



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

LR Motor Shop Repairs

**Job Number 104422**

Prepared for Sage V Foods

5901 SLOAN DRIVE  
LITTLE ROCK AR 72206

# Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: Z1512110426

1.0

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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: 104422  
FormID: 24050659

### AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: Z1512110426

Description: 20 HP BALDOR

Hi-Speed Job Number: 104422

Manufacturer: Baldor

Product Number: CAT#EM2334T

Spec/ID #: 09P011Y583G1

Serial Number: Z1512110426

HP/kW: 20 (HP)

RPM: 1765 (RPM)

Frame: 256T

Voltage: 230 / 460

Current: 48/24 (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: No

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 ● 12 - Good

### Overall Condition

1. Report Date

04/22/2025

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## 2. Nameplate Picture



3. Photos of all six sides of the machine.



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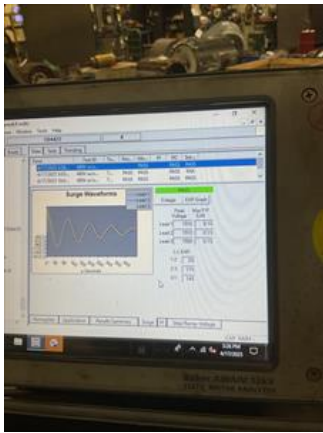
4. Describe the Overall Condition of the Equipment as Received		
<i>Serviceable</i>		
● 5. Is this a UL Listed Motor		(No) No
● 6. Is the motor water cooled or can be pressure checked before teardown		(No) No
<b>Initial Mechanical/Electrical</b>		
● 7. Does Shaft Turn Freely?		(Y) Yes
● 8. Does the shaft require T.I.R in Lathe to identify additional repairs?		(No) No
9. Does Shaft Have Visible Damage?		(No) No
● 10. Assembled Shaft Runout		0.0002 Inches
11. Assembled Shaft End Play		inches
12. Air Gap Variation <10%		
● 13. Lead Condition		(P) Pass
14. Lead Length		10 Inches
● 15. Does it have Lugs?, If so what is the Stud Size?		(No) No
16. Lead Numbers		1-9
● 17. Are the Leads insulated with Chico or other material		(No) No
18. Frame Condition		pass
● 19. Fan Condition		(F) Fail
■ <i>Fan clamp broke</i>		



● 20. Does motor have internal fan?	(No) No
21. Broken or Missing Components	no
<b>Initial Electrical Inspection</b>	

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22. Insulation Resistance/Megger	8008 Megohms	
23. Winding Resistance		
1-2	1-3	2-3
0.425	0.429	0.433
24. Perform Surge Test	(P) Pass	



25. Number of Stator Slots	36
26. Stator Condition	wash and dry



27. Stator Thermistors/Ohms	na
28. Stator Overloads/Ohms	na
<b>Mechanical Inspection</b>	
29. Drive End Bearing Brand	SKF



30. Drive End Bearing Number-

6309 C3



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?	no
35. Drive End Wavy Washer/Snap-Ring Other Retention Device?	na
36. Drive End Bearing Condition	metal fatigue and fluting



37. Opposite Drive End Bearing Brand	SKF
38. Opposite Drive End Bearing Number-	6208 C3



39. Opposite Drive End Bearing Qty.	1
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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?	na
43. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
44. Opposite Drive End Bearing Condition	axial load and fluting



45. Drive End Seal	NA
46. Opposite Drive End Seal	NA

#### Rotor Inspection

47. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
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48. Growler Test	(Pass) Pass
49. Number of Rotor Bars	42
50. Rotor Condition	wash
51. List the Parts needed for the Repair Below 1-6309ZZC3 1-6208ZZC3	
52. Signature of Technician that Disassembled Motor	RW

*[Handwritten Signature]*

#### Mechanical Fits- Rotor

53. Shaft Runout	0.0002 inches
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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	
1.772	1.772	1.772	
58. Drive End Bearing Shaft Fit Condition			(P) Pass



59. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
1.5751	1.5751	1.5751	
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

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62. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
3.9379	3.9379	3.9379	
63. Drive End - Endbell Bearing Fit Condition			(P) Pass



64. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
3.1507	3.1507	3.1504	
65. Opposite Drive End - Endbell Bearing Fit Condition			(F) Fail

Resleeve

66. Bearing Cap Condition			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
Pass			

67. End Bell Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Pass			

68. List Machine Work Needed Below			
Ope end bell			

69. Technician			RW
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*[Handwritten signature]*

Co sign: CW

### Root Cause of Failure

70. Failure locations			
Bearings and mixed grease			
71. Root cause of failure			
Both bearings had fluting and drive bearing had metal fatigue .needs aegis ring			

### Dynamic Balance Report

72. Rotor Weight and Balance Grade			
Rotor Weight	Balance Grade		

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73. Initial Balance Readings			
Drive End	Opposite Drive End		
74. Final Balance Readings			
Drive End	Opposite Drive End		
75. Technician			
<b>Mechanical Fits- Bearing Housings - Post Repair</b>			
76. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
77. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
78. Bearing Cap Condition Post Repair			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
79. End Bell Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
80. End Bell Repair Sign-off			
<b>Assembly</b>			
81. QC Check All Parts for Cleanliness Prior to Assembly			
82. Photograph All Major Components prior to assembly			
83. Final Insulation Resistance Test			
84. Assembled Shaft Endplay			
85. Assembled Shaft Runout			
86. Test Run Voltage			
Volts	Volts	Volts	
87. Test Run Amperage			
Amps	Amps	Amps	
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			
94. Final Pics and QC Review			

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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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