



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

LR Motor Shop Repairs

Job Number 99993

Prepared for Delta Plastics (11016)

8801 Frazier Pike
Little Rock AR 72206

Table of Contents



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

AC Recondition As Found

Delta Plastics (11016)

8801 Frazier Pike
Little Rock, AR 72206

FolderID: 99993
FormID: 13969698

AC Recondition - Rev. 2

Location: MOTOR SHOP LR
Serial Number: 3G1P163500601
Description: 400KW ABB 1800RPM 355M

Hi-Speed Job Number:	99993
Manufacturer:	ABB
Product Number:	M3BP 355 MLA 4 IMB3/IM1001
Serial Number:	3G1P163500601
HP/kW:	400 (kW)
RPM:	1790 (RPM)
Frame:	355
Voltage:	460
Current:	635
Phase:	Three
Hz:	60 (Hz)
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	06/30/2022
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 2 - High ● 3 - Good

Overall Condition

1. Report Date
2. Nameplate Picture



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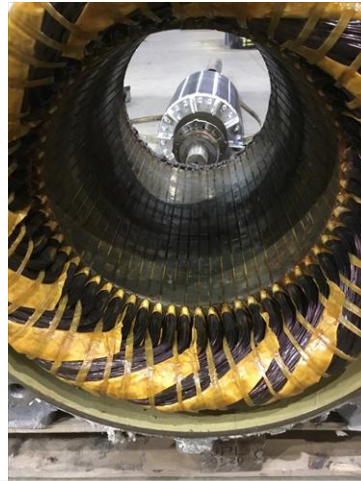
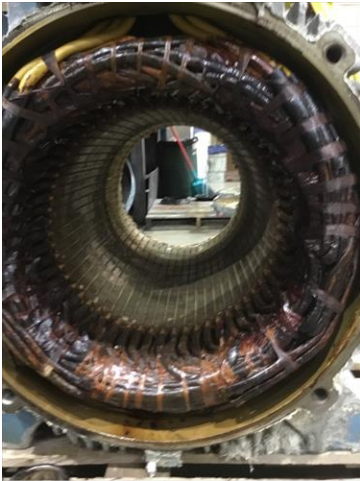


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3. Describe the Overall Condition of the Equipment as Received
4. Photos of all six sides of the machine.
5. Photos of all six sides of the machine.

Initial Mechanical/Electrical

6. Does Shaft Turn Freely?
7. Does Shaft Have Visible Damage?
8. Assembled Shaft Runout
9. Assembled Shaft End Play
10. Air Gap Variation <10%
11. Lead Condition
12. Lead Length
13. Stator Temperature Detector Rating and Function
14. Bearing Temperature Detector Rating and Function
15. Frame Condition
16. Fan Condition
17. Broken or Missing Components

Quantity

Rating

Quantity Passed

Quantity

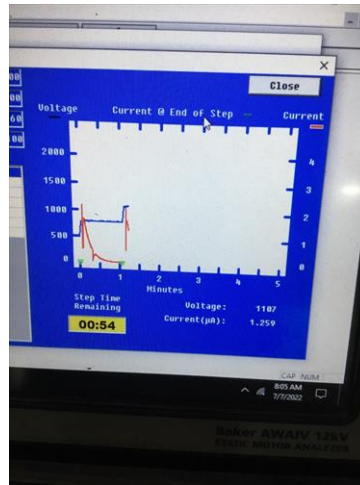
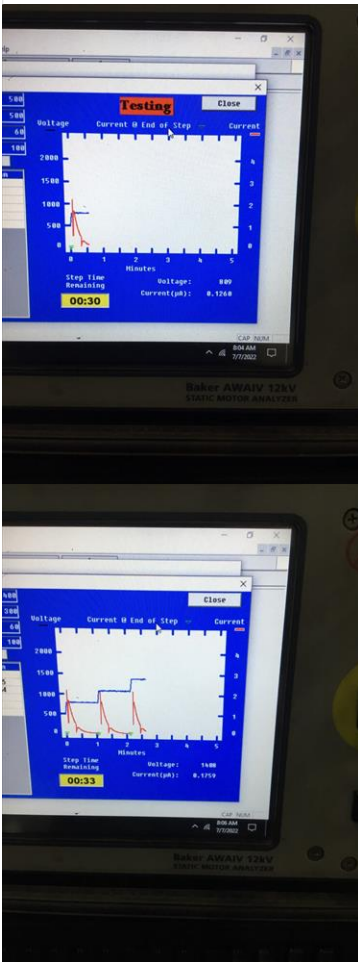
Rating

Quantity Passed

Initial Electrical Inspection

18. Insulation Resistance/Megger

Megohms



19. Winding Resistance

1-2

1-3

2-3

20. Perform Surge Test

(F) Fail

21. Stator Condition

rewind

Mechanical Inspection

22. Drive End Bearing Number-

NU 322EC




23. Drive End Bearing Qty.


1

24. Drive End Bearing Type


(Roller) Roller Bearing

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25. Drive End Lubrication Type	(Grease) Grease Lubricated
26. Drive End Bearing Insulation or Grounding Device?	
27. Drive End Wavy Washer/Snap-Ring Other Retention Device?	spacer behind bearing
28. Drive End Bearing Condition	bad
29. Opposite Drive End Bearing Number-	6316 Insucote
30. Opposite Drive End Bearing Qty.	1
31. Opposite Drive End Bearing Type	(Ball) Ball Bearing
32. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
33. Opposite Drive End Bearing Insulation or Grounding Device?	insulatedbearing
34. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	stainless washer and snap ring
35. Opposite Drive End Bearing Condition	bad
36. Drive End Seal	labyrinth (good)
37. Opposite Drive End Seal	labyrinth (good)
Rotor Inspection	
38. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
39. Growler Test	(Pass) Pass
40. Number of Rotor Bars	50
41. Rotor Condition	good
42. List the Parts needed for the Repair Below <i>Rewind, NU322, Insulated 6316, sleeve DE end bell</i>	
43. Signature of Technician that Disassembled Motor	David Maclin
	
Mechanical Fits- Rotor	
44. Shaft Runout	
45. Rotor Runout	
Drive End Bearing Fit	Rotor Body
Opposite Drive End Bearing	
46. Coupling Fit Closest to Bearing Housing	
0 Degrees	90 Degrees
120 Degrees	
47. Coupling Fit Closest to the end of the Shaft	
0 Degrees	60 Degrees
120 Degrees	
48. Drive End Bearing Shaft Fit	
0 Degrees	60 Degrees
120 Degrees	
4.3312	4.3312
4.3312	
49. Drive End Bearing Shaft Fit Condition	(P) Pass
50. Opposite Drive End Bearing Shaft Fit	
0 Degrees	60 Degrees
120 Degrees	
51. Opposite Drive End Bearing Shaft Fit Condition	(P) Pass

52.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings			
53.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	54.	Drive End - Endbell Bearing Fit Condition	
		(F) Fail	
55.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	6.695	6.695	6.695



56. Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass	
57. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
 Good		
58. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
59. List Machine Work Needed Below		
<i>Sleeve DE end bell</i>		
60. Technician	David Maclin	

Dynamic Balance Report

61. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
62. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	

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63. Initial Balance Readings		
Drive End	Opposite Drive End	
64. Initial Balance Readings		
Drive End	Opposite Drive End	
65. Final Balance Readings		
Drive End	Opposite Drive End	
66. Final Balance Readings		
Drive End	Opposite Drive End	
67. Technician		
68. Technician		
Rewind		
69. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	
70. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	
71. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	
72. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	
73. Post Rewind Electrical Test- Insulation Resistance		
74. Post Rewind Electrical Test- Insulation Resistance		
75. Post Rewind Polarization Index		
76. Post Rewind Polarization Index		
77. Post Rewind Winding Resistance		
1-2	1-3	2-3
78. Post Rewind Winding Resistance		
1-2	1-3	2-3
79. Post Rewind Surge Test		
80. Post Rewind Surge Test		
81. Post Rewind Hi-Pot		
82. Post Rewind Hi-Pot		
83. Technician		
84. Technician		
Root Cause of Failure		
85. Failure locations		
<i>Bearings</i>		
86. Root cause of failure		
<i>Improper lubrication</i>		
Mechanical Fits- Rotor - Post Repair		

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87. Shaft Runout Post Repair		
88. Shaft Runout Post Repair		
89. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
90. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
91. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
92. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
93. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
94. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
95. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
<div>  <i>Cut snap ring groove in front of D.E. Bearing fit.</i> </div>		



96. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
97. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
98. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
99. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	

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100. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
101. Shaft Repair Sign-off		
102. Shaft Repair Sign-off		Gary Moore
Mechanical Fits- Bearing Housings - Post Repair		
103. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
104. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
9.449199999999999	9.449199999999999	9.4491

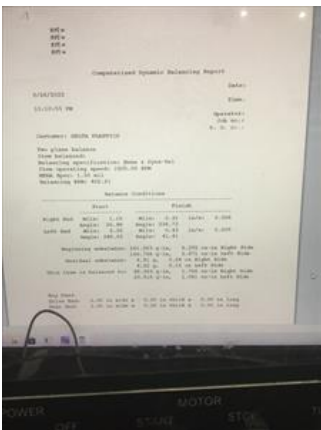


105. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
106. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
6.6935	6.6935	6.6936

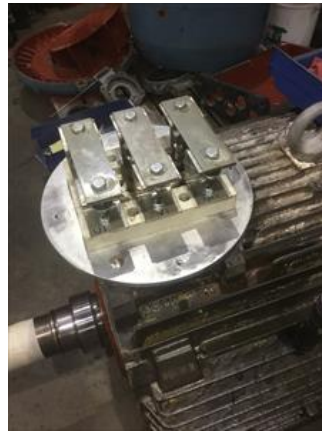


107. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	

108. Bearing Cap Condition Post Repair	
Drive End Bearing Cap	Opposite Drive End Bearing Cap
109. End Bell Air Seal Fits Post Repair	
Drive End Air Seal	Opposite Drive End Air Seal
110. End Bell Air Seal Fits Post Repair	
Drive End Air Seal	Opposite Drive End Air Seal
111. End Bell Repair Sign-off	
112. End Bell Repair Sign-off	
Assembly	
113. Photograph All Major Components prior to assembly	
114. Photograph All Major Components prior to assembly	(Complete) Complete



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115. Final Insulation Resistance Test

21,470 Megohms



116. Final Insulation Resistance Test

117. Assembled Shaft Endplay

118. Assembled Shaft Endplay

119. Assembled Shaft Runout

120. Assembled Shaft Runout

121. Test Run Voltage

Volts

Volts

Volts

457

455

459

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122. Test Run Voltage		
Volts	Volts	Volts
123. Test Run Amperage		
Amps	Amps	Amps
124. Test Run Amperage		
Amps	Amps	Amps
207	195	200



125. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
126. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
127. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
128. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
129. Ambient Temperature - Fahrenheit		
130. Ambient Temperature - Fahrenheit		

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131. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
132. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
133. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
134. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
135. Final Test Run Sign-off		
136. Final Test Run Sign-off		
137. Document Final Condition with Pictures after paint		



138. Document Final Condition with Pictures after paint	
139. Final Pics and QC Review	
140. Final Pics and QC Review	RW

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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.
3. **SCOPE OF GOODS AND/OR SERVICES.** The goods and/or services provided by Hi-Speed pursuant to any quotation shall be limited exclusively to those goods and/or services expressly identified therein. Hi-Speed does not assume any responsibility and/or liability for the failure to provide any other goods and/or services not identified in any quotation. Modifications, additions or deletions to or from the scope referenced in any quotation shall only be effective if evidenced in writing and signed by Hi-Speed. The sale of any of all goods and/or services affected by such modification, addition or deletion shall be subject to these same Standard Terms and Conditions whether or not referenced therein.
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.
12. **ABANDONED EQUIPMENT.** Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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.
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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.