



KEEPING YOUR FACILITY UP TO SPEED
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LR Motor Shop Repairs

Job Number 103694

Prepared for Sage V Foods

5901 SLOAN DRIVE
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

Sage V Foods
5901 SLOAN DRIVE
LITTLE ROCK, AR 72206

FolderID: 103694
FormID: 22106163

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: F1706303504

Description: 2HP BALDOR 1750RPM

Hi-Speed Job Number: 103694

Manufacturer: Baldor

Spec/ID #: F1706303504

Serial Number: F1706303504

HP/kW: 2 (HP)

RPM: 1750 (RPM)

Frame: 145TDZ

Voltage: 230 / 460

Current: 5.8/2.9 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

of Leads: 9

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:** Yes

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 2 - High ● 11 - Good

Overall Condition

1. Report Date

11/25/2024

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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
Ok

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	0.002 Inches
9. Assembled Shaft End Play	0 inches
10. Air Gap Variation <10%	ok
11. Lead Condition	(P) Pass
12. Lead Length	12 Inches
13. Does it have Lugs?, If so what is the Stud Size?	(No) No
14. Lead Numbers	1-9
15. Frame Condition	good
16. Fan Condition	(P) Pass
17. Broken or Missing Components	none

Initial Electrical Inspection

18. Insulation Resistance/Megger	0 Megohms		
19. Winding Resistance			
1-2	1-3	2-3	
0	0	0	
 20. Perform Surge Test	(F) Fail		

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21. Number of Stator Slots	36
22. Stator Condition	rewind
23. Stator Thermistors/Ohms	none
24. Stator Overloads/Ohms	none
Mechanical Inspection	
25. Drive End Bearing Brand	NTN

26. Drive End Bearing Number-	6207 2RS
27. Drive End Bearing Qty.	1
28. Drive End Bearing Type	(Ball) Ball Bearing
29. Drive End Lubrication Type	(Grease) Grease Lubricated
30. Drive End Bearing Insulation or Grounding Device?	none
31. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
32. Drive End Bearing Condition	ok
33. Opposite Drive End Bearing Brand	NTN
34. Opposite Drive End Bearing Number-	6203 2RS
35. Opposite Drive End Bearing Qty.	1
36. Opposite Drive End Bearing Type	(Ball) Ball Bearing
37. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
38. Opposite Drive End Bearing Insulation or Grounding Device?	none
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy
40. Opposite Drive End Bearing Condition	ok
41. Drive End Seal	labyrinth
42. Opposite Drive End Seal	labyrinth
Rotor Inspection	
43. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
44. Growler Test	(Pass) Pass
45. Number of Rotor Bars	28
46. Rotor Condition	good
47. List the Parts needed for the Repair Below	
	6207 2RS, 6203 2RS, rewind

48. Signature of Technician that Disassembled Motor

David Maclin



Mechanical Fits- Rotor

49. Shaft Runout 2 inches

50. Rotor Runout

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0	0	0

51. Coupling Fit Closest to Bearing Housing

0 Degrees	90 Degrees	120 Degrees
0	0	0

52. Coupling Fit Closest to the end of the Shaft

0 Degrees	60 Degrees	120 Degrees
0	0	0

53. Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
1.3782	1.3783	1.3782

54. Drive End Bearing Shaft Fit Condition (P) Pass

55. Opposite Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
0.6693	0.6693	0.6693

56. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

57. Shaft Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal
ok	ok

Mechanical Fits- Bearing Housings

58. Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
2.835	2.835	2.835

59. Drive End - Endbell Bearing Fit Condition (P) Pass

60. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
1.5765	1.5768	1.576

61. Opposite Drive End - Endbell Bearing Fit Condition (F) Fail

62. Bearing Cap Condition

Drive End Bearing Cap	Opposite Drive End Bearing Cap
ok	na

63. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal
ok	ok

64. List Machine Work Needed Below

Ode sleeve endbell

65. Technician

David Maclin

**Root Cause of Failure**

66. Failure locations

Ode end bell went down causing rotor stator contact

67. Root cause of failure

*Vibration/alignment***Dynamic Balance Report**

68. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

69. Initial Balance Readings

Drive End

Opposite Drive End

70. Final Balance Readings

Drive End

Opposite Drive End

71. Technician

Rewind

72. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

73. Core Hot Spot Test

Pre-Burnout

Post-Burnout

74. Post Rewind Electrical Test- Insulation Resistance

Megohms

75. Post Rewind Polarization Index

Polarization Index

76. Post Rewind Winding Resistance

1-2

1-3

2-3

77. Post Rewind Surge Test

78. Post Rewind Hi-Pot

micro-amps

79. Technician

Mechanical Fits- Bearing Housings - Post Repair

80. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees


120 Degrees

81. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
1.575	1.575	1.5751



82. Bearing Cap Condition Post Repair		
Drive End Bearing Cap		Opposite Drive End Bearing Cap
83. End Bell Air Seal Fits Post Repair		
Drive End Air Seal		Opposite Drive End Air Seal
84. End Bell Repair Sign-off		Gary

Assembly

85. QC Check All Parts for Cleanliness Prior to Assembly		Crw
		

86. Photograph All Major Components prior to assembly		(Complete) Complete
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87. Final Insulation Resistance Test	Megohms
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88. Assembled Shaft Endplay	inches	
89. Assembled Shaft Runout	0.002 inches	
90. Test Run Voltage		
Volts	Volts	Volts



91. Test Run Amperage		
Amps	Amps	Amps
 <i>Witnessed by TH</i>		



92. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
93. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
94. Ambient Temperature - Fahrenheit		
95. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
96. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
97. Document Final Condition with Pictures after paint		

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98. Final Pics and QC Review

Cw

Co sign: TH



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

AC Random Coil Rewind Report


FolderID: 103694
FormID: 22588586

Sage V Foods
5901 SLOAN DRIVE
LITTLE ROCK, AR 72206

Priorities Found: 2 - Good

General	
1. Job Number	103694
2. Report Date	
3. Customer	Sage Foods
Stator Winding	
4. Core Length	3.625 "
1.25 head both sides	
5. Core ID	3.875 "
6. Back Iron Depth	0.5 "
7. Slot Depth	0.5 "
8. Tooth Width	0.125 "
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	1.01 W/lbs.
15. After Burnout Core Loss	
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	
19. Core Iron Condition	(P) Pass
20. RTD's	(N) No
21. RTD's Reading	Ohm's
22. Motor Heaters	(N) No
23. Heater Qty.	0
24. Heater Voltage	
25. Heater Wattage	
26. Thermistors	
27. Number of Poles	4
28. Slots	36
29. Number of Coils	24
30. Coil Weight	Lbs.
31. Lead Markings	
1-9	

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32. Grouping	
12 Of2	
33. Multiple Wires	(Y) Yes
34. Wire Size	
1#22 1#23	
35. Turns per coil	
26-56	
1-7 1-9	
36. Pitch 1 to:	
7&9	
37. Connection	
1 wye @460v	
38. Lead Length	8 "
39. Lead Size	18
40. Number of Leads	9
41. Megger Reading After Rewind	7819 Mohms
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	0.07539999999999999 Ua
46. Surge Pattern After Rewind	(P) Pass
47. Service Technician	
	
<p>Ode 1.625 Dr end 1.375 5lbs #19 awg 12' #18 600v epdm 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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