator Slots			96
	23. Stator Condition			Rewind
	24. Stator Thermistors/Ohms			
	 Na			
	25. Stator Overloads/Ohms			
	 Na			
Mechanical Inspection				
	26. Drive End Bearing Brand			SKF
	27. Drive End Bearing Number-			6319 2ZC3GJN
	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?			No
	32. Drive End Wavy Washer/Snap-Ring Other Retention Device?			Retaining nut and washer
	33. Drive End Bearing Condition			Worn
	34. Opposite Drive End Bearing Brand			SKF
	35. Opposite Drive End Bearing Number-			6319 2ZC3GJN
	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?			No
	40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?			Retaining nut and washer
	41. Opposite Drive End Bearing Condition			Worn
	42. Drive End Seal			Brass dust seal
	43. Opposite Drive End Seal			No
Rotor Inspection				
	44. Rotor Type/Material			(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
	45. Growler Test			(Pass) Pass
	46. Number of Rotor Bars			117

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47. Rotor Condition	Good		
48. List the Parts needed for the Repair Below <i>Rewind stator</i> <i>2-63192ZC3</i> <i>Sleeve endbells</i>			
49. Signature of Technician that Disassembled Motor	Trevor Hall		
			
Mechanical Fits- Rotor			
50. Shaft Runout	0.002 inches		
51. Rotor Runout			
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
Na			
52. Coupling Fit Closest to Bearing Housing			
0 Degrees	90 Degrees	120 Degrees	
3.3743	3.3746	3.374	
53. Coupling Fit Closest to the end of the Shaft			
0 Degrees	60 Degrees	120 Degrees	
3.3752	3.3741	3.3745	
54. Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
3.741	3.741	3.741	
55. Drive End Bearing Shaft Fit Condition	(P) Pass		
56. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
3.7409	3.7409	3.7409	
57. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass		
58. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Good	Good		
Mechanical Fits- Bearing Housings			
59. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
7.8747	7.8748	7.8748	
60. Drive End - Endbell Bearing Fit Condition	(P) Pass		
61. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
7.8783	7.877	7.8766	
62. Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail		
63. Bearing Cap Condition			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
Good	Good		

64. End Bell Air Seal Fits	
Drive End Air Seal	Opposite Drive End Air Seal
Good	Good
65. List Machine Work Needed Below <i>Sleeve OD endbell</i>	
66. Technician Trevor Hall	
	
Co sign: CRW	
Root Cause of Failure	
67. Failure locations <i>Windings shorted at bottom of stator where all the buildup of debris is located. Bearings are worn and endbells are oversized.</i>	
68. Root cause of failure <i>Windings shorted at the bottom of the stator where all the debris was built up. Bearings have wear in them. Opposite drive endbell is oversized.</i>	
Dynamic Balance Report	
69. Rotor Weight and Balance Grade	
Rotor Weight	Balance Grade



70. Initial Balance Readings	
Drive End	Opposite Drive End
0.98	2.02
71. Final Balance Readings	
Drive End	Opposite Drive End
0.28	0.56
72. Technician RW	
	
Rewind	

73.	Core Test Results - Watts loss per Pound		
	Pre-Burnout	Post Burnout	
74.	Core Hot Spot Test		
	Pre-Burnout	Post-Burnout	
75.	Post Rewind Electrical Test- Insulation Resistance		Megohms
76.	Post Rewind Polarization Index		Polarization Index
77.	Post Rewind Winding Resistance		
	1-2	1-3	2-3
78.	Post Rewind Surge Test		
79.	Post Rewind Hi-Pot		micro-amps
80.	Technician		
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
	7.8749	7.8748	7.8749



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	Gary
	、	

Assembly

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86. QC Check All Parts for Cleanliness Prior to Assembly

RW

B2 ✓

87. Photograph All Major Components prior to assembly

(Complete) Complete





88. Final Insulation Resistance Test

12,820 Megohms

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89. Assembled Shaft Endplay	0 inches	
90. Assembled Shaft Runout	0.0004 inches	
91. Test Run Voltage		
Volts	Volts	Volts
2296	2298	2310



Co sign CRW

92. Test Run Amperage		
Amps	Amps	Amps
22.1	21.9	21.6



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93. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.02	0.02	0.03
94. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.02	0.01	0.03
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. Stator Temperatures- Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
99. Document Final Condition with Pictures after paint		



100. Final Pics and QC Review	RW
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A handwritten signature in black ink, appearing to be 'H2' followed by a checkmark-like flourish.

Co sign CRW



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

AC Random Coil Rewind Report

FolderID: 104211
FormID: 23871099

American Kraft Paper
1701 Jefferson Parkway
White Hall, AR 71602

LR MOTOR SHOP
Winding

Priorities Found: ● 2 - Good

General

1. Job Number 104211



2. Report Date 03/26/2025

3. Customer American Kraft Paper

Stator Winding

4. Core Length 13.625 "

5. Core ID 18.5 "

6. Back Iron Depth 1.175 "

7. Slot Depth 2.175 "

8. Tooth Width 0.375 "

9. Number of Vents 4

10. Vent Width 0.375 "

● 11. Before Burnout Core loss (P) Pass

12. Flux Before Burnout

13. Watts before burnout Watts

14. Watts loss per lb. before burnout 0.765 W/lbs.

15. After Burnout Core Loss

16. Flux After burnout

17. Watts After Burnout

18. Watts loss per lb After Burnout 0.745 W/lbs.

● 19. Core Iron Condition (P) Pass

20. RTD's

21. RTD's Reading

22. Motor Heaters

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23. Heater Qty.	
24. Heater Voltage	
25. Heater Wattage	
26. Thermistors	
27. Number of Poles	8
28. Slots	96
29. Number of Coils	
30. Coil Weight	
31. Lead Markings	
<i>None</i>	
32. Grouping	
<i>24g of 4c</i>	
33. Multiple Wires	
34. Wire Size	
35. Turns per coil	11
36. Pitch 1 to:	10
37. Connection	
<i>1 delta</i>	
38. Lead Length	16 "
39. Lead Size	
40. Number of Leads	3
41. Megger Reading After Rewind	
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	
46. Surge Pattern After Rewind	
47. Service Technician	





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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

replace any defective or non-conforming goods in accordance with the applicable manufacturer's warranty. Warranty for any defective or incorrect parts is limited to the repair or replacement of those parts. Hi-Speed warrants that all services will conform in all material respects to the description of services identified in the quotation and will be performed in a good and workmanlike manner in accordance with industry practices and standards. Should the services be reasonably rejected or not conform with the foregoing warranties, Hi-Speed shall, at its sole cost, re-perform the defective or nonconforming services. Notwithstanding the foregoing, these warranties do not extend to goods or services to the extent that such goods have been subject to misuse, neglect or abuse not caused by Hi-Speed or have been used in violation of the approved written instructions furnished to Buyer. THE FOREGOING REPRESENTS THE SOLE AND EXCLUSIVE WARRANTY GIVEN BY HI-SPEED WITH RESPECT TO ALL GOODS SOLD AND IS IN LIEU OF ALL OTHER WARRANTIES EITHER EXPRESS OR IMPLIED. HI-SPEED EXPRESSLY DISCLAIMS ALL OTHER WARRANTIES INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR USE OR PURPOSE. BUYER WAIVES ANY CLAIM THAT THESE EXCLUSIONS OR LIMITATIONS DEPRIVE IT OF AN ADEQUATE REMEDY AT EQUITY OR LAW OR CAUSE THIS AGREEMENT TO FAIL IN ITS ESSENTIAL PURPOSE. BUYER SHALL BE ENTITLED TO NO OTHER REMEDY OTHER THAN AS SET FORTH HEREIN, REGARDLESS OF THE CLAIM OR CAUSE OF ACTION, WHETHER BASED IN CONTRACT, TORT, NEGLIGENCE, GOODS LIABILITY, STRICT LIABILITY OR OTHERWISE.

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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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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.