



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

LR Motor Shop Repairs

Job Number 100730

Prepared for Georges Inc

1810 S. St. Louis Street
Batesville AR 72501

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AC Random Coil Rewind Report		2.0



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

AC Recondition As Found


Georges Inc
1810 S. St. Louis Street
Batesville, AR 72501

FolderID: 100730
FormID: 15620716

AC Recondition - Rev. 2

Location: Shop
Serial Number: 60102199A2
Description: 250HP GENERAL DYNAMICS
3600RPM 504

Hi-Speed Job Number:	100730
Manufacturer:	Other
Serial Number:	60102199A2
HP/kW:	250 (HP)
RPM:	3560 (RPM)
Frame:	504
Voltage:	460
Current:	283
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	ODP
J-box Included:	None
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found:  6 - High

Overall Condition

1. Report Date
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		
Initial Mechanical/Electrical		
<input checked="" type="radio"/> 5. Does Shaft Turn Freely?	(No) No	
6. Does Shaft Have Visible Damage?	(No) No	
7. Assembled Shaft Runout		
8. Assembled Shaft End Play		
9. Air Gap Variation <10%		

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10. Lead Condition

(F) Fail



11.	Lead Length	24 Inches	
12.	Frame Condition	dirty	
13.	Fan Condition	(N) NA	
14.	Broken or Missing Components		
Initial Electrical Inspection			
15.	Insulation Resistance/Megger		
16.	Winding Resistance		
	1-2	1-3	2-3
17.	Perform Surge Test		
18.	Number of Stator Slots	Megohms	
19.	Stator Condition	dirty	
	Rewind		



Mechanical Inspection

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20. Drive End Bearing Number-

6313 MC/P52



21. Drive End Bearing Qty.	1
22. Drive End Bearing Type	(Ball) Ball Bearing
23. Drive End Lubrication Type	(Grease) Grease Lubricated
24. Drive End Bearing Insulation or Grounding Device?	no
25. Drive End Wavy Washer/Snap-Ring Other Retention Device?	yes



26. Drive End Bearing Condition

27. Opposite Drive End Bearing Number-

6313 MC/P52



28. Opposite Drive End Bearing Qty.	1
29. Opposite Drive End Bearing Type	(Ball) Ball Bearing

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30. Opposite Drive End Lubrication Type

(Grease) Grease Lubricated



31. Opposite Drive End Bearing Insulation or Grounding Device?

no

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

Wavy washer



33. Opposite Drive End Bearing Condition

34. Drive End Seal

35. Opposite Drive End Seal

Rotor Inspection

36. Rotor Type/Material

(Squirrel Aluminum) Squirrel
Cage Aluminum Die Cast



37. Growler Test

(Pass) Pass

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38. Number of Rotor Bars	29
39. Rotor Condition	pass



40. List the Parts needed for the Repair Below	
41. Signature of Technician that Disassembled Motor	RW

RW

Mechanical Fits- Rotor

42. Shaft Runout		
43. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
44. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
45. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
46. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.5589	2.5589	2.5589
47. Drive End Bearing Shaft Fit Condition		(F) Fail
48. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
2.559	2.5589	2.5593
49. Opposite Drive End Bearing Shaft Fit Condition		(F) Fail
50. Shaft Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	

Mechanical Fits- Bearing Housings

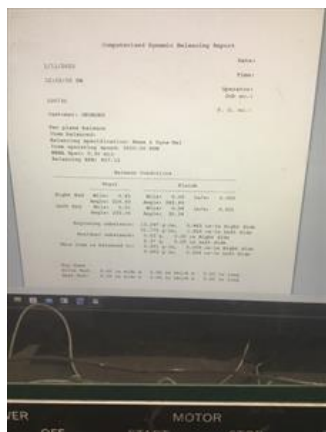
51. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.5148	5.5129	5.5134
52. Drive End - Endbell Bearing Fit Condition		(F) Fail

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53. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.5129	5.5138	5.5142
54. Opposite Drive End - Endbell Bearing Fit Condition		(F) Fail
55. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
needs repaired	pass	



56. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
57. List Machine Work Needed Below		
<i>DE AND ODE SHAFT BEARING FITS BAD DE AND ODE END BELL HOUSING FIT BAD DE bearing cap needs repaired</i>		
58. Technician		
Dynamic Balance Report		
59. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	



60. Initial Balance Readings		
Drive End	Opposite Drive End	
61. Final Balance Readings		
Drive End	Opposite Drive End	

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62. Technician		
Rewind		
63. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	
64. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	
65. Post Rewind Electrical Test- Insulation Resistance		
66. Post Rewind Polarization Index		
67. Post Rewind Winding Resistance		
1-2	1-3	2-3
68. Post Rewind Surge Test		
69. Post Rewind Hi-Pot		
70. Technician		
Root Cause of Failure		
71. Failure locations		

72. Root cause of failure

Needs rewind because of the previous splicing done from Another vendor. The Leads are corroded and the damage is all the way back into the connections of the windings.



Mechanical Fits- Rotor - Post Repair

73. Shaft Runout Post Repair

74. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

75. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
76. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
77. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
2.5597	2.5597	2.5596



78. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
2.5596	2.5596	2.5595



79. Shaft Air Seal Fits Post Repair		
Drive End Air Seal		Opposite Drive End Air Seal
80. Shaft Repair Sign-off		
Mechanical Fits- Bearing Housings - Post Repair		

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81. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
5.5123	5.5123	5.5123



82. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
5.5123	5.5122	5.5122



83. Bearing Cap Condition Post Repair		
Drive End Bearing Cap		Opposite Drive End Bearing Cap
84. End Bell Air Seal Fits Post Repair		
Drive End Air Seal		Opposite Drive End Air Seal
85. End Bell Repair Sign-off		
Assembly		
86. Photograph All Major Components prior to assembly		
87. Final Insulation Resistance Test		
88. Assembled Shaft Endplay		
89. Assembled Shaft Runout		
90. Test Run Voltage		
Volts	Volts	Volts

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91. Test Run Amperage		
Amps	Amps	Amps
92. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
93. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
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. Final Test Run Sign-off		
98. Document Final Condition with Pictures after paint		



99. Final Pics and QC Review



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

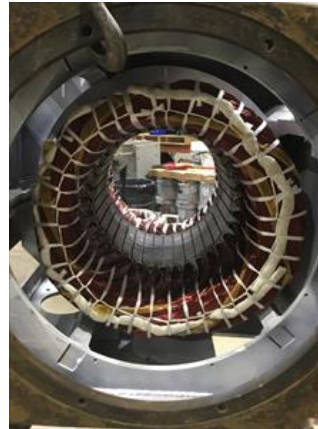
AC Random Coil Rewind Report

FolderID: 100730
FormID: 15651184

Georges Inc
1810 S. St. Louis Street
Batesville, AR 72501

Priorities Found:

General	
1. Job Number	100730
2. Report Date	01/06/2023
3. Customer	George's
Stator Winding	
4. Core Length	8.125 "



5. Core ID	11.812 "
6. Back Iron Depth	2.812 "
7. Slot Depth	2 "
8. Tooth Width	0.5 "
9. Number of Vents	
10. Vent Width	
11. Before Burnout Core loss	
12. Flux Before Burnout	
13. Watts before burnout	
14. Watts loss per lb. before burnout	
15. After Burnout Core Loss	
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	
19. Core Iron Condition	
20. RTD's	
21. RTD's Reading	
22. Motor Heaters	

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23. Heater Qty.	
24. Heater Voltage	
25. Heater Wattage	
26. Thermistors	
27. Number of Poles	2
28. Slots	36
29. Number of Coils	36
30. Coil Weight	
31. Lead Markings	
32. Grouping	
33. Multiple Wires	
34. Wire Size	
35. Turns per coil	
36. Pitch 1 to:	13
37. Connection <i>2Y, 2Delta</i>	
38. Lead Length	"
39. Lead Size	
40. Number of Leads	6
41. Megger Reading After Rewind	
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	
46. Surge Pattern After Rewind	
47. Service Technician	



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.
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.
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.
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.