



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

LR Motor Shop Repairs

**Job Number 103535**

Prepared for Riceland Foods (11100-RLF)

Hwy 79 & N. Park Ave.  
Stuttgart AR 72160

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AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *C0304210199*

**1.0**

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

## AC Inspection as Found

Riceland Foods (11100-RLF)

Hwy 79 & N. Park Ave.  
Stuttgart, AR 72160

FolderID: 103535  
FormID: 21696236

### AC Inspection - Rev. 2

Location: MOTOR SHOP LR  
Serial Number: C0304210199  
Description: 75/60HP BALDOR 1780/1450RPM

Hi-Speed Job Number:	103535
Manufacturer:	Baldor
Spec/ID #:	14P024W982H1
Serial Number:	C0304210199
HP/kW:	75 (HP)
RPM:	1780 (RPM)
Frame:	365T
Voltage:	230 / 460
Current:	170/85 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
Enclosure:	TENV
# of Leads:	9
J-box Included:	Complete
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	No
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: ● 3 - High ● 11 - Good

### Overall Condition

1. Report Date	09/23/2024
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1.2







4. Describe the Overall Condition of the Equipment as Received  
*Dirty*

5. Report Date [COPY]

**Initial Mechanical/Electrical**

<input checked="" type="radio"/>	6. Does Shaft Turn Freely?	(Y) Yes
<input checked="" type="radio"/>	7. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
	8. Does Shaft Have Visible Damage?	(No) No
	9. Assembled Shaft Runout	Inches
	10. Assembled Shaft End Play	inches
	11. Air Gap Variation <10%	

12. Lead Condition

(F) Fail



13. Lead Length 12 Inches

14. Does it have Lugs?, If so what is the Stud Size? (No) No

15. Lead Numbers 1-9

16. Frame Condition pass

17. Fan Condition (P) Pass

18. Broken or Missing Components

1 j-box mounting bolt is broke and 2 j-box cover bolts broke



Initial Electrical Inspection



19. Insulation Resistance/Megger

Megohms

Pass



20. Winding Resistance

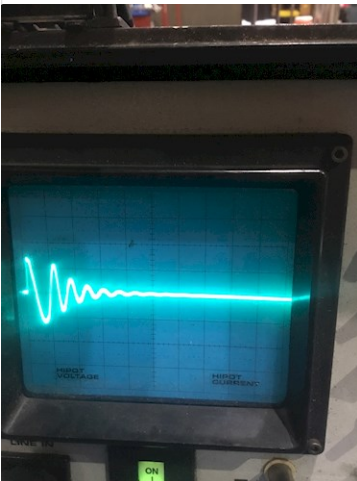
1-2

1-3

2-3

21. Perform Surge Test

(P) Pass



22. Number of Stator Slots

23. Stator Condition

pass

24. Stator Thermistors/Ohms

25. Stator Overloads/Ohms

Over load leads are bad needs new leads

### Mechanical Inspection

26. Drive End Bearing Brand

SKF

27. Drive End Bearing Number-

6313

28. Drive End Bearing Qty.

11

29. Drive End Bearing Type

(Ball) Ball Bearing

30. Drive End Lubrication Type

(Grease) Grease Lubricated

31. Drive End Bearing Insulation or Grounding Device?

Na

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

spanner nut

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## 33. Drive End Bearing Condition

 *Wear*



34. Opposite Drive End Bearing Brand	<b>SKF</b>
35. Opposite Drive End Bearing Number-	<b>6312</b>
36. Opposite Drive End Bearing Qty.	<b>1</b>
37. Opposite Drive End Bearing Type	<b>(Ball) Ball Bearing</b>
38. Opposite Drive End Lubrication Type	<b>(Grease) Grease Lubricated</b>
39. Opposite Drive End Bearing Insulation or Grounding Device?	
40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>wavy washer</b>
41. Opposite Drive End Bearing Condition	

 *Wear*



42. Drive End Seal
43. Opposite Drive End Seal

### Rotor Inspection

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

**6313**  
**6312**  
**New over load**

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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

2.5593

2.5593

2.5593

55. Drive End Bearing Shaft Fit Condition

(P) Pass

56. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.362

2.3622

2.3622

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

5.5125

5.5125

5.5124

60. Drive End - Endbell Bearing Fit Condition

(P) Pass

61. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

5.1184

5.1185

5.1184

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



Co sign: DM

### Root Cause of Failure

67. Failure locations

*Bearings, leads, and some bolts are broke from j-box*

68. Root cause of failure

*Wear*

### Dynamic Balance Report

69. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

Na

70. Initial Balance Readings

Drive End

Opposite Drive End

Na

71. Final Balance Readings

Drive End

Opposite Drive End

**0.3**

**0.2**

72. Technician

Trever

### Assembly

73. QC Check All Parts for Cleanliness Prior to Assembly

Trevor Hall



74. Photograph All Major Components prior to assembly







75. Final Insulation Resistance Test	Megohms	
76. Assembled Shaft Endplay	inches	
77. Assembled Shaft Runout	inches	
78. Test Run Voltage		
Volts	Volts	Volts

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79. Test Run Amperage

Amps

Amps

Amps

Witnessed by RRW



80. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.03

0.01

0.05

81. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

0.01

0.02

0.04

82. Ambient Temperature - Fahrenheit

83. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

84. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

85. Document Final Condition with Pictures after paint



86. Final Pics and QC Review

Cw

*Chen*

Co sign: RRW





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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.
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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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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.
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.