



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

LR Motor Shop Repairs

Job Number 104540

Prepared for Westrock Coffee

30 Collins Industrial Pl
North Little Rock AR 72113

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AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *IEC60034*

1.0

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AC Inspection as Found

Westrock Coffee
30 Collins Industrial Pl
North Little Rock, AR 72113

FolderID: 104540
FormID: 24301248

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: IEC60034

Description: .42 KW REXROTH

Hi-Speed Job Number: 104540

Manufacturer: Other

Product Number: 13496159

Spec/ID #: UL1004-1

Serial Number: IEC60034

HP/kW: .42 (HP)

RPM: 1680 (RPM)

Voltage: 230 / 460

Current: 1.65/0.90 (Amps)

Phase: Three

Hz: 60 (Hz)

Enclosure: TEFC

of Leads: 6

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: ● 2 - High ● 12 - Good

Overall Condition

1. Report Date

05/27/2025

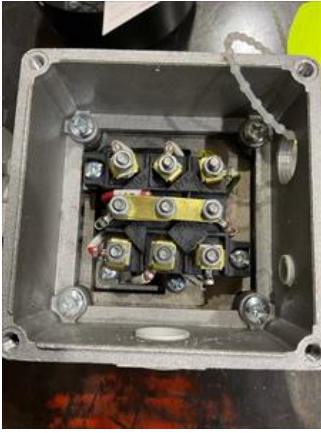
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2. Nameplate Picture



3. Photos of all six sides of the machine.





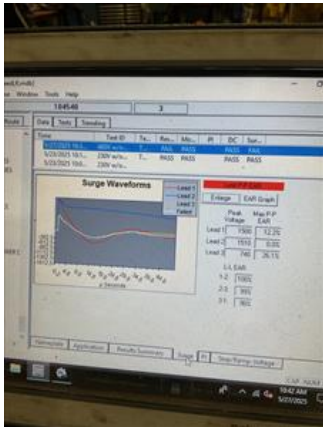
4.	Describe the Overall Condition of the Equipment as Received	
	<i>Serviceable</i>	
● 5.	Is this a UL Listed Motor	(No) No
● 6.	Is the motor water cooled or can be pressure checked before teardown	(No) No
Initial Mechanical/Electrical		
● 7.	Does Shaft Turn Freely?	(Y) Yes
● 8.	Does the shaft require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



● 20.	Does motor have internal fan?	(No) No
	21. Broken or Missing Components	
Initial Electrical Inspection		
	22. Insulation Resistance/Megger	7103 Megohms

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23. Winding Resistance			
1-2	1-3	2-3	
30.91	30.91	36.94	
24. Perform Surge Test			(F) Fail



25. Number of Stator Slots	24
26. Stator Condition	rewind
27. Stator Thermistors/Ohms	
28. Stator Overloads/Ohms	1.9 ohms
Mechanical Inspection	
29. Drive End Bearing Brand	SKF
30. Drive End Bearing Number-	6205
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?	Na
35. Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
36. Drive End Bearing Condition	
37. Opposite Drive End Bearing Brand	SKF
38. Opposite Drive End Bearing Number-	6204
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?	NA
43. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
44. Opposite Drive End Bearing Condition	
45. Drive End Seal	yes
46. Opposite Drive End Seal	NA
Rotor Inspection	

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47. Rotor Type/Material

(Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast



48. Growler Test

49. Number of Rotor Bars

50. Rotor Condition



51. List the Parts needed for the Repair Below

52. Signature of Technician that Disassembled Motor

RW

Mechanical Fits- Rotor

53. Shaft Runout

0 inches

54. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

0

0

0

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

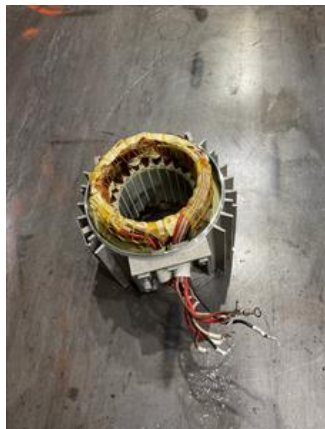
120 Degrees

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57. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
58. Drive End Bearing Shaft Fit Condition		(P) Pass
59. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
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		
62. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
63. Drive End - Endbell Bearing Fit Condition		(P) Pass
64. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
65. Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
66. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
67. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
Pass		
68. List Machine Work Needed Below		
69. Technician		RW
		
Co sign: CRW		
Root Cause of Failure		
70. Failure locations		
Winding		

71. Root cause of failure

Shorted in windings



Dynamic Balance Report

72. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

73. Initial Balance Readings

Drive End

Opposite Drive End

74. Final Balance Readings

Drive End

Opposite Drive End

75. Technician

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

79. Post Rewind Polarization Index

80. Post Rewind Winding Resistance

1-2

1-3

2-3

81. Post Rewind Surge Test

82. Post Rewind Hi-Pot

83. Technician

Assembly

84. QC Check All Parts for Cleanliness Prior to Assembly

85. Photograph All Major Components prior to assembly

86. Final Insulation Resistance Test

87. Assembled Shaft Endplay

88. Assembled Shaft Runout

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89. Test Run Voltage			
Volts	Volts	Volts	
90. Test Run Amperage			
Amps	Amps	Amps	
91. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
92. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
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			
97. Final Pics and QC Review			



STANDARD TERMS AND CONDITIONS FOR PURCHASE OF GOOD AND/OR SERVICES

1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
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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.
6. **DELIVERY SITE AND TIME FOR PERFORMANCE.** Hi-Speed and Buyer agree that time is of the essence for the purchase order and that Buyer shall fully cooperate with Hi-Speed in order to allow Hi-Speed full access to prosecute its work diligently and in an orderly manner. Buyer shall assist Hi-Speed in every way possible to avoid delaying, disrupting or interfering with the progress of Hi-Speed's work at the project site. In the event Hi-Speed's work is delayed, hindered, suspended, disrupted, re-sequenced or interfered with or rendered less efficient or more costly or adversely affected in any way as a result of acts or omissions of Buyer or other contractors or employees of Buyer or by any other reason beyond Hi-Speed's control and without the fault of Hi-Speed, then, in such event, Buyer shall be liable to Hi-Speed for any damages, additional costs, expenses, labor, materials, man hours, acceleration costs, overtime, additional jobsite overhead, extended home office overhead, and any and all other direct and indirect expenses of whatsoever nature or kind, caused in whole or in part, as a result of any of the above-referenced occurrences. Hi-Speed's project records will be the basis for computing the additional costs and damages of Hi-Speed's labor, materials, expenses and overhead related to such changes. BUYER WARRANTS THAT THE SITE FOR DELIVERY OR INSTALLATION OF ANY GOODS AND/OR FOR THE PERFORMANCE OF ANY SERVICES SHALL BE READY AND ADEQUATE FOR HI-SPEED'S DELIVERY OF GOODS AND/OR PERFORMANCE OF SERVICES AND THAT HI-SPEED SHALL HAVE FULL ACCESS THERETO, FREE OF ALL OBSTRUCTIONS. BUYER SHALL ASSUME ALL EXTRA COSTS ASSOCIATED WITH HI-SPEED'S INABILITY TO INSTALL ANY GOODS OR PERFORM ANY SERVICES AS A RESULT OF BUYER'S FAILURE TO COMPLY WITH THIS PROVISION. HI-SPEED MAY NOT INSPECT THE SITE PRIOR TO DELIVERY AND/OR INSTALLATION OF GOODS AND/OR PERFORMANCE OF SERVICES AND MAKES NO WARRANTY AS TO THE SUFFICIENCY OF THE SITE FOR THE DELIVERY AND/OR INSTALLATION OF GOODS AND/OR THE PERFORMANCE OF SERVICES AT SUCH SITE.
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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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