



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

LR Motor Shop Repairs

Job Number 104415

Prepared for Tyson Foods (10914)

1238 Market Street
Clarksville AR 72830

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

AC Inspection as Found

Tyson Foods (10914)

1238 Market Street
Clarksville, AR 72830

FolderID: 104415
FormID: 24037883

AC Inspection - Rev. 2

Location: LR MOTOR SHOP

Serial Number: 12H013Y276

Description: 40 HP BALDOR

Hi-Speed Job Number: 104415

Manufacturer: Baldor

Product Number: CAT#EM4110T

Serial Number: 12H013Y276

HP/kW: 40 (HP)

RPM: 1775 (RPM)

Frame: 324T

Voltage: 230 / 460

Current: 96 / 48 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.0

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:** No

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 1 - High ● 15 - Good

Overall Condition

1. Report Date

04/18/2025

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2. Nameplate Picture



3. Photos of all six sides of the machine.



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Printed on 5/22/2025



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1.2



4. Describe the Overall Condition of the Equipment as Received		
<i>Serviceable</i>		
<input checked="" type="radio"/>	5. Is this a UL Listed Motor	(No) No
<input checked="" type="radio"/>	6. Is the motor water cooled or can be pressure checked before teardown	(No) No
Initial Mechanical/Electrical		
<input checked="" type="radio"/>	7. Does Shaft Turn Freely?	(Y) Yes
<input checked="" type="radio"/>	8. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
	9. Does Shaft Have Visible Damage?	(No) No
<input checked="" type="radio"/>	10. Assembled Shaft Runout	0.002 Inches

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11. Assembled Shaft End Play	0 inches
12. Air Gap Variation <10%	
● 13. Lead Condition	(P) Pass
	
14. Lead Length	11 Inches
● 15. Does it have Lugs?, If so what is the Stud Size?	(No) No
16. Lead Numbers	1-9
17. Frame Condition	pass
● 18. Fan Condition	(P) Pass
	
● 19. Does motor have internal fan?	(No) No
20. Broken or Missing Components	
● 21. Are the Leads insulated with Chico or other material	(No) No
Initial Electrical Inspection	

Megohms

23. Winding Resistance

2-3

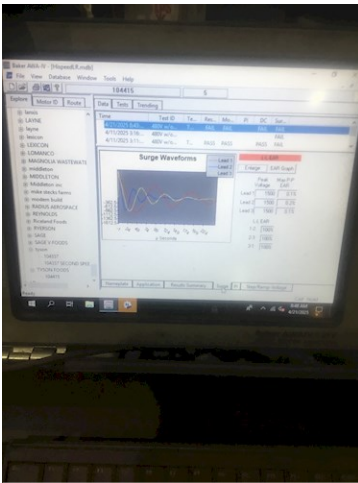
24. Perform Surge Test

(F) Fail

Test Type	Step-Voltage	No Test	No Test
Volt (V)	89	1398	
(μA)	111.0	0.0797	
Resist	1	17534	
At 40°C		4734	
Surge Status	L-L E&B	Leak P-P E&B	Leak P-P E&B
Peak Volt(V) L1	1500	1500	No Test
Peak Volt(V) L2	1500	1040	
Peak Volt(V) L3	1500	0	
Max P-P E&B	0.1-0.2/O.I	0.1/28.0/-	0.2/16.3/-
E&B -2/2-S-	100/100/100	94/-/-	97/-/-

Nameplate	Application	Results Summary	Surge IN	Step/Surge Voltage
<div style="text-align: right;">E&B 42U0</div>				

1.5



25. Number of Stator Slots	48
26. Stator Condition	rewind
27. Stator Thermistors/Ohms	
28. Stator Overloads/Ohms	

Mechanical Inspection

29. Drive End Bearing Brand	SKF
30. Drive End Bearing Number-	6312/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?	none
35. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
36. Drive End Bearing Condition	evidence of frosting

37. Opposite Drive End Bearing Brand

FAG



38. Opposite Drive End Bearing Number-

6311 C3



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?

wavy washer



44. Opposite Drive End Bearing Condition

evidence of frosting on inner
and outer races

45. Drive End Seal

VA-055

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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

41

50. Rotor Condition

pass

51. List the Parts needed for the Repair Below

1) 6312/C3
1) 6311/C3
Rewind stator

52. Signature of Technician that Disassembled Motor

Terrence Holland

Mechanical Fits- Rotor

53. Shaft Runout


0.002 inches

54. Rotor Runout

Drive End Bearing Fit

Rotor Body

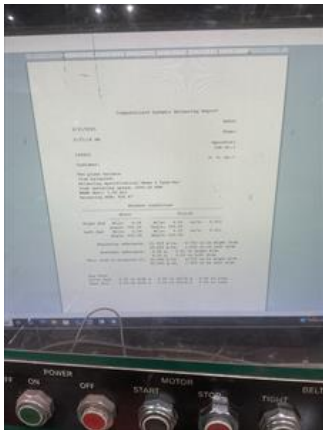
Opposite Drive End Bearing

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	
2.3625	2.3626	2.2625	
58. Drive End Bearing Shaft Fit Condition			(P) Pass
59. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.1659	2.1659	2.1659	
60. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
61. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Mechanical Fits- Bearing Housings			
62. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.1184	5.1182	5.1182	
63. Drive End - Endbell Bearing Fit Condition			(P) Pass
64. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
4.725	4.7251	4.72	
65. Opposite Drive End - Endbell Bearing Fit Condition			(P) Pass
66. Bearing Cap Condition			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
pass	pass		
67. End Bell Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
68. List Machine Work Needed Below	<i>Two broken bolts on connection box. Drill and tap connection box cover bolt holes</i>		
69. Technician	Terrence Holland		
			
Co sign: CRW			
Root Cause of Failure			
70. Failure locations	<i>Windings shorted. Both bearings have frosting.</i>		
71. Root cause of failure	<i>Windings shorted between phases.</i>		
Dynamic Balance Report			

72. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



73. Initial Balance Readings

Drive End

Opposite Drive End

0.54

0.52

74. Final Balance Readings

Drive End

Opposite Drive End

0.54

0.53

75. Technician

RW

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

Megohms

79. Post Rewind Polarization Index

Polarization Index

80. Post Rewind Winding Resistance

1-2

1-3

2-3

81. Post Rewind Surge Test

82. Post Rewind Hi-Pot

micro-amps

83. Technician

Assembly

84. QC Check All Parts for Cleanliness Prior to Assembly

RW

[Handwritten signature]

85. Photograph All Major Components prior to assembly

(Complete) Complete





86. Final Insulation Resistance Test

17,800 Megohms



87. Assembled Shaft Endplay	0 inches
88. Assembled Shaft Runout	0.0003 inches
89. Test Run Voltage	

Volts	Volts	Volts
454	453	455

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Co sign CRW

90. Test Run Amperage		
Amps	Amps	Amps
20.2	20.3	19.6



91. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.04	0.04	0.03
92. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.04	0.04	0.04
93. Ambient Temperature - Fahrenheit		
94. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
95. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
96. Document Final Condition with Pictures after paint		

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97. Final Pics and QC Review

RW

Co sign CRW



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

AC Random Coil Rewind Report

FolderID: 104415
FormID: 24282213

Tyson Foods (10914)


1238 Market Street
Clarksville, AR 72830

LR MOTOR SHOP

Priorities Found: 5 - Good

General		
1.	Job Number	104415
2.	Report Date	04/30/2025
3.	Customer	Tyson Food
Stator Winding		
4.	Core Length	6.75 "
5.	Core ID	8.5 "
6.	Back Iron Depth	1.125 "
7.	Slot Depth	1.3125 "
8.	Tooth Width	0.25 "
9.	Number of Vents	
10.	Vent Width	
	11. Before Burnout Core loss	(P) Pass
	12. Flux Before Burnout	
	13. Watts before burnout	
	14. Watts loss per lb. before burnout	1.49 W/lbs.
	15. After Burnout Core Loss	(P) Pass
	16. Flux After burnout	
	17. Watts After Burnout	Watts
	18. Watts loss per lb After Burnout	1.192 W/lbs.
	19. Core Iron Condition	(P) Pass
	20. RTD's	
	21. RTD's Reading	
	22. Motor Heaters	
	23. Heater Qty.	
	24. Heater Voltage	
	25. Heater Wattage	
	26. Thermistors	
	27. Number of Poles	4
	28. Slots	48
	29. Number of Coils	36
	30. Coil Weight	
	31. Lead Markings	
	32. Grouping	
	12of3 7-9 lap	
	33. Multiple Wires	(Y) Yes
	2	

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34. Wire Size	
	3#17 2#18.
35. Turns per coil	
	16-17-32
36. Pitch 1 to:	
	8-10-12
37. Connection	
	2&4Delta
38. Lead Length	"
	12"
39. Lead Size	
	5#8 EXAR
40. Number of Leads	9
41. Megger Reading After Rewind	7915 Mohms
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	0.08203000000000001 Ua
46. Surge Pattern After Rewind	(P) Pass
47. Service Technician	LE 3.50. OE 3.50
	
<div> <div></div> <div> 40Lbs total 25Lbs #17 15Lbs #18 5#8 EXAR Lead Wire </div> </div>	







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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.
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