



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

LR Motor Shop Repairs

**Job Number 99758**

Prepared for Sage V Foods

5901 SLOAN DRIVE  
LITTLE ROCK AR 72206

# Table of Contents

AC Recondition As Found - *MOTOR SHOP LR*

AC Recondition - Rev. 2: *C2002030652*

**1.0**

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

## AC Recondition As Found

Sage V Foods  
5901 SLOAN DRIVE  
LITTLE ROCK, AR 72206

FolderID: 99758  
FormID: 13502225

### AC Recondition - Rev. 2

Location: MOTOR SHOP LR

Serial Number: C2002030652

Description: 25HP Baldor 1775RPM 284T Severe Duty

Hi-Speed Job Number: 99758

Manufacturer: Baldor

Spec/ID #: 10-0000-0086

Serial Number: C2002030652

HP/kW: 25 (HP)

RPM: 1775 (RPM)

Frame: 284T

Voltage: 230 / 460

Current: 62/31

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.00

Enclosure: TENV

J-box Included: Complete

Coupling/Sheave: None

Date Received: 05/05/2022

Bearing RTDs: No

Stator RTDs: No

Repair Stage: Final

Heaters: No

Winding Type : Random Wound

Bearing Type: Rolling Element

Priorities Found: ● 7 - Good

### Overall Condition

1. Report Date

05/25/2022

2. Nameplate Picture



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1.1





3. Describe the Overall Condition of the Equipment as Received

**Shaft broken**

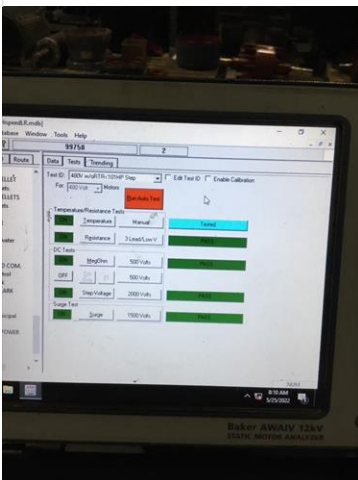
4. Photos of all six sides of the machine.

### Initial Mechanical/Electrical

5. Does Shaft Turn Freely?	(Yes) Yes
6. Does Shaft Have Visible Damage?	(Yes) Yes
Drive end broken off.	
7. Assembled Shaft Runout	
8. Assembled Shaft End Play	
9. Air Gap Variation <10%	
10. Lead Condition	(P) Pass
11. Lead Length	12 Inches
12. Frame Condition	good
13. Fan Condition	(N) NA
14. Broken or Missing Components	shaft broken

### 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

**good**

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**Mechanical Inspection**

19. Drive End Bearing Number-	6311
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?	none
24. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
25. Drive End Bearing Condition	good
26. Opposite Drive End Bearing Number-	6309
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?	none
31. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	wavy washer
32. Opposite Drive End Bearing Condition	good
33. Drive End Seal	good
34. Opposite Drive End Seal	none

**Rotor Inspection**

35. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
36. Growler Test	(Pass) Pass
37. Number of Rotor Bars	40
38. Rotor Condition	good
39. List the Parts needed for the Repair Below <i>shaft, 6311, 6309</i>	
40. Signature of Technician that Disassembled Motor	David Maclin

**Mechanical Fits- Rotor**

41. Shaft Runout		
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
44. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
45. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
46. Drive End Bearing Shaft Fit Condition		(P) Pass
47. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees

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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
51.	Drive End - Endbell Bearing Fit Condition	(P) Pass	
52.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
53.	Opposite Drive End - Endbell Bearing Fit Condition	(P) Pass	
54.	Bearing Cap Condition		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
55.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
56.	List Machine Work Needed Below		
	New shaft		



57. Technician

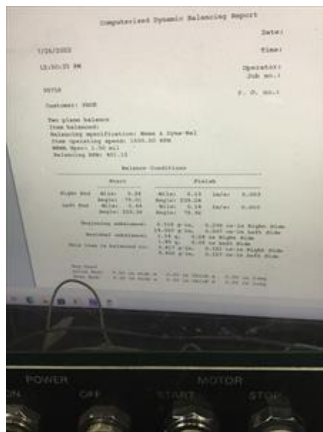
David Maclin

**Dynamic Balance Report**

## 58. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



## 59. Initial Balance Readings

Drive End

Opposite Drive End

**.25****.44**

## 60. Final Balance Readings

Drive End

Opposite Drive End

**.13****.14**

## 61. Technician

**RW**
**Rewind**

## 62. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

## 63. Core Hot Spot Test

Pre-Burnout

Post-Burnout

## 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

**Shaft broken.**

## 71. Root cause of failure

**Shaft broken****Mechanical Fits- Rotor - Post Repair**

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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		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
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
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		
<b>Assembly</b>		
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

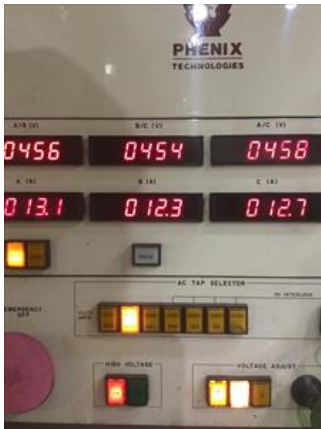
456

Volts

454

Volts

458



## 90. Test Run Amperage

Amps

13.1

Amps

12.4

Amps

12.7



## 91. Drive End Vibration Readings - Inches Per Second

Horizontal

0.01

Vertical

0.02

Axial

0.05

## 92. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

0.04

Vertical

0.02

Axial

0.05

## 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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98. Final Pics and QC Review

RW

RW





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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.
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