



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

LR Motor Shop Repairs

Job Number 104650

Prepared for Westrock Coffee

30 Collins Industrial Pl
North Little Rock AR 72113

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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: 104650
FormID: 24514843

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: 1LE15232DB234AB4-Z

Description: 125 HP SIEMANS

Hi-Speed Job Number:	104650
Manufacturer:	Siemens
Product Number:	1CV3282B
Spec/ID #:	UC2306/339217001
Serial Number:	1LE15232DB234AB4-Z
HP/kW:	125 (HP)
RPM:	1785 (RPM)
Frame:	IP55
Voltage:	460
Current:	136 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TEFC
# of Leads:	6
J-box Included:	Complete
Coupling/Sheave:	Coupling
Date Received:	05/21/2025
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 ● 9 - Good

Overall Condition

- | | |
|----------------------|------------|
| 1. Report Date | 05/21/2025 |
| 2. Nameplate Picture | |

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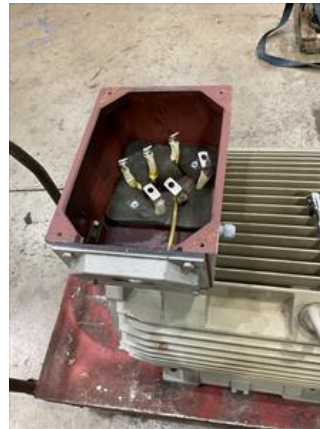




3. Photos of all six sides of the machine.

Some pics on nameplate tab





4.	Describe the Overall Condition of the Equipment as Received	
	<i>Overloaded</i>	
5.	Distance from the end of the shaft to the Coupling/Sheave	2.125 inches
6.	Is this a UL Listed Motor	(No) No
7.	Is the motor water cooled or can be pressure checked before teardown	(No) No
Initial Mechanical/Electrical		
8.	Does Shaft Turn Freely?	(Y) Yes
	<i>Fan hitting something in fan cover</i>	
9.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No

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10.	Does Shaft Have Visible Damage?	(No) No
● 11.	Assembled Shaft Runout	0 Inches
12.	Assembled Shaft End Play	inches
13.	Air Gap Variation <10%	
14.	Lead Condition	
15.	Lead Length	6 Inches
● 16.	Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
	3/8 eyelet	
17.	Lead Numbers	1-6
● 18.	Are the Leads insulated with Chico or other material	(No) No
● 19.	Frame Condition	good
● 20.	Fan Condition	(F) Fail
	Needs new fan melted off	
● 21.	Does motor have internal fan?	(No) No
22.	Broken or Missing Components	
Initial Electrical Inspection		
23.	Insulation Resistance/Megger	Megohms
24.	Winding Resistance	
	1-2	1-3 2-3
25.	Perform Surge Test	
26.	Number of Stator Slots	48
27.	Stator Condition	overloaded
28.	Stator Thermistors/Ohms	142
29.	Stator Overloads/Ohms	
Mechanical Inspection		
30.	Drive End Bearing Brand	FAG
31.	Drive End Bearing Number-	NU317
32.	Drive End Bearing Qty.	1
33.	Drive End Bearing Type	(Roller) Roller Bearing
34.	Drive End Lubrication Type	(Grease) Grease Lubricated
35.	Drive End Bearing Insulation or Grounding Device?	
36.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	bearing cap
37.	Drive End Bearing Condition	loss of lubrication due to overload/misconnection
38.	Opposite Drive End Bearing Brand	
39.	Opposite Drive End Bearing Number-	6317
40.	Opposite Drive End Bearing Qty.	1
41.	Opposite Drive End Bearing Type	(Ball) Ball Bearing
42.	Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
43.	Opposite Drive End Bearing Insulation or Grounding Device?	
44.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	
45.	Opposite Drive End Bearing Condition	
46.	Drive End Seal	
47.	Opposite Drive End Seal	
Rotor Inspection		
48.	Rotor Type/Material	

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49. Growler Test		
50. Number of Rotor Bars		
51. Rotor Condition		
52. List the Parts needed for the Repair Below		
53. Signature of Technician that Disassembled Motor		
Mechanical Fits- Rotor		
54. Shaft Runout inches		
55. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
56. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
57. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
58. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
59. Drive End Bearing Shaft Fit Condition		
60. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
61. Opposite Drive End Bearing Shaft Fit Condition		
62. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings		
63. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
64. Drive End - Endbell Bearing Fit Condition		
65. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
66. Opposite Drive End - Endbell Bearing Fit Condition		
67. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
68. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
69. List Machine Work Needed Below		
70. Technician		
Root Cause of Failure		
71. Failure locations		
72. Root cause of failure		
Dynamic Balance Report		

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73. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



74. Initial Balance Readings

Drive End

Opposite Drive End

1.14**3.48**

75. Final Balance Readings

Drive End

Opposite Drive End

0.11**0.15**

76. Technician

TH
Rewind

77. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

78. Core Hot Spot Test

Pre-Burnout

Post-Burnout

79. Post Rewind Electrical Test- Insulation Resistance

Megohms

80. Post Rewind Polarization Index

Polarization Index

81. Post Rewind Winding Resistance

1-2

1-3

2-3

82. Post Rewind Surge Test

83. Post Rewind Hi-Pot

micro-amps

84. Technician

Assembly

85. QC Check All Parts for Cleanliness Prior to Assembly

RW

[Handwritten signature]

86. Photograph All Major Components prior to assembly

(Complete) Complete



87. Final Insulation Resistance Test

22,300 Megohms



88. Assembled Shaft Endplay

0 inches

89. Assembled Shaft Runout

0 inches

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90. Test Run Voltage		
Volts	Volts	Volts
457	456	458



Co sign TH

91. Test Run Amperage		
Amps	Amps	Amps
51.1	49.8	48.6



92. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.08	0.04	0.02
93. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.05	0.02	0.01
94. Ambient Temperature - Fahrenheit		
95. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
96. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
97. Document Final Condition with Pictures after paint		

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98. Final Pics and QC Review

RW

A large, stylized handwritten signature in black ink.

Co sign TH



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

AC Random Coil Rewind Report

FolderID: 104650
FormID: 24526725

Westrock Coffee

30 Collins Industrial Pl
North Little Rock, AR 72113

MOTOR SHOP LR

Priorities Found: ● 5 - Good

General	
1. Job Number	104650
2. Report Date	05/21/2025
3. Customer	Westrock Coffee
Stator Winding	
4. Core Length	14 "
5. Core ID	11.625 "
6. Back Iron Depth	1.625 "
7. Slot Depth	1.2 "
8. Tooth Width	0.375 "
9. Number of Vents	0
10. Vent Width	"
● 11. Before Burnout Core loss	(P) Pass
12. Flux Before Burnout	
13. Watts before burnout	Watts
14. Watts loss per lb. before burnout	1.23 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	1.161 W/lbs.
● 19. Core Iron Condition	
20. RTD's	
21. RTD's Reading	Ohm's
22. Motor Heaters	
23. Heater Qty.	
24. Heater Voltage	Volts
25. Heater Wattage	Watts
● 26. Thermistors	(Y) Yes
■ 142 ohms	
27. Number of Poles	4
28. Slots	48
29. Number of Coils	
30. Coil Weight	
31. Lead Markings	1-6
32. Grouping	12g of 2c

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33. Multiple Wires	
34. Wire Size	
	10 #1.25 metric 8 #1.4 metric
35. Turns per coil	6
36. Pitch 1 to:	
	1-10,12
37. Connection	
	1 wye delta
38. Lead Length	6 "
39. Lead Size	none
40. Number of Leads	6
41. Megger Reading After Rewind	9045 Mohms

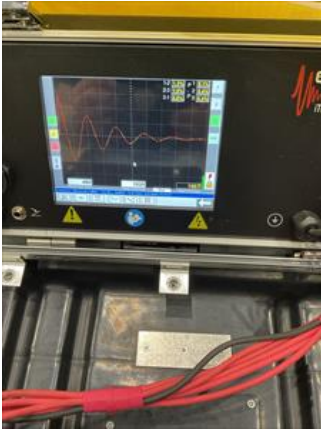


42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	0.06233 Ua



● 46. Surge Pattern After Rewind	(P) Pass
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47. Service Technician

3.5 conn and opp conn end



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2. **PRICE.** All quoted prices shall remain firm and binding for a period of thirty (30) days from the date of quotation or for the period specifically stated in the quotation. The price for any and all goods and/or services ordered or approved by Buyer after thirty (30) days from the date of any quotation are subject to any increase in price that may occur after the expiration of thirty (30) days from the issuance of the quotation and the date the Buyer releases any shipment.
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4. **BILLING AND PAYMENT TERMS.** Hi-Speed shall invoice Buyer for all goods and/or services as same are rendered at the address listed on the quotation. Payments for all goods and/or services shall be due thirty (30) days from the date of the current invoice or as otherwise set forth in the quotation. Late payments are subject to a late fee of 5% of the total invoice amount. Recurring late payments may lead to a deposit requirement on future services or sale of goods. Buyer shall be liable to Hi-Speed for any and all fees and expenses incurred by Hi-Speed to collect any invoices or to enforce these Standard Terms and Conditions, including but not limited to, attorney's fees.
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

replace any defective or non-conforming goods in accordance with the applicable manufacturer's warranty. Warranty for any defective or incorrect parts is limited to the repair or replacement of those parts. Hi-Speed warrants that all services will conform in all material respects to the description of services identified in the quotation and will be performed in a good and workmanlike manner in accordance with industry practices and standards. Should the services be reasonably rejected or not conform with the foregoing warranties, Hi-Speed shall, at its sole cost, re-perform the defective or nonconforming services. Notwithstanding the foregoing, these warranties do not extend to goods or services to the extent that such goods have been subject to misuse, neglect or abuse not caused by Hi-Speed or have been used in violation of the approved written instructions furnished to Buyer. THE FOREGOING REPRESENTS THE SOLE AND EXCLUSIVE WARRANTY GIVEN BY HI-SPEED WITH RESPECT TO ALL GOODS SOLD AND IS IN LIEU OF ALL OTHER WARRANTIES EITHER EXPRESS OR IMPLIED. HI-SPEED EXPRESSLY DISCLAIMS ALL OTHER WARRANTIES INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR USE OR PURPOSE. BUYER WAIVES ANY CLAIM THAT THESE EXCLUSIONS OR LIMITATIONS DEPRIVE IT OF AN ADEQUATE REMEDY AT EQUITY OR LAW OR CAUSE THIS AGREEMENT TO FAIL IN ITS ESSENTIAL PURPOSE. BUYER SHALL BE ENTITLED TO NO OTHER REMEDY OTHER THAN AS SET FORTH HEREIN, REGARDLESS OF THE CLAIM OR CAUSE OF ACTION, WHETHER BASED IN CONTRACT, TORT, NEGLIGENCE, GOODS LIABILITY, STRICT LIABILITY OR OTHERWISE.

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10. **SEVERABILITY.** The partial or complete invalidity of any provision of these Standard Terms and Conditions shall not affect the enforceability of the remainder of these Standard Terms and Conditions. If any provision is found to be invalid or unenforceable, that portion shall be modified to make it enforceable or shall be stricken and the remainder of these Standard Terms and Conditions shall enforced.
11. **GOVERNING LAW AND JURISDICTION.** Any controversy arising out of any quotation, the purchase order, the goods sold or delivered, repair or replacement thereof, or any services provided pursuant to any quotation or any purchase order, or these Standard Terms and Conditions shall be governed by the laws of the state of Tennessee without regard to any choice of law provisions and any cause of action related in any manner thereto shall be brought only in the state or federal courts of Shelby County, Tennessee.
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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.
14. **NONWAIVER.** No course of dealing or failure of either party to strictly enforce any term, right, or condition of these Standard Terms and Conditions will be construed as a waiver of such term, right or condition. Any waiver by Hi-Speed will only be in writing and will waive no succeeding breach of a term, right or condition.
15. **ASSIGNMENT.** The rights and obligations of the parties shall neither be assigned nor delegated without the prior written consent of the other party. However, any party may assign or delegate its respective rights and obligations, in whole or in part, (i) to any subsidiary, (ii) pursuant to other financing, merger or reorganization or (iii) pursuant to any sale or transfer of substantially all of the assets of the assigning party. These Standard Terms and Conditions shall bind the heirs, successors and assigns of the parties hereto.
16. **NO INDIVIDUAL LIABILITY.** Notwithstanding any other agreement to the contrary, the Buyer agrees that in no event will the Buyer hold and Hi-Speed owner, director, officer or employee personally liable for unintentional tortious conduct or conduct that constitutes the breach of any contract between Hi-Speed and the Buyer, even if the Hi-Speed owner, director, officer or employee is or could be construed to be a party to such contract.