



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

LR Motor Shop Repairs

**Job Number 104402**

Prepared for Arkansas Lime Company

600 Limesdale Rd  
Batesville AR 72501

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AC Inspection as Found - *LITTLE ROCK MOTOR  
SHOP*

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

Arkansas Lime Company

600 Limesdale Rd  
Batesville, AR 72501

FolderID: 104402  
FormID: 23980593

### AC Inspection - Rev. 2

Location: LITTLE ROCK MOTOR SHOP

Serial Number:

Description: 250 HP TOSHIBA

Hi-Speed Job Number: 104402

Manufacturer: Toshiba

Product Number: E2506FLF4BM

HP/kW: 250 (HP)

RPM: 1185 (RPM)

Frame: N587UZ

Voltage: 460

Current: 296 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

# of Leads: 12

J-box Included: None

Coupling/Sheave: Sheave

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: No

Shaft Machined Fit Repairs  
Required: No

Bearing Housing Machined  
Fit Repairs Required: Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: 6 - High

2 - Low

13 - Good

### Overall Condition

1. Report Date

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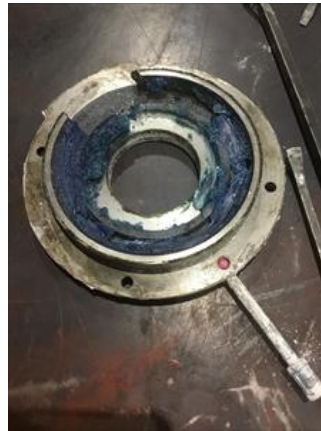
1.0

## 2. Nameplate Picture



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









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	<b>inches</b>



2.0405 in

Initial Mechanical/Electrical	
6. Does Shaft Turn Freely?	<b>(Y) Yes</b>
7. Does the shaft require T.I.R in Lathe to identify additional repairs?	<b>(No) No</b>

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8. Does Shaft Have Visible Damage?

(Yes) Yes

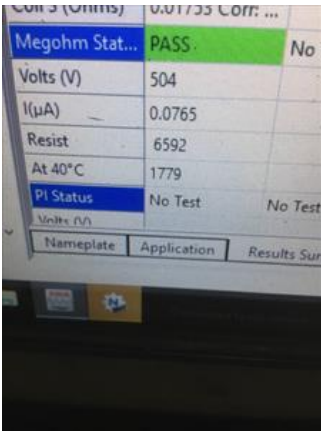


9. Assembled Shaft Runout	0.001 Inches
10. Assembled Shaft End Play	inches
11. Air Gap Variation <10%	
12. Lead Condition	(P) Pass
13. Lead Length	12 Inches
14. Does it have Lugs?, If so what is the Stud Size?	(No) No
15. Lead Numbers	1-12
16. Frame Condition	
17. Fan Condition	(P) Pass
18. Does motor have internal fan?	(Yes) Yes
19. Broken or Missing Components	
J-box and bolts	

### Initial Electrical Inspection

20. Insulation Resistance/Megger

Megohms



## 21. Winding Resistance

1-2

1-3

2-3

Temp Com...	Thermoplastic	None
Resist Status	PASS	No Test
Bal L1 (Ohms)		
Bal L2 (Ohms)		
Bal L3 (Ohms)		
L1-L2 (Ohms)	0.01138 Corr: ...	
L2-L3 (Ohms)	0.01138 Corr: ...	
L3-L1 (Ohms)	0.01156 Corr: ...	
Max Delta R %	1.624	
Coil 1 (Ohms)	0.01697 Corr: ...	
Coil 2 (Ohms)	0.01697 Corr: ...	
Coil 3 (Ohms)	0.01753 Corr: ...	
Application		
Results Summary		

## 22. Perform Surge Test

(P) Pass

104402	2
Tests	Trending
Test ID	400V w/HTL/100HP Shop
For	Motor
Temperature/Resistance Tests	
Temperature	Manual
Resistance	3 Lead Low V
DC Tests	
Med/Pre	500 Vdc
OFF	500 Vdc
Step Voltage	1420 Vdc
Surge Test	Surge 100 Vdc

## 23. Number of Stator Slots

72

## 24. Stator Condition

## 25. Stator Thermistors/Ohms

## 26. Stator Overloads/Ohms

## Mechanical Inspection

## 27. Drive End Bearing Brand

KOYO

## 28. Drive End Bearing Number-

NU324

## 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?

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

snap ring

### 34. Drive End Bearing Condition

Contamination



35. Opposite Drive End Bearing Brand	KOYO
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?	
41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
42. Opposite Drive End Bearing Condition	

Normal wear



- 43. Drive End Seal
- 44. Opposite Drive End Seal

### Rotor Inspection

45. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
46. Growler Test	(Pass) Pass
47. Number of Rotor Bars	60
48. Rotor Condition	
49. List the Parts needed for the Repair Below	

NU324  
6320

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50. Signature of Technician that Disassembled Motor

Cw


**Mechanical Fits- Rotor**

<div><div></div></div>	51. Shaft Runout	inches	
	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
<div><div></div></div>	4.7251-4.7253-4.7254		
<div><div></div></div>	56. Drive End Bearing Shaft Fit Condition	(P) Pass	
<div><div></div></div>	Recommend new shaft due to gouging		
	57. Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
<div><div></div></div>	3.9370-3.9372-3.9372		
<div><div></div></div>	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		
<div><div></div></div>	60. Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
<div><div></div></div>	Excessive pitting and gouge marks		
<div><div></div></div>	61. Drive End - Endbell Bearing Fit Condition	(F) Fail	
<div><div></div></div>	62. Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
<div><div></div></div>	Excessive pitting and gouge marks		
<div><div></div></div>	63. Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail	
<div><div></div></div>	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	

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66.	List Machine Work Needed Below <i>Both end bell bearing fits and recommend new shaft due to damage on DE shaft bearing fit</i>		
67.	Technician		Cw
			
Co sign: DM			
<b>Root Cause of Failure</b>			
68.	Failure locations <i>Bearings and bearing fits</i>		
69.	Root cause of failure <i>Excessive wear and contamination due to mixing of grease</i>		
<b>Dynamic Balance Report</b>			
70.	Rotor Weight and Balance Grade		
	Rotor Weight	Balance Grade	
71.	Initial Balance Readings		
	Drive End	Opposite Drive End	
72.	Final Balance Readings		
	Drive End	Opposite Drive End	
73.	Technician		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>			
74.	Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
75.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
76.	Bearing Cap Condition Post Repair		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
77.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
78.	End Bell Repair Sign-off		
<b>Assembly</b>			
79.	QC Check All Parts for Cleanliness Prior to Assembly		
80.	Photograph All Major Components prior to assembly		
81.	Final Insulation Resistance Test		
82.	Assembled Shaft Endplay		
83.	Assembled Shaft Runout		
84.	Test Run Voltage		
	Volts	Volts	Volts

85. Test Run Amperage			
Amps	Amps	Amps	
86. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
87. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
88. Ambient Temperature - Fahrenheit			
89. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
90. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
91. Document Final Condition with Pictures after paint			
92. 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.
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

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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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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.