



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

Motor Shop Repairs

Job Number 98582

Prepared for 3M-Main Plant (10001)

310 Walter Road
Little Rock AR 72216

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AC Recondition Repair Report

1.0

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AC Recondition Repair Report

FolderID: 98582
FormID: 11347365

3M-Main Plant (10001)
310 Walter Road
Little Rock, AR 72216

Priorities Found: ● 7 - High ● 8 - Good

General

| | |
|----------------|------------|
| 1. Job Number | 98582 |
| 2. Report Date | 10/12/2021 |
| 3. Customer | 3M |

Name Plate Information

| | |
|-----------------|------|
| 4. Manufacturer | G.E. |
|-----------------|------|



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1.2



| | |
|------------------|---------------|
| 5. Model | 5KGS509SN601P |
| 6. Serial Number | |
| 7. Horsepower | 100 |
| 8. KW | |
| 9. Volts | 460 |
| 10. Amps | 134 |
| 11. RPM | 595 |
| 12. Frame | 509 |
| 13. Enclosure | TEFC |
| 14. Cycles | 60 |

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| | |
|------------------------------------|-----------|
| 15. Phase | 3 |
| 16. Service Factor | 1.15 |
| 17. Motor Mount Position | |
| Initial Inspection | |
| 18. Number of Leads | 3 |
| 19. Lead Length | 18 Inches |
| 20. Lead Size | |
| 21. Lead Condition | (P) Pass |
| 22. Lead Markings | 1-3 |
| 23. Lug Size, Condition, and Type | |
| 24. Winding RTD's | |
| 25. Winding Rtd's Condition | |
| 26. Shaft Run Out | |
| 27. Does Shaft Turn Freely | No |
| 28. Does Shaft Have Visible Damage | |
| 29. Bearing Rtd's | |
| 30. Bearing Rtd's Condition | |
| 31. Contamination | |
| 32. Frame Condition | (P) Pass |
| 33. Fan Condition | (P) Pass |
| 34. Broken or missing components | |
| <i>Fan cover is broke</i> | |



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Initial Electric Test

- 35. Resistance to Ground
- 36. Winding Resistance 1-2
- 37. Winding Resistance 2-3
- 38. Winding Resistance 1-3
- 39. Resistive Imbalance
- 40. Hi-Pot

- 41. Surge Test (F) Fail
Windings blown in slot



- 42. Stator Condition

- 43. Failure Location in slot

Initial Rotor Inspection

- 44. Rotor Type cast aluminum



- 45. Air Gap <10% Variation

- 46. Number of Rotor Bars 105

- 47. Number of Broken Rotor Bars

- 48. Growler Test

- 49. Rotor Condition

Mechanical Inspection

- 50. Bearing Manufacture SKF

- 51. Bearing DE Size 320 NU

- 52. Bearing DE Type roller bearing

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| | |
|-------------------------|--------------|
| 53. DE Bearing Qty. | 1 |
| 54. Bearing ODE Size | 6315 |
| 55. Bearing ODE Type | ball bearing |
| 56. ODE Bearing Qty. | 1 |
| 57. Insulated Bearing | |
| 58. Lubrication Type | grease |
| ● 59. Grease Condition | (F) Fail |
| ● 60. Bearing Retainers | (Y) Yes |



| | |
|----------------------------|---------------------|
| 61. Shaft Grounding Device | |
| 62. DE Seal | (NA) Not Applicable |
| 63. DE Seal Type/Size | |
| 64. ODE Seal | (NA) Not Applicable |
| 65. ODE Seal Type/Size | |

Root Cause of Failure

| | |
|------------------------|--|
| 66. Component Failure | DE shaft fit, DE end bell, ODE end bell, windings |
| 67. Cause of Failure | <i>DE bearing fit on shaft went out causing play between shaft and bearing which caused the end bell fits to be over sized and causing rotor to drag iron causing windings to blow</i> |
| 68. Comments | <i>Recommend new shaft, bearings, machine work, and rewind</i> |
| 69. Service Technician | |

Machine Fit Inspection Report

| | |
|--|----------|
| 70. Shaft Run Out | |
| 71. Initial Shaft Run Out | |
| 72. Final Shaft Run Out | |
| ● 73. DE Bearing Shaft Fit | (F) Fail |
| 74. DE Initial Shaft Bearing Fit Size 1 | 3.9362 " |
| 75. DE Initial Shaft Bearing Fit Size 2 | 3.9358 " |
| 76. DE Initial Shaft Bearing Fit Size 3 | 3.9361 " |
| 77. DE Finial Shaft Bearing Fit Size 1 | |
| 78. DE Finial Shaft Bearing Fit Size 2 | |
| 79. DE Finial Shaft Bearing Fit Size 3 | |
| ● 80. ODE Bearing Shaft Fit | (F) Fail |
| 81. ODE Initial Shaft Bearing Fit Size 1 | |

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| | | |
|------------------|--------------------------------------|---------------------|
| 82. | ODE Initial Shaft Bearing Fit Size 2 | |
| 83. | ODE Initial Shaft Bearing Fit Size 3 | |
| 84. | ODE Finial Shaft Bearing Fit Size 1 | |
| 85. | ODE Finial Shaft Bearing Fit Size 2 | |
| 86. | ODE Finial Shaft Bearing Fit Size 3 | |
| 87. | DE Air Seal Shaft Fit | |
| 88. | DE Initial Air Seal Shaft Size | |
| 89. | DE Final Air Seal Shaft Size | |
| 90. | ODE Air Seal Shaft Fit | |
| 91. | ODE Initial Air Seal Shaft Size | |
| 92. | ODE Final Air Seal Shaft Size | " |
| ● 93. | DE Endbell Fit | (F) Fail |
| 94. | DE Initial Endbell Fit Size 1 | 8.4663 " |
| 95. | DE Initial Endbell Fit Size 2 | 8.465999999999999 " |
| 96. | DE Initial Endbell Fit Size 3 | 8.466200000000001 " |
| 97. | DE Final Endbell Fit Size 1 | |
| 98. | DE Finial Endbell Fit Size 2 | |
| 99. | DE Final Endbell Fit Size 3 | |
| 100. | DE Endbell Fit Insulated | |
| 101. | DE Endbell Air Seal Fit | |
| 102. | Initial Endbell Air Seal Fit Size | |
| 103. | Finial Endbell Air Seal Fit Size | |
| ● 104. | ODE Endbell Fit | (F) Fail |
| 105. | ODE Initial Endbell Fit Size 1 | 6.3007 " |
| 106. | ODE Initial Endbell Fit Size 2 | 6.3019 " |
| 107. | ODE Initial Endbell Fit Size 3 | 6.3013 " |
| 108. | ODE Final Endbell Fit Size 1 | |
| 109. | ODE Final Endbell Fit Size 2 | |
| 110. | ODE Final Endbell Fit Size 3 | |
| 111. | ODE Endbell Fit Insulated | |
| 112. | ODE Endbell Air Seal Fit | |
| 113. | ODE Initial Endbell Seal Fit Size | |
| 114. | ODE Finial Endbell Seal Fit Size | |
| ● 115. | Foot Flatness | (P) Pass |
| ● 116. | Foot Condition | (P) Pass |
| ● 117. | Flange Condition | (NA) Not Applicable |
| 118. | Service Technician | |
| Balancing Report | | |

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[illegible]

RL

| | |
|-------------------------------|------------------|
| 127. Meggar Testing Reading | |
| 128. Surge Test | |
| 129. Hi-Pot | |
| 130. Winding Resistance 1-2 | |
| 131. Winding Resistance 2-3 | |
| 132. Winding Resistance 1-3 | |
| 133. Test Run Voltage Phase A | 455 Volts |



| | |
|----------------------|---------|
| 134. Test Run Amps A | 66 Amps |
|----------------------|---------|

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135. Test Run Voltage Phase B

457 Volts



136. Test Run Amps B

69 Amps

137. Test Run Voltage Phase C

458 Volts



138. Test Run Amps C

70 Amps

139. DE Horizontal Vibration Reading

140. DE Vertical Vibration Reading

141. DE Axial Vibration Reading

142. ODE Horizontal Vibration Reading

143. ODE Vertical Vibration Reading

144. ODE Axial Vibration Reading

145. Ambient Temp at start of Test Run

146. Temp at 5 minutes

147. Temp at 10 minutes

148. Temp at 15 minutes

149. Temp at 20 minutes

150. Temp at 25 minutes

151. Temp at 30 minutes

152. Temp at 35 minutes

153. Temp at 40 minutes

154. Temp at 45 minutes

155. Temp at 50 minutes

156. Temp at 55 minutes

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157. Temp at 60 minutes

● 158. Motor Paint

(P) Pass



159. Service Technician

RW

Handwritten signature or initials, possibly "RL".



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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.
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

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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.
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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.