



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

Motor Shop Repairs

Job Number 99812

Prepared for Riceland Foods (11100-RLF)

Hwy 79 & N. Park Ave.
Stuttgart AR 72160

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AC Recondition As Found - *Motor Shop*

AC Recondition - Rev. 2: QQ2-G17T1862XPE 2

1.0

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

AC Recondition As Found

Riceland Foods (11100-RLF)

Hwy 79 & N. Park Ave.
Stuttgart, AR 72160

FolderID: 99812
FormID: 13623505

AC Recondition - Rev. 2

Location: Motor Shop

Serial Number: QQ2-G17T1862XPE 2

Description: 250HP Siemens 1800RPM B449T
XP

Hi-Speed Job Number: 99812

Manufacturer: Siemens

Product Number: 1MB21214EB512AG3

Serial Number: QQ2-G17T1862XPE 2

HP/kW: 250 (HP)

RPM: 1785 (RPM)

Frame: B449T

Voltage: 460

Current: 278

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.0

Enclosure: XP

J-box Included: Complete

Coupling/Sheave: None

Date Received: 05/17/2022

Bearing RTDs: No


Stator RTDs: No

Repair Stage: Final

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found:  8 - Good

Overall Condition

1. Report Date

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1.0

2. Nameplate Picture



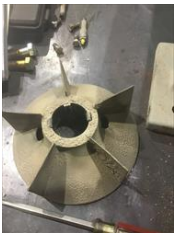
3. Describe the Overall Condition of the Equipment as Received

Initial Mechanical/Electrical

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



10. Lead Length	17 Inches
11. Frame Condition	pass
12. Fan Condition	(P) Pass



13. Broken or Missing Components

Initial Electrical Inspection

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14. Insulation Resistance/Megger

55,700 Megohms



15. Winding Resistance

1-2

1-3

2-3

.0146

.0146

.0146

16. Perform Surge Test

(P) Pass



17. Stator Condition

wash and bake



Mechanical Inspection

18. Drive End Bearing Number-

6318Z



19. Drive End Bearing Qty.

1

20. Drive End Bearing Type

(Ball) Ball Bearing

21. Drive End Lubrication Type





(Grease) Grease Lubricated

22. Drive End Bearing Insulation or Grounding Device?

no

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

no

24. Drive End Bearing Condition	normal wear
	
25. Opposite Drive End Bearing Number-	6316Z
	
26. Opposite Drive End Bearing Qty.	1
27. Opposite Drive End Bearing Type	(Ball) Ball Bearing
28. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
29. Opposite Drive End Bearing Insulation or Grounding Device?	no
30. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	yes
31. Opposite Drive End Bearing Condition	normal wear
	
32. Drive End Seal	
33. Opposite Drive End Seal	
Rotor Inspection	
34. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
35. Growler Test	(Pass) Pass
36. Number of Rotor Bars	
37. Rotor Condition	great
	
38. List the Parts needed for the Repair Below	

39. Signature of Technician that Disassembled Motor

RW

RW

Mechanical Fits- Rotor

40. Shaft Runout

41. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

42. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

43. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

44. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.5442

3.5442

3.5442

45. Drive End Bearing Shaft Fit Condition

(P) Pass



46. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

3.1502

3.1502

3.1502

47. Opposite Drive End Bearing Shaft Fit Condition

(P) Pass



48. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

49. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

7.4815

7.4815

7.4815

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50. Drive End - Endbell Bearing Fit Condition

(P) Pass



51. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

6.6929

6.6929

6.6929

52. Opposite Drive End - Endbell Bearing Fit Condition

(P) Pass



53. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap

pass



54. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

55. List Machine Work Needed Below

56. Technician

RW

RW

Dynamic Balance Report

57. Rotor Weight and Balance Grade

Rotor Weight



Balance Grade

58. Initial Balance Readings

Drive End

Opposite Drive End

59. Final Balance Readings		
Drive End	Opposite Drive End	
60. Technician		
Rewind		
61. Core Test Results - Watts loss per Pound		
Pre-Burnout	Post Burnout	
62. Core Hot Spot Test		
Pre-Burnout	Post-Burnout	
63. Post Rewind Electrical Test- Insulation Resistance		
64. Post Rewind Polarization Index		
65. Post Rewind Winding Resistance		
1-2	1-3	2-3
66. Post Rewind Surge Test		
67. Post Rewind Hi-Pot		
68. Technician		
Root Cause of Failure		
69. Failure locations		
70. Root cause of failure		
None		
Mechanical Fits- Rotor - Post Repair		
71. Shaft Runout Post Repair		
72. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
73. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
74. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
75. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
76. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
77. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
78. Shaft Repair Sign-off		
Mechanical Fits- Bearing Housings - Post Repair		
79. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees

80. Opposite Drive End - Endbell Bearing Fit Post Repair			
0 Degrees	60 Degrees	120 Degrees	
81. Bearing Cap Condition Post Repair			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
82. End Bell Air Seal Fits Post Repair			
Drive End Air Seal	Opposite Drive End Air Seal		
83. End Bell Repair Sign-off			
Assembly			
84. Photograph All Major Components prior to assembly			
85. Final Insulation Resistance Test			
86. Assembled Shaft Endplay			
87. Assembled Shaft Runout			
88. Test Run Voltage			
Volts	Volts	Volts	
459	458	461	
			
89. Test Run Amperage			
Amps	Amps	Amps	
105.6	100.2	100.2	
			
90. Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
0.02	0.04	0.02	
91. Opposite Drive End Vibration Readings - Inches Per Second			
Horizontal	Vertical	Axial	
0.02	0.02	0.01	
92. Ambient Temperature - Fahrenheit			
93. Drive End Bearing Temps - Fahrenheit			
5 Minutes	10 Minutes	15 Minutes	

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94. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

95. Final Test Run Sign-off

RW

RW

96. Document Final Condition with Pictures after paint



97. Final Pics and QC Review

RW

RW





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.
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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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.
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.