



KEEPING YOUR FACILITY UP TO SPEED
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LR Motor Shop Repairs

Job Number 100715

Prepared for Georges Inc

1810 S. St. Louis Street
Batesville AR 72501

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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: 100715
FormID: 15551920

AC Recondition - Rev. 2

Location: Shop
Serial Number: BP190465
Description: NASH XL250/7 VACUUM PUMP
1080RPM

Hi-Speed Job Number:	100715
Manufacturer:	Other
Product Number:	XL250/7
Serial Number:	BP190465
RPM:	1080 (RPM)
Voltage:	460
Phase:	Three
Hz:	60 (Hz)
Enclosure:	TEFC
J-box Included:	Complete
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 1 - High ● 2 - Good

Overall Condition

1. Report Date



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2. Nameplate Picture



3. Photos of all six sides of the machine.

4. Describe the Overall Condition of the Equipment as Received

Dirty, locked up

5. Distance from the end of the shaft to the Coupling/Sheave inches

Initial Mechanical/Electrical

6. Does Shaft Turn Freely? (No) No

7. Does Shaft Have Visible Damage? (No) No

8. Assembled Shaft Runout

9. Assembled Shaft End Play

10. Air Gap Variation <10%

11. Lead Condition (NA) Not Applicable

12. Lead Length Inches

13. Frame Condition ok

14. Fan Condition (N) NA

15. Broken or Missing Components none

Initial Electrical Inspection

16. Insulation Resistance/Megger Megohms

17. Winding Resistance

1-2

1-3

2-3

18. Perform Surge Test (NA) Not Applicable


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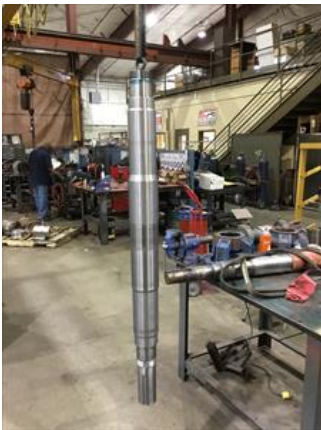
19. Number of Stator Slots
20. Stator Condition
Mechanical Inspection
21. Drive End Bearing Number-
22. Drive End Bearing Qty.
23. Drive End Bearing Type
24. Drive End Lubrication Type
25. Drive End Bearing Insulation or Grounding Device?
26. Drive End Wavy Washer/Snap-Ring Other Retention Device?
27. Drive End Bearing Condition
28. Opposite Drive End Bearing Number-
29. Opposite Drive End Bearing Qty.
30. Opposite Drive End Bearing Type
31. Opposite Drive End Lubrication Type
32. Opposite Drive End Bearing Insulation or Grounding Device?
33. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?
34. Opposite Drive End Bearing Condition
35. Drive End Seal
36. Opposite Drive End Seal
Rotor Inspection
37. Rotor Type/Material
38. Growler Test
39. Number of Rotor Bars
40. Rotor Condition
41. List the Parts needed for the Repair Below
42. Signature of Technician that Disassembled Motor
Mechanical Fits- Rotor
43. Shaft Runout
44. Rotor Runout
Drive End Bearing Fit Rotor Body Opposite Drive End Bearing
45. Coupling Fit Closest to Bearing Housing
0 Degrees 90 Degrees 120 Degrees
46. Coupling Fit Closest to the end of the Shaft
0 Degrees 60 Degrees 120 Degrees
47. Drive End Bearing Shaft Fit
0 Degrees 60 Degrees 120 Degrees
48. Drive End Bearing Shaft Fit Condition
49. Opposite Drive End Bearing Shaft Fit
0 Degrees 60 Degrees 120 Degrees
50. Opposite Drive End Bearing Shaft Fit Condition
51. Shaft Air Seal Fits
Drive End Air Seal Opposite Drive End Air Seal

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Mechanical Fits- Bearing Housings		
52. Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
53. Drive End - Endbell Bearing Fit Condition		
54. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
55. Opposite Drive End - Endbell Bearing Fit Condition		
56. Bearing Cap Condition		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
57. End Bell Air Seal Fits		
Drive End Air Seal	Opposite Drive End Air Seal	
58. List Machine Work Needed Below		
59. Technician		
Dynamic Balance Report		
60. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
61. Initial Balance Readings		
Drive End	Opposite Drive End	
62. Final Balance Readings		
Drive End	Opposite Drive End	
63. Technician		
Rewind		
64. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	
65. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	
66. Post Rewind Electrical Test- Insulation Resistance		
67. Post Rewind Polarization Index		
68. Post Rewind Winding Resistance		
1-2	1-3	2-3
69. Post Rewind Surge Test		
70. Post Rewind Hi-Pot		
71. Technician		
Root Cause of Failure		
72. Failure locations		
73. Root cause of failure		
Mechanical Fits- Rotor - Post Repair		
74. Shaft Runout Post Repair		

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75. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
76. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
77. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
78. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
79. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
80. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
81. Shaft Repair Sign-off		
 Gary M.		



Mechanical Fits- Bearing Housings - Post Repair

82. Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
5.3767	5.3766	5.3766	



83. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
84. Bearing Cap Condition Post Repair			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
85. End Bell Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
86. End Bell Repair Sign-off			
Assembly			
87. Photograph All Major Components prior to assembly			
88. Final Insulation Resistance Test			
89. Assembled Shaft Endplay			
90. Assembled Shaft Runout			
91. Test Run Voltage			
Volts	Volts	Volts	
92. Test Run Amperage			
Amps	Amps	Amps	
93. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
94. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
95. Ambient Temperature - Fahrenheit			
96. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	

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97. Opposite Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	
98. Final Test Run Sign-off			
99. Document Final Condition with Pictures after paint			
100. Final Pics and QC Review			



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

Split Case Centrifugal Pump Report

FolderID: 100715
FormID: 15604309

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

Priorities Found: ● 4 - High ● 14 - Good

General

1. Job Number	100715
2. Report Date	01/04/2023
3. Customer	George's

Initial Inspection

4. Bowl Condition	(N) NA
● 5. Impeller Condition	(P) Pass
6. Wear Ring Condition	(N) NA
7. Wear Ring Material	
● 8. Seal Surfaces Condition	(P) Pass
9. Number of Seals	8

See breakdown

10. Seal Type	Packing
---------------	---------

11.	Seal Material on Rotary Face
12.	Seal Material on Stationary Seat
13.	Mechanical Seal ID/Shaft Diameter
14.	Mechanical Seal OD
15.	Mechanical Seal Length
16.	Lip Seal Elastic Material
17.	Lip Seal ID/Shaft Diameter
18.	Lip Seal OD/Bore Diameter
19.	Lip Seal Height
20.	Seal Sleeve Material
21.	Seal Plate Condition
22.	Seal Cavity
23.	Shaft Run Out
24.	Does Shaft Turn Freely
25.	Does Shaft Have Visible Damage
26.	Contamination
No	

● 27. Frame Condition	(P) Pass
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● 28. Fan Condition	(NA) Not Applicable
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29. Broken or missing components	One check ball missing. See breakdown
----------------------------------	---------------------------------------


Mechanical Inspection

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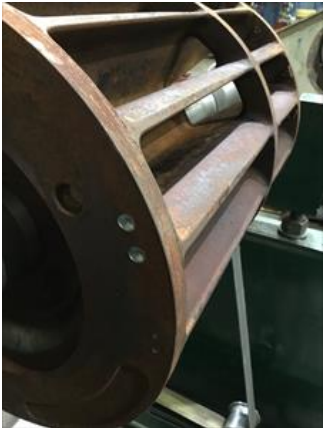
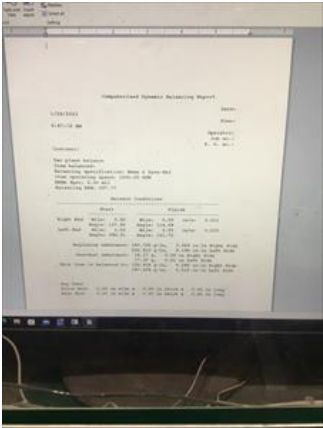
31. Bearing DE Size	497
32. Bearing DE Type	tapered roller
33. DE Bearing Qty.	2
34. Bearing ODE Size	497
35. Bearing ODE Type	tapered roller
36. ODE Bearing Qty.	2
37. Insulated Bearing	
38. Lubrication Type	grease
39. Grease Condition	(F) Fail
Incompatible grease added	
40. Bearing Retainers	(Y) Yes
AN 17 with locking rings (*2)	
41. Shaft Grounding Device	
42. DE Seal	(Y) Yes
43. DE Seal Type/Size	
See breakdown	
44. ODE Seal	(Y) Yes
45. ODE Seal Type/Size	
See breakdown	
46. Wear Ring Size	in
47. Clearances on Wear Ring to Impeller	

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48.	Number of Wear Rings		
49.	Wear Ring Material		
Root Cause of Failure			
50.	Component Failure		DE bearings
51.	Cause of Failure <i>Improper maintenance with incorrect grease added to bearing.</i>		
52.	Comments <i>Replace shaft, sleeve DE endbell, replace parts highlighted in parts breakdown.</i>		
53.	Service Technician		David Maclin
			
Machine Fit Inspection Report			
54.	Shaft Run Out		
55.	Shaft Run Out Measurements		
	Initial	Final	
56.	DE Bearing Shaft Fit		(F) Fail
57.	DE Initial Shaft Bearing Fit Size		
	Measure 1	Measure 2	Measure 3
58.	DE Final Shaft Bearing Fit Size		
	Measure 1	Measure 2	Measure 3
59.	ODE Bearing Shaft Fit		(F) Fail
60.	ODE Initial Shaft Bearing Fit Size		
	Measure 1	Measure 2	Measure 3
61.	ODE Final Shaft Bearing Fit Size		
	Measure 1	Measure 2	Measure 3
62.	DE Air Seal Shaft Fit		
63.	DE Air Seal Shaft Size		
	Initial	Final	
64.	ODE Air Seal Shaft Fit		
65.	ODE Air Seal Shaft Size		
	Initial	Final	
66.	DE Endbell Fit		(F) Fail
67.	DE Initial Endbell Fit Size		
	Measure 1	Measure 2	Measure 3
68.	DE Final Endbell Fit Size		
	Measure 1	Measure 2	Measure 3
69.	DE Endbell Fit Insulated		

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70.	DE Endbell Air Seal Fit		
71.	DE Endbell Air Seal Fit Size		
	Initial	Final	
72.	ODE Endbell Fit		(P) Pass
73.	ODE Initial Endbell Fit Size		
	Measure 1	Measure 2	Measure 3
74.	ODE Final Endbell Fit Size		
	Measure 1	Measure 2	Measure 3
75.	ODE Endbell Fit Insulated		
76.	ODE Endbell Air Seal Fit		
77.	ODE Endbell Seal Fit Size		
	Initial	Final	
78.	Foot Flatness		(P) Pass
79.	Foot Condition		(P) Pass
80.	Flange Condition		(P) Pass
81.	Service Technician		David Maclin
			
Balancing Report			
82.	Balance Type		dynamic
83.	Balance Operating Speed		297.77 RPM
84.	Starting Measurements		
	Left End	Right End	
	0.92	1.5	
85.	Balancing Specification		2.0
86.	Finished Measurements		
	Left End	Right End	
	0.95	0.6899999999999999	

Assembly and Final Test

88. Impeller Balanced

(Y) Yes





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89. Seal Cavity Test Pressure	
90. Pressure Test Time	
91. Painted	(Y) Yes
92. Final Assembly Completed	(Y) Yes



93. Service Technician	David Maclin
	

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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.
7. **INSPECTION/ACCEPTANCE.** All goods and services ordered pursuant to any quotation shall be subject to inspection by Buyer after delivery or performance to determine conformity with the quotation and/or purchase order and Hi-Speed's advertised or published specifications. Buyer shall have a period of thirty (30) days from shipment of goods at the delivery destination specified in the quotation within which to inspect the goods for conformity with the quotation, order and/or Hi-Speed's advertised and published specifications and to provide Hi-Speed with written notice of any discrepancy or rejection. Buyer shall have a period of thirty (30) days following completion of any services within which to inspect the services for conformity with the quotation, purchase order and/or Hi-Speed's advertised and published specifications and to provide Hi-Speed with written notice of any discrepancy or rejection. If the goods delivered or services performed do not so conform, upon delivery of notice to Hi-Speed of any discrepancy, nonconformance or rejection, Hi-Speed shall have sixty (60) days to cure the alleged discrepancy and/or nonconformance. If Hi-Speed fails to cure in this time period, Buyer shall have the right to reject such goods or services. After the cure period, goods that have been delivered and rejected, in whole or in part, shall be returned to Hi-Speed. Buyer shall notify Hi-Speed and arrange for the return of the goods as required. Should such non-conforming services be rejected Hi-Speed shall, at its sole cost, re-perform the non-conforming services. Inspection or failure to inspect on any occasion shall not affect Buyer's rights under the warranty provisions herein.
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.