



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

LR Motor Shop Repairs

Job Number 104027

Prepared for Custom Craft Poultry

3064 E Main St
Batesville AR 72501

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

AC Inspection as Found

Custom Craft Poultry

3064 E Main St
Batesville, AR 72501

FolderID: 104027
FormID: 23082687

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: 2/6/25-104027

Description: NO HEADPLATE DATA

Hi-Speed Job Number: 104027

Voltage: 230 / 460

Phase: Three

Enclosure: ODP

of Leads: 9

J-box Included: Complete

Coupling/Sheave: Sheave

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 : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 3 - High ● 10 - Good

Overall Condition

1. Report Date
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





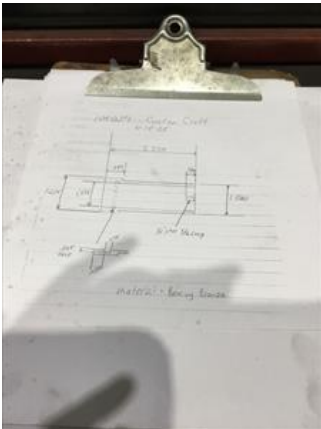
5.	Distance from the end of the shaft to the Coupling/Sheave	inches
Initial Mechanical/Electrical		
6.	Does Shaft Turn Freely?	(Y) Yes
7.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
8.	Does Shaft Have Visible Damage?	(Yes) Yes
9.	Assembled Shaft Runout	0.004 Inches
10.	Assembled Shaft End Play	inches
11.	Air Gap Variation <10%	
12.	Lead Condition	(NA) Not Applicable
13.	Lead Length	Inches
14.	Does it have Lugs?, If so what is the Stud Size?	(No) No
15.	Lead Numbers	9
16.	Frame Condition	
17.	Fan Condition	(N) NA
18.	Broken or Missing Components	
19.	Does motor have internal fan?	(No) No
Initial Electrical Inspection		
20.	Insulation Resistance/Megger	Megohms
21.	Winding Resistance	
	1-2	1-3 2-3
22.	Perform Surge Test	

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23. Number of Stator Slots
24. Stator Condition
25. Stator Thermistors/Ohms
26. Stator Overloads/Ohms
Mechanical Inspection
27. Drive End Bearing Brand
28. Drive End Bearing Number-
29. Drive End Bearing Qty.
30. Drive End Bearing Type
31. Drive End Lubrication Type
32. Drive End Bearing Insulation or Grounding Device?
33. Drive End Wavy Washer/Snap-Ring Other Retention Device?
34. Drive End Bearing Condition
35. Opposite Drive End Bearing Brand
36. Opposite Drive End Bearing Number-
37. Opposite Drive End Bearing Qty.
38. Opposite Drive End Bearing Type
39. Opposite Drive End Lubrication Type
40. Opposite Drive End Bearing Insulation or Grounding Device?
41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?
42. Opposite Drive End Bearing Condition
43. Drive End Seal



Machined new seal sleeve.



44. Opposite Drive End Seal


Rotor Inspection

- 45. Rotor Type/Material
- 46. Growler Test
- 47. Number of Rotor Bars
- 48. Rotor Condition
- 49. List the Parts needed for the Repair Below
- 50. Signature of Technician that Disassembled Motor

Mechanical Fits- Rotor

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
1.9688	1.9688	1.9699

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56.	Drive End Bearing Shaft Fit Condition	(P) Pass	
57.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	1.7719	1.7719	1.7718
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			
60.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	4.3314	4.3309	4.3324
61.	Drive End - Endbell Bearing Fit Condition	(F) Fail	
62.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	3.9385	3.9386	3.9387
63.	Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail	
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	
66.	List Machine Work Needed Below		
67.	Technician	RHR	
			
Root Cause of Failure			
68.	Failure locations		
69.	Root cause of failure		
Dynamic Balance Report			
70.	Rotor Weight and Balance Grade		
	Rotor Weight	Balance Grade	

71. Initial Balance Readings

Drive End

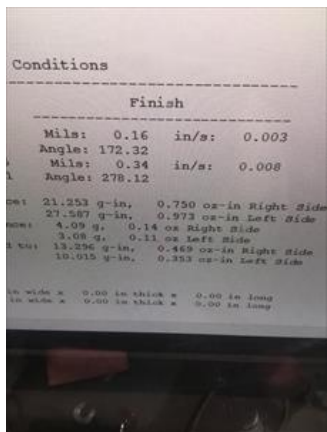
Opposite Drive End



72. Final Balance Readings

Drive End

Opposite Drive End



73. Technician

Cw

[Handwritten Signature]

Rewind

74. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

75. Core Hot Spot Test

Pre-Burnout

Post-Burnout

76. Post Rewind Electrical Test- Insulation Resistance

Megohms

77. Post Rewind Polarization Index

Polarization Index

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78. Post Rewind Winding Resistance		
1-2	1-3	2-3
79. Post Rewind Surge Test		
80. Post Rewind Hi-Pot		micro-amps
81. Technician		
Mechanical Fits- Bearing Housings - Post Repair		
82. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
4.3313	4.3313	4.3313



83. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
3.9379	3.9379	3.9379



84. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
85. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	

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86. End Bell Repair Sign-off

RW



Assembly

87. QC Check All Parts for Cleanliness Prior to Assembly

Cw



88. Photograph All Major Components prior to assembly





89. Final Insulation Resistance Test	Megohms		
90. Assembled Shaft Endplay	inches		
91. Assembled Shaft Runout	inches		
92. Test Run Voltage			
Volts	Volts	Volts	
460	457	461	



93. Test Run Amperage			
Amps	Amps	Amps	
8.6	8.5	8.4	

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94. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
95. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
96. Ambient Temperature - Fahrenheit		
97. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
98. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes

99. Document Final Condition with Pictures after paint



100. Final Pics and QC Review

RW



Co sign CRW



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

AC Random Coil Rewind Report

FolderID: 104027
FormID: 23314411

Custom Craft Poultry

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Batesville, AR 72501

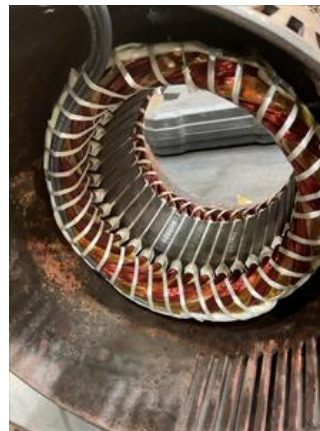
LR MOTOR SHOP

Priorities Found: ● 3 - Good

General	
1. Job Number	104027
2. Report Date	02/06/2025
3. Customer	Custom Craft
Stator Winding	
4. Core Length	3 "
5. Core ID	6.75 "
6. Back Iron Depth	1.25 "
7. Slot Depth	1 "
8. Tooth Width	0.362 "
9. Number of Vents	
10. Vent Width	
11. Before Burnout Core loss	
12. Flux Before Burnout	
13. Watts before burnout	
14. Watts loss per lb. before burnout	1.504 W/lbs.
● 15. After Burnout Core Loss	(P) Pass
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	1.75 W/lbs.
● 19. Core Iron Condition	(P) Pass
20. RTD's	
21. RTD's Reading	
22. Motor Heaters	
23. Heater Qty.	
24. Heater Voltage	
25. Heater Wattage	
26. Thermistors	
27. Number of Poles	4
28. Slots	36
29. Number of Coils	36
30. Coil Weight	
31. Lead Markings	
1-9	
32. Grouping	
12 OF 3	
33. Multiple Wires	

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34. Wire Size	
2 #19 awg	
35. Turns per coil	27
36. Pitch 1 to:	7
37. Connection	
2 wye @460v	
38. Lead Length	9 "
39. Lead Size	10
40. Number of Leads	9
41. Megger Reading After Rewind	8042 Mohms
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	0.073 Ua
46. Surge Pattern After Rewind	(P) Pass
47. Service Technician	
	
<p>  DRE 1.875 ODE. 15lbs #19 awg copper wire 8' #10 exar 600v lead wire </p>	





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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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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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