



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

LR Motor Shop Repairs

**Job Number 104416**

Prepared for Westrock Coffee

30 Collins Industrial Pl  
North Little Rock AR 72113

# Table of Contents

AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *C2306231387*

**1.0**

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*Printed on 5/8/2025*

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

## AC Inspection as Found

### Westrock Coffee

30 Collins Industrial Pl  
North Little Rock, AR 72113

FolderID: 104416  
FormID: 24038444

#### AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: C2306231387

Description: 100 HP BALDOR

Hi-Speed Job Number: 104416

Manufacturer: Baldor

Product Number: CAT#EM2555T-4G

Spec/ID #: 44E227W390G1

Serial Number: C2306231387

HP/kW: 100 (HP)

RPM: 1780 (RPM)

Frame: 404T

Voltage: 460

Current: 118 (Amps)

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: ODP

# 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 ● 17 - Good

#### Overall Condition

1. Report Date

05/08/2025

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## 2. Nameplate Picture



## 3. Photos of all six sides of the machine.



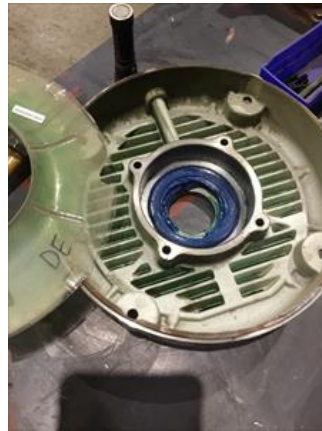


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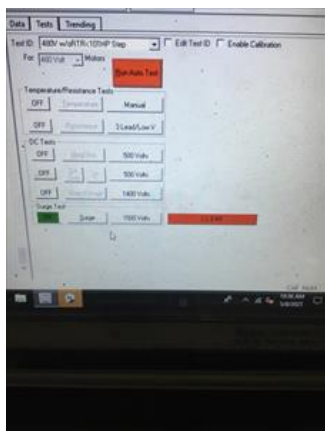




4. Describe the Overall Condition of the Equipment as Received		
<i>Dirty</i>		
5. Is this a UL Listed Motor	(No)	No
6. Is the motor water cooled or can be pressure checked before teardown	(No)	No
<b>Initial Mechanical/Electrical</b>		
7. Does Shaft Turn Freely?	(Y)	Yes
8. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No)	No
9. Does Shaft Have Visible Damage?	(No)	No
10. Assembled Shaft Runout		0.01 Inches

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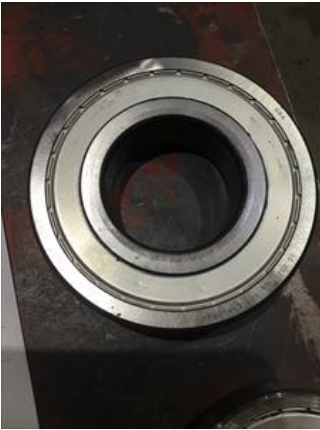
11. Assembled Shaft End Play	inches
12. Air Gap Variation <10%	
13. Lead Condition	(NA) Not Applicable
14. Lead Length	18 Inches
15. Does it have Lugs?, If so what is the Stud Size?	(No) No
16. Lead Numbers	1-6
17. Frame Condition	
18. Fan Condition	(N) NA
19. Does motor have internal fan?	(No) No
20. Broken or Missing Components	
21. Are the Leads insulated with Chico or other material	(No) No
<b>Initial Electrical Inspection</b>	
22. Insulation Resistance/Megger	Megohms
23. Winding Resistance	
1-2	1-3 2-3
24. Perform Surge Test	(F) Fail



25. Number of Stator Slots	48
26. Stator Condition	
<b>Rewind</b>	
27. Stator Thermistors/Ohms	
28. Stator Overloads/Ohms	
<b>Mechanical Inspection</b>	
29. Drive End Bearing Brand	skf

30. Drive End Bearing Number-

6316



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?

 Aegis ring

35. Drive End Wavy Washer/Snap-Ring Other Retention Device?

36. Drive End Bearing Condition

 Contamination



37. Opposite Drive End Bearing Brand skf

38. Opposite Drive End Bearing Number- 6312





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	
<div> <div></div> <div>Contamination</div> </div>	



45. Drive End Seal	
46. Opposite Drive End Seal	
<b>Rotor Inspection</b>	
47. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
48. Growler Test	(Pass) Pass
49. Number of Rotor Bars	40
50. Rotor Condition	
51. List the Parts needed for the Repair Below	
<div> <div>6316</div> <div>6312</div> <div>Aegis ring</div> </div>	

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52. Signature of Technician that Disassembled Motor

Cw



### Mechanical Fits- Rotor

53. Shaft Runout 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

3.1494-3.1493-3.1494

58. Drive End Bearing Shaft Fit Condition

(P) Pass

59. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

2.3624-2.3623-2.3624

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

6.6931-6.6932-6.6931

63. Drive End - Endbell Bearing Fit Condition

(P) Pass

64. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

5.1184-5.1185-5.1184

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

68. List Machine Work Needed Below

69. Technician

Cw



Co sign: DM

**Root Cause of Failure**

70. Failure locations

*Bearings and windings*

71. Root cause of failure

*Turn to turn short and contamination***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

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			



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