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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 104239

Prepared for Hormel (11974)

8201 Fraizer Pike
Little Rock AR 72206

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

AC Inspection as Found

Hormel (11974)
8201 Fraizer Pike
Little Rock, AR 72206

FolderID: 104239
FormID: 23628175

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: 200HP BALDOR 3600RPM 447TY

Hi-Speed Job Number: 104239

Manufacturer: Baldor

Product Number: Z44G8505

Spec/ID #: Z44G8505

HP/kW: 200 (HP)

RPM: 3575 (RPM)

Frame: 447TY

Voltage: 460

Current: 222

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

of Leads: 6

J-box Included: Complete

Coupling/Sheave: None

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Rewind: Yes

Shaft Machined Fit Repairs
Required: No

Bearing Housing Machined
Fit Repairs Required: No

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 6 - High ● 11 - Good

Overall Condition

1. Report Date

03/11/2025

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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 | | | |
| <i>Dirty</i> | | | |
| 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 | | (NA) Not Applicable |
| | <i>Rewind</i> | | |
| 12. | Lead Length | | 18 Inches |
| 13. | Does it have Lugs?, If so what is the Stud Size? | | (Yes) Yes |
| 14. | Lead Numbers | | 1-6 |
| 15. | Frame Condition | | |
| 16. | Fan Condition | | (P) Pass |
| 17. | Does motor have internal fan? | | (No) No |
| 18. | Broken or Missing Components | | J-box and bolts |
| Initial Electrical Inspection | | | |
| 19. | Insulation Resistance/Megger | | Megohms |
| 20. | Winding Resistance | | |
| | 1-2 | 1-3 | 2-3 |
| 21. | Perform Surge Test | | (NA) Not Applicable |
| 22. | Number of Stator Slots | | 48 |
| 23. | Stator Condition | | |
| | <i>Rewind</i> | | |
| 24. | Stator Thermistors/Ohms | | |
| 25. | Stator Overloads/Ohms | | |
| Mechanical Inspection | | | |

26. Drive End Bearing Brand

KOYO



27. Drive End Bearing Number-

NU313

28. Drive End Bearing Qty.

1

29. Drive End Bearing Type

(Roller) Roller Bearing

30. Drive End Lubrication Type

(Oil) Oil Lubricated

31. Drive End Bearing Insulation or Grounding Device?

Aegis ring

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

Spacer after bearing

33. Drive End Bearing Condition

Normal wear



34. Opposite Drive End Bearing Brand

NACHI



| | |
|--|-----------------------------------|
| 35. Opposite Drive End Bearing Number- | 6313 |
| 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? | snap ring |
| 41. Opposite Drive End Bearing Condition | |
| <div> <div></div> <i>Signs of contamination</i> </div> | |



| | |
|---|--|
| <div> <div></div> <div>42. Drive End Seal</div> </div> <div> <div></div> <div>65-85-8 lip seal</div> </div> | |
|---|--|



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43. Opposite Drive End Seal


65-85-9 lip 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 | needs cleaned |
| 48. List the Parts needed for the Repair Below NU313 6313 Two new lip seals | |
| 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 | |
|  2.5599-2.5598-2.5599 | | | |
| 55. Drive End Bearing Shaft Fit Condition | | | (P) Pass |

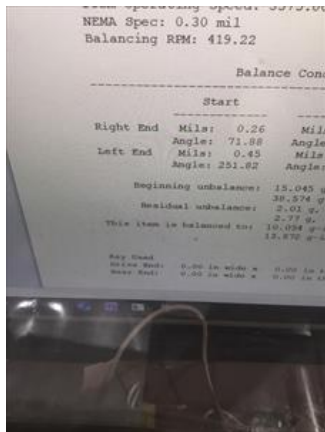
2.5599-2.5598-2.5599

| | | |
|---|--------------------------------|-------------|
| 56. Opposite Drive End Bearing Shaft Fit | | |
| 0 Degrees | 60 Degrees | 120 Degrees |
| <div> 2.5598-2.5598-2.5597 </div> | | |
| 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 |
| <div> 5.5122-5.5121-5.5122 </div> | | |
| 60. Drive End - Endbell Bearing Fit Condition | | (P) Pass |
| 61. Opposite Drive End - Endbell Bearing Fit | | |
| 0 Degrees | 60 Degrees | 120 Degrees |
| <div> 5.5126-5.5125-5.5125 </div> | | |
| 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 | | |
| 66. Technician | | Cw |
|  | | |
| <div> Co sign: RRW </div> | | |
| Root Cause of Failure | | |
| 67. Failure locations | | |
| <i>Windings, bearings, and seals</i> | | |
| 68. Root cause of failure | | |
| <i>Excessive heat buildup on ODE caused coil to coil short</i> | | |
| 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

Chris W

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

76. Post Rewind Polarization Index

| | | |
|---|-----|-------------------------|
| 77. Post Rewind Winding Resistance | | |
| 1-2 | 1-3 | 2-3 |
| 78. Post Rewind Surge Test | | |
| 79. Post Rewind Hi-Pot | | |
| 80. Technician | | |
| Assembly | | |
| 81. QC Check All Parts for Cleanliness Prior to Assembly | | Terrence Holland |
|  | | |

82. Photograph All Major Components prior to assembly



| | |
|--------------------------------------|---------|
| 83. Final Insulation Resistance Test | Megohms |
| 84. Assembled Shaft Endplay | inches |
| 85. Assembled Shaft Runout | inches |

86. Test Run Voltage

Volts

Volts

Volts



87. Test Run Amperage

Amps

Amps

Amps

Witnessed by TLH



88. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

89. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

90. Ambient Temperature - Fahrenheit

91. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

92. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

93. Document Final Condition with Pictures after paint

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94. Final Pics and QC Review

Cw

Co sign: TLH



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

AC Random Coil Rewind Report

FolderID: 104239
FormID: 23739624

Hormel (11974)
8201 Fraizer Pike
Little Rock, AR 72206

MOTOR SHOP LR
Winding

Priorities Found: ● 3 - Good

| General | |
|---------------------------------------|--------------|
| 1. Job Number | 104239 |
| 2. Report Date | 03/14/2025 |
| 3. Customer | Skippy |
| Stator Winding | |
| 4. Core Length | 10.25 " |
| 5. Core ID | 10.875 " |
| 6. Back Iron Depth | 2.5 " |
| 7. Slot Depth | 2 " |
| 8. Tooth Width | 0.3125 " |
| 9. Number of Vents | |
| 10. Vent Width | |
| ● 11. Before Burnout Core loss | (P) Pass |
| 12. Flux Before Burnout | |
| 13. Watts before burnout | |
| 14. Watts loss per lb. before burnout | 1.42 W/lbs. |
| ● 15. After Burnout Core Loss | (P) Pass |
| 16. Flux After burnout | |
| 17. Watts After Burnout | |
| 18. Watts loss per lb After Burnout | 1.375 W/lbs. |
| 19. Core Iron Condition | |
| 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 | |
| 28. Slots | 48 |
| 29. Number of Coils | |
| 30. Coil Weight | |
| 31. Lead Markings | |
| 32. Grouping | |
| 6g of 4c | |
| 33. Multiple Wires | |

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| | |
|---------------------------------|------------|
| 34. Wire Size | |
| 35. Turns per coil | |
| 6-5-6-5-6-5 | |
| 36. Pitch 1 to: | 18 |
| 37. Connection | |
| 2 delta @460 | |
| 38. Lead Length | 16 " |
| 39. Lead Size | 2 |
| 40. Number of Leads | 6 |
| 41. Megger Reading After Rewind | 5860 Mohms |
| 42. Coil Machine Slot | |
| 43. Coil Machine Tip | |
| 44. Coil Machine Pitch | |
| 45. Hi Pot Reading After Rewind | 0.1 Ua |
| 46. Surge Pattern After Rewind | (P) Pass |



47. Service Technician

[Handwritten signature]

OPP end 6.75
Conn end 7.25
360 lbs total wire
200 lbs #15 awg
100 lbs #16 awg
60 lbs #17 awg
25' #2 600v epdm lead wire
6 #2 lugs 3/8 eyelet



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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.
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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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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.
14. **NONWAIVER.** No course of dealing or failure of either party to strictly enforce any term, right, or condition of these Standard Terms and Conditions will be construed as a waiver of such term, right or condition. Any waiver by Hi-Speed will only be in writing and will waive no succeeding breach of a term, right or condition.
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.
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