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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 103910**

Prepared for Saint Jean Industries, Inc. (11653)

424 Industrial Park Road  
Heber Springs AR 72543

# Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *S9062235-001*

**1.0**

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*Printed on 3/14/2025*

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

**AC Inspection as Found**  
**Saint Jean Industries, Inc. (11653)**  
424 Industrial Park Road  
Heber Springs, AR 72543

FolderID: 103910  
FormID: 22675598

**AC Inspection - Rev. 2**

**Location:** MOTOR SHOP LR

**Serial Number:** S9062235-001

**Description:** 300 HP BALDOR

**Hi-Speed Job Number:** 103910

**Manufacturer:** Baldor

**Spec/ID #:** P44G5097

**Serial Number:** S9062235-001

**HP/kW:** 300 (HP)

**RPM:** 1780 (RPM)

**Frame:** 449T

**Voltage:** 460

**Current:** 329

**Phase:** Three

**Hz:** 60 (Hz)

**Service Factor:** 1.15

**Enclosure:** DP

**# of Leads:** 12

**J-box Included:** None

**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: ● 2 - High ● 10 - Good

**Overall Condition**

1. Report Date

01/03/2025

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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

*Serviceable*

#### 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	0.0002 Inches
9.	Assembled Shaft End Play	inches
	Na	






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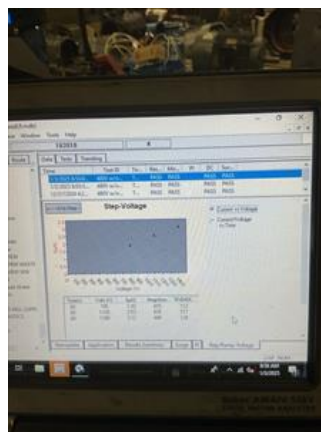
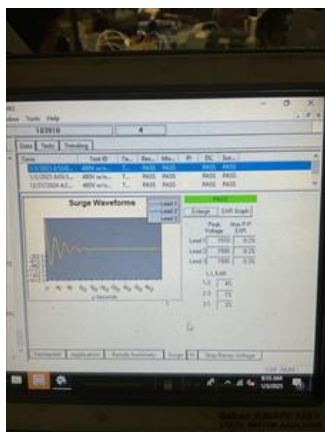
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1.2



10.	Air Gap Variation <10%		
	Na		
	11. Lead Condition	(P) Pass	
	12. Lead Length	18 Inches	
	13. Does it have Lugs?, If so what is the Stud Size?	(No) No	
	14. Lead Numbers	1-12	
	15. Frame Condition	pass	
	16. Fan Condition	(N) NA	
	17. Broken or Missing Components	missing connection box	
	None		
Initial Electrical Inspection			
	18. Insulation Resistance/Megger	390 Megohms	
	19. Winding Resistance		
	1-2	1-3	2-3
	0.01179	0.01185	0.01176
	20. Perform Surge Test	(P) Pass	



Step voltage

21. Number of Stator Slots	72
22. Stator Condition	wash and dry



23. Stator Thermistors/Ohms	na
24. Stator Overloads/Ohms	na

### Mechanical Inspection

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25. Drive End Bearing Brand	<b>SKF</b>
26. Drive End Bearing Number-	<b>6318</b>



27. Drive End Bearing Qty.	<b>1</b>
28. Drive End Bearing Type	<b>(Ball) Ball Bearing</b>
29. Drive End Lubrication Type	<b>(Grease) Grease Lubricated</b>
30. Drive End Bearing Insulation or Grounding Device?	<b>Na</b>
31. Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>na</b>
32. Drive End Bearing Condition	<b>water contamination</b>



33. Opposite Drive End Bearing Brand	<b>SKF</b>
34. Opposite Drive End Bearing Number-	<b>6318 ZZC3</b>




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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?	NA
39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	Wavy washer
40. Opposite Drive End Bearing Condition	water contamination



41. Drive End Seal	pass
42. Opposite Drive End Seal	pass
<b>Rotor Inspection</b>	
43. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
44. Growler Test	(Pass) Pass
45. Number of Rotor Bars	56
46. Rotor Condition	
 Wash	



47. List the Parts needed for the Repair Below <b>2-6318 ZZ C3 BEARING</b>	
48. Signature of Technician that Disassembled Motor	RW
	

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**Mechanical Fits- Rotor**

49. Shaft Runout	0 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
3.3743	3.3743	3.3743
52. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
3.3742	3.3742	3.3742
53. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
3.5435	3.5435	3.5435
54. Drive End Bearing Shaft Fit Condition	(P) Pass	



55. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
3.5435	3.5435	3.5435
56. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass	



57. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
pass	pass	

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## Mechanical Fits- Bearing Housings

58. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

7.4819

7.4818

7.4818

● 59. Drive End - Endbell Bearing Fit Condition

(F) Fail



60. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

7.482

7.4819

7.482

● 61. Opposite Drive End - Endbell Bearing Fit Condition

(F) Fail



## 62. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass



## 63. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

pass

pass

## 64. List Machine Work Needed Below

*De and. Ode end bell bearing fit bad*

## 65. Technician

RW



Co sign CRW

## Root Cause of Failure

## 66. Failure locations

*Bearing and housing . Winding very dirty*

## 67. Root cause of failure

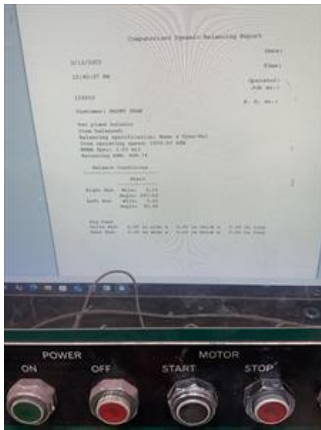
*Water*

## Dynamic Balance Report

## 68. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



## 69. Initial Balance Readings

Drive End

Opposite Drive End

0.15

0.22

## 70. Final Balance Readings

Drive End

Opposite Drive End

0.15

0.22

## 71. Technician

RW

## Mechanical Fits- Bearing Housings - Post Repair

## 72. Drive End - Endbell Bearing Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

7.481

7.481

7.481




73. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
7.4805	7.4805	7.4804



74. Bearing Cap Condition Post Repair		
Drive End Bearing Cap		Opposite Drive End Bearing Cap
75. End Bell Air Seal Fits Post Repair		
Drive End Air Seal		Opposite Drive End Air Seal
76. End Bell Repair Sign-off		Gary
.		

Assembly

77. QC Check All Parts for Cleanliness Prior to Assembly	RW
	

78. Photograph All Major Components prior to assembly	(Complete) Complete
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79. Final Insulation Resistance Test

**5230 Megohms**

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80. Assembled Shaft Endplay	0 inches	
81. Assembled Shaft Runout	0 inches	
82. Test Run Voltage		
Volts	Volts	Volts
456	456	457



Co sign TRH

83. Test Run Amperage		
Amps	Amps	Amps
87	85.40000000000001	83.90000000000001



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84. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
<b>0.01</b>	<b>0.01</b>	<b>0.05</b>
85. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
<b>0.02</b>	<b>0.02</b>	<b>0.05</b>
86. Ambient Temperature - Fahrenheit		
87. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
88. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
89. Document Final Condition with Pictures after paint		





90. Final Pics and QC Review

RW



Co sign TRH



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