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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

Job Number 100400

Prepared for Hormel (11974)

8201 Fraizer 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

Hormel (11974)
8201 Fraizer Pike
Little Rock, AR 72206

FolderID: 100400
FormID: 14741723

AC Recondition - Rev. 2

Location: MOTOR SHOP LR

Serial Number: 8007

Description: 75HP WESTINGHOUSE 1800RPM
444U

Hi-Speed Job Number: 100400

Manufacturer: TECO Westinghouse

Product Number: 773B732G30

Serial Number: 8007

HP/kW: 75 (HP)

RPM: 1780 (RPM)

Frame: 444U

Voltage: 230 / 460

Current: 172/86

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: TEFC

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: ● 2 - High ● 6 - 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

Covered in peanut oil

Initial Mechanical/Electrical

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

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11. Lead Length

15 Inches

12. Frame Condition



13. Fan Condition

(P) Pass



14. Broken or Missing Components

missing bearing cap on
opposite drive end

Initial Electrical Inspection

15. Insulation Resistance/Megger

Megohms

16. Winding Resistance

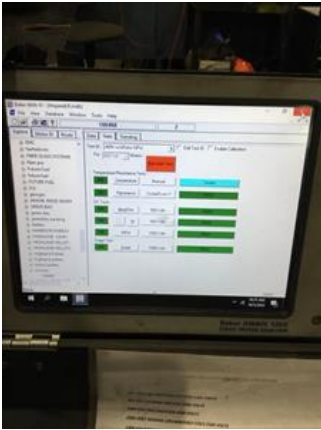
1-2

1-3

2-3

17. Perform Surge Test

(P) Pass



18. Stator Condition

recondition

Mechanical Inspection

19. Drive End Bearing Number-

6319 c3



20. Drive End Bearing Qty.

1

21. Drive End Bearing Type

(Ball) Ball Bearing

22. Drive End Lubrication Type

(Grease) Grease Lubricated

23. Drive End Bearing Insulation or Grounding Device?

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

no

25. Drive End Bearing Condition

worn



27. Opposite Drive End Bearing Qty.	1
28. Opposite Drive End Bearing Type	(Ball) Ball Bearing
29. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
30. Opposite Drive End Bearing Insulation or Grounding Device?	
31. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	no
32. Opposite Drive End Bearing Condition	worn
33. Drive End Seal	
34. Opposite Drive End Seal	

Rotor Inspection



35. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
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36. Growler Test
37. Number of Rotor Bars
38. Rotor Condition
39. List the Parts needed for the Repair Below
40. Signature of Technician that Disassembled Motor

Mechanical Fits- Rotor

41. Shaft Runout	0.001 inches	
42. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing


43.	Coupling Fit Closest to Bearing Housing		
	0 Degrees	90 Degrees	120 Degrees
	2.8735	2.8735	2.8735
44.	Coupling Fit Closest to the end of the Shaft		
	0 Degrees	60 Degrees	120 Degrees
	2.8735	2.8735	2.8735
45.	Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	3.7404	3.7405	3.7406
	46.	Drive End Bearing Shaft Fit Condition	(P) Pass
	47.	Opposite Drive End Bearing Shaft Fit	
		0 Degrees	60 Degrees 120 Degrees
		2.5595	2.5595 2.5594
	48.	Opposite Drive End Bearing Shaft Fit Condition	(P) Pass
	49.	Shaft Air Seal Fits	
		Drive End Air Seal	Opposite Drive End Air Seal
Mechanical Fits- Bearing Housings			
	50.	Drive End - Endbell Bearing Fit	
		0 Degrees	60 Degrees 120 Degrees
		7.876	7.8761 7.8759



51. Drive End - Endbell Bearing Fit Condition	(F) Fail
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52. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
5.5133	5.5134	5.5134



53.	Opposite Drive End - Endbell Bearing Fit Condition	(F) Fail
54.	Bearing Cap Condition	
	Drive End Bearing Cap	Opposite Drive End Bearing Cap missing
55.	End Bell Air Seal Fits	
	Drive End Air Seal	Opposite Drive End Air Seal
56.	List Machine Work Needed Below	
	<i>Sleeve both endbells</i>	
57.	Technician	Trevor Hall
		

Dynamic Balance Report

58. Rotor Weight and Balance Grade		
Rotor Weight	Balance Grade	
59. Initial Balance Readings		
Drive End	Opposite Drive End	
60. Final Balance Readings		
Drive End	Opposite Drive End	
61. Technician		

Rewind

62. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	
63. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	

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64.	Post Rewind Electrical Test- Insulation Resistance		
65.	Post Rewind Polarization Index		
66.	Post Rewind Winding Resistance		
1-2	1-3	2-3	
67.	Post Rewind Surge Test		
68.	Post Rewind Hi-Pot		
69.	Technician		
Root Cause of Failure			
70.	Failure locations <i>Endbells and bearings</i>		
71.	Root cause of failure <i>Normal wear</i>		
Mechanical Fits- Rotor - Post Repair			
72.	Shaft Runout Post Repair		
73.	Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
74.	Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees	
75.	Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees	
76.	Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees	
77.	Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees	
78.	Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal		
79.	Shaft Repair Sign-off		
Mechanical Fits- Bearing Housings - Post Repair			
80.	Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees	

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



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

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Printed on 10/6/2022

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98. Final Pics and QC Review



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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.
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.
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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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