



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

Motor Shop Repairs

Job Number 99813

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: 12408383

1.0

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AC Recondition As Found

Riceland Foods (11100-RLF)

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

FolderID: 99813
FormID: 13623510

AC Recondition - Rev. 2

Location: Motor Shop

Serial Number: 12408383

Description: 300HP WEG 1800RPM 449T XP

Hi-Speed Job Number: 99813

Manufacturer: WEG

Product Number: 30018XT3G449T

Serial Number: 12408383

HP/kW: 300 (HP)

RPM: 1785 (RPM)

Frame: 449T

Voltage: 460

Current: 334

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

Enclosure: XP

J-box Included: Complete

Coupling/Sheave: None

Date Received: 05/17/2022

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Bearing Housing Machined Yes
Fit Repairs Required:

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

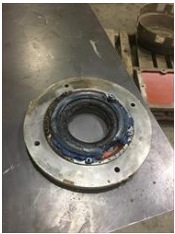
Priorities Found: ● 1 - High ● 7 - Good

Overall Condition

1. Report Date
2. Nameplate Picture



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3. Describe the Overall Condition of the Equipment as Received

Initial Mechanical/Electrical

4. Does Shaft Turn Freely? (Yes) Yes

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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	14 Inches
11.	Frame Condition	pass
12.	Fan Condition	(P) Pass
13.	Broken or Missing Components	na
Initial Electrical Inspection		
14.	Insulation Resistance/Megger	Megohms
15.	Winding Resistance	
	1-2	1-3 2-3
<div> <div></div> <div>Pass</div> </div>		
16.	Perform Surge Test	(P) Pass
17.	Stator Condition	pass
Mechanical Inspection		
18.	Drive End Bearing Number-	6322
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?	na
23.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	na
24.	Drive End Bearing Condition	normal wear
25.	Opposite Drive End Bearing Number-	6319
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?	na
30.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	springs
31.	Opposite Drive End Bearing Condition	normal wear
32.	Drive End Seal	lip seal/ pass
33.	Opposite Drive End Seal	lip seal/ pass
Rotor Inspection		
34.	Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
35.	Growler Test	(Pass) Pass
36.	Number of Rotor Bars	48
37.	Rotor Condition	pass
38.	List the Parts needed for the Repair Below	
	<i>Bearings</i>	
39.	Signature of Technician that Disassembled Motor	
Mechanical Fits- Rotor		
40.	Shaft Runout	0.001 inches

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41. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0.001		
42. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
Pass		
43. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
Pass		
44. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
Pass		
45. Drive End Bearing Shaft Fit Condition		(P) Pass
46. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
Pass		
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
9.4489/9.4489/9.4490		
50. Drive End - Endbell Bearing Fit Condition		(P) Pass
51. Opposite Drive End - Endbell Bearing Fit		
0 Degrees	60 Degrees	120 Degrees
7.8755	7.8765	7.876
Fail		
52. Opposite Drive End - Endbell Bearing Fit Condition		(F) Fail
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

ODE end bell bearing fit



56. Technician

Gary Moore

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

Bearing wear

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
469	459		462



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89. Test Run Amperage

Amps

114.5

Amps

100.7

Amps

111.2



90. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

91. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

92. Ambient Temperature - Fahrenheit

93. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

94. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

95. Final Test Run Sign-off

96. Document Final Condition with Pictures after paint



97. Final Pics and QC Review

CW

CW





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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.
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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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