



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

LR Motor Shop Repairs

Job Number 104361

Prepared for Kroger

20820 interstate 30 N
Benton AR 72019

Table of Contents



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

AC Inspection as Found

Kroger

20820 interstate 30 N
Benton, AR 72019

FolderID: 104361
FormID: 23873693

AC Inspection - Rev. 2

Location: LR MOTOR SHOP

Serial Number:

Description: 3 HP ILG INDUSTRIES

Hi-Speed Job Number: 104361

Product Number: 30-00-200A

HP/kW: 3 (HP)

RPM: 665 (RPM)

Voltage: 220-240

Current: 10.2 (Amps)

Phase: Three

Hz: 60 (Hz)

Enclosure: TENV

of Leads: 3

J-box Included: None

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: Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 3 - High ● 8 - Good

Overall Condition

1. Report Date
2. Nameplate Picture

05/07/2025



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3. Photos of all six sides of the machine.





4.	Describe the Overall Condition of the Equipment as Received	
	<i>Serviceable</i>	
5.	Is this a UL Listed Motor	
6.	Is the motor water cooled or can be pressure checked before teardown	
Initial Mechanical/Electrical		
● 7.	Does Shaft Turn Freely?	(Y) Yes
● 8.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
● 9.	Does Shaft Have Visible Damage?	(No) No
● 10.	Assembled Shaft Runout	0.0005999999999999999 Inches
11.	Assembled Shaft End Play	inches
12.	Air Gap Variation <10%	
● 13.	Lead Condition	(F) Fail
14.	Lead Length	8 Inches
● 15.	Does it have Lugs?, If so what is the Stud Size?	(No) No
16.	Lead Numbers	
17.	Frame Condition	pass
18.	Fan Condition	(N) NA
● 19.	Does motor have internal fan?	(No) No
20.	Broken or Missing Components	
21.	Are the Leads insulated with Chico or other material	
Initial Electrical Inspection		
22.	Insulation Resistance/Megger	Megohms

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23. Winding Resistance		
1-2	1-3	2-3
24. Perform Surge Test	(NA) Not Applicable	
25. Number of Stator Slots		54
26. Stator Condition	rewind single phased	



27. Stator Thermistors/Ohms	
28. Stator Overloads/Ohms	
Mechanical Inspection	
29. Drive End Bearing Brand	STEYR
30. Drive End Bearing Number-	6208ZZC3



31. Drive End Bearing Qty.	1
32. Drive End Bearing Type	(Ball) Ball Bearing
33. Drive End Lubrication Type	(Grease) Grease Lubricated
34. Drive End Bearing Insulation or Grounding Device?	
35. Drive End Wavy Washer/Snap-Ring Other Retention Device?	

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36. Drive End Bearing Condition



Little bit of frosting but normal wear

37. Opposite Drive End Bearing Brand

KBC



38. Opposite Drive End Bearing Number-	6206ZZC3
39. Opposite Drive End Bearing Qty.	1
40. Opposite Drive End Bearing Type	(Ball) Ball Bearing
41. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
42. Opposite Drive End Bearing Insulation or Grounding Device?	
43. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	
44. Opposite Drive End Bearing Condition	axial thrust on bearing



- 45. Drive End Seal
- 46. Opposite Drive End Seal

Rotor Inspection

- 47. Rotor Type/Material (Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast



- 48. Growler Test (Pass) Pass
- 49. Number of Rotor Bars 70
- 50. Rotor Condition pass
- 51. List the Parts needed for the Repair Below
1-6208 ZZ 2-6206 ZZ BEARINGS
- 52. Signature of Technician that Disassembled Motor RW

Mechanical Fits- Rotor

- 53. Shaft Runout 0.0005999999999999999 inches
- 54. Rotor Runout
- Drive End Bearing Fit Rotor Body Opposite Drive End Bearing

55. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
56. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
57. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
1.5753	1.5753	1.5753



58. Drive End Bearing Shaft Fit Condition		(P) Pass
59. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
1.1814	1.1814	1.1814



60. Opposite Drive End Bearing Shaft Fit Condition		(P) Pass
61. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	

Pass

Mechanical Fits- Bearing Housings

62. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
3.15	3.15	3.15

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63.	Drive End - Endbell Bearing Fit Condition	(P) Pass	
64.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	2.1442	2.1442	2.1442
65.	Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail	
	Resleeve		



66.	Bearing Cap Condition	
	Drive End Bearing Cap	Opposite Drive End Bearing Cap
67.	End Bell Air Seal Fits	
	Drive End Air Seal	Opposite Drive End Air Seal
	pass	
68.	List Machine Work Needed Below	
	ODE END BELL BEARING FIT BAD	
69.	Technician	RW
		
	Co sign: CRW	

Root Cause of Failure

70.	Failure locations	
	Ode bearing fit bad winding single phased	
71.	Root cause of failure	
	Oversized bearing fit on end bell	

Dynamic Balance Report

72.	Rotor Weight and Balance Grade	
	Rotor Weight	Balance Grade
73.	Initial Balance Readings	
	Drive End	Opposite Drive End
74.	Final Balance Readings	
	Drive End	Opposite Drive End

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75. Technician			
Rewind			
76. Core Test Results - Watts loss per Pound			
Pre-Burnout	Post Burnout		
77. Core Hot Spot Test			
Pre-Burnout	Post-Burnout		
78. Post Rewind Electrical Test- Insulation Resistance			
79. Post Rewind Polarization Index			
80. Post Rewind Winding Resistance			
1-2	1-3	2-3	
81. Post Rewind Surge Test			
82. Post Rewind Hi-Pot			
83. Technician			
Mechanical Fits- Bearing Housings - Post Repair			
84. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
85. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
86. Bearing Cap Condition Post Repair			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
87. End Bell Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
88. End Bell Repair Sign-off			
Assembly			
89. QC Check All Parts for Cleanliness Prior to Assembly			
90. Photograph All Major Components prior to assembly			
91. Final Insulation Resistance Test			
92. Assembled Shaft Endplay			
93. Assembled Shaft Runout			
94. Test Run Voltage			
Volts	Volts	Volts	
95. Test Run Amperage			
Amps	Amps	Amps	
96. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
97. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
98. Ambient Temperature - Fahrenheit			

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99. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
100. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
101. Document Final Condition with Pictures after paint		
102. 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.
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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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