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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 100522**

Prepared for Hiland Dairy (10126)

6901 I-30  
Little Rock AR 72209

# Table of Contents



Hi-Speed Industrial Service  
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Millington, Tn 38053  
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## AC Recondition As Found

Hiland Dairy (10126)

6901 I-30  
Little Rock, AR 72209

FolderID: 100522  
FormID: 14994608

### AC Recondition - Rev. 2

Location: MOTOR SHOP LR

Serial Number: 1059353603

Description: 150HP WEG 1800RPM 444/5TSC

Hi-Speed Job Number:	100522
Manufacturer:	WEG
Product Number:	150180T3G444TSC-W40
Serial Number:	1059353603
HP/kW:	150 (HP)
RPM:	1784 (RPM)
Frame:	444/5TSC
Voltage:	460
Current:	170
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.25
Enclosure:	ODP
J-box Included:	Complete
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 1 - High ● 7 - Good

### 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

*Serviceable*

### Initial Mechanical/Electrical

● 5. Does Shaft Turn Freely?	(Yes) Yes
6. Does Shaft Have Visible Damage?	(No) No
● 7. Assembled Shaft Runout	0.001 Inches
8. Assembled Shaft End Play	
9. Air Gap Variation <10%	
● 10. Lead Condition	(P) Pass



11. Lead Length	12 Inches
12. Frame Condition	pass
13. Fan Condition	(N) NA
14. Broken or Missing Components	

### Initial Electrical Inspection

15. Insulation Resistance/Megger

16. Winding Resistance

1-2

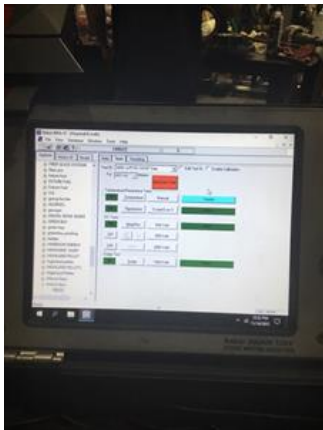
1-3

2-3

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17. Perform Surge Test

(P) Pass



18. Stator Condition

pass

19. Number of Stator Slots

**Mechanical Inspection**

20. Drive End Bearing Number-

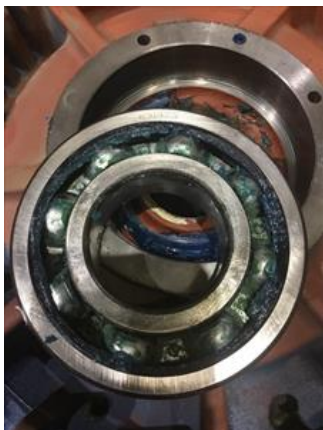
6314 C3

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?

none

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

none

26. Drive End Bearing Condition

replace

27. Opposite Drive End Bearing Number-

6212 C3

28. Opposite Drive End Bearing Qty.

1

29. Opposite Drive End Bearing Type

(Ball) Ball Bearing



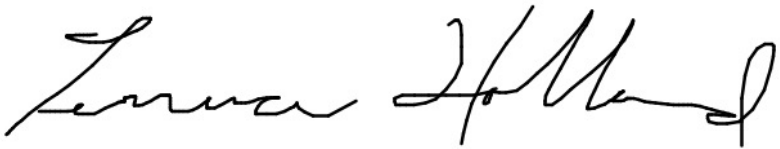


30. Opposite Drive End Lubrication Type	<b>(Grease) Grease Lubricated</b>
31. Opposite Drive End Bearing Insulation or Grounding Device?	<b>none</b>
32. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	<b>none</b>
33. Opposite Drive End Bearing Condition	<b>replace</b>
34. Drive End Seal	
35. Opposite Drive End Seal	
<b>Rotor Inspection</b>	
36. Rotor Type/Material	<b>(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast</b>



37. Growler Test	<b>(Pass) Pass</b>
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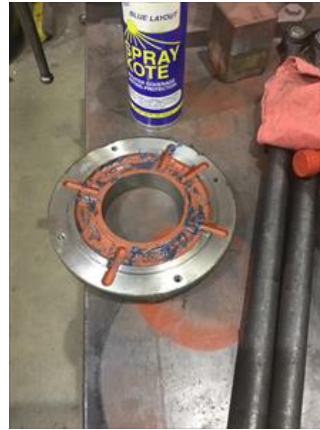
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38.	Number of Rotor Bars		
39.	Rotor Condition <b>pass</b>		
40.	List the Parts needed for the Repair Below		
41.	Signature of Technician that Disassembled Motor <b>Terrence. Holland</b>		
			
<b>Mechanical Fits- Rotor</b>			
42.	Shaft Runout <b>0.001 inches</b>		
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
	<b>2.7562</b>	<b>2.7563</b>	<b>2.7563</b>
● 47.	Drive End Bearing Shaft Fit Condition <b>(P) Pass</b>		
48.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	<b>2.3627</b>	<b>2.3628</b>	<b>2.3628</b>
● 49.	Opposite Drive End Bearing Shaft Fit Condition <b>(P) Pass</b>		
50.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
<b>Mechanical Fits- Bearing Housings</b>			
51.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	<b>5.906</b>	<b>5.9062</b>	<b>5.9062</b>
● 52.	Drive End - Endbell Bearing Fit Condition <b>(P) Pass</b>		
53.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
	<b>4.3313</b>	<b>4.3312</b>	<b>4.3313</b>
● 54.	Opposite Drive End - Endbell Bearing Fit Condition <b>(P) Pass</b>		

## 55. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap



## 56. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

## 57. List Machine Work Needed Below

None

## 58. Technician

Terrence Holland

**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

## 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		
<b>Root Cause of Failure</b>		
71. Failure locations		
72. Root cause of failure		
<i>Recondition</i>		
<b>Mechanical Fits- Rotor - Post Repair</b>		
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
78. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
79. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
80. Shaft Repair Sign-off		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
81. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
82. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
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		
<b>Assembly</b>		
86. Photograph All Major Components prior to assembly		
87. Final Insulation Resistance Test		
88. Assembled Shaft Endplay		

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89. Assembled Shaft Runout			
90. Test Run Voltage			
Volts	Volts	Volts	
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			



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99. Final Pics and QC Review



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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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