



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

LR Motor Shop Repairs

**Job Number 100321**

Prepared for Sage V Foods

5901 SLOAN DRIVE  
LITTLE ROCK AR 72206

# Table of Contents



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: 100321  
 FormID: 14613305

### AC Recondition - Rev. 2

**Location:** MOTOR SHOP LR  
**Serial Number:** C1810150237  
**Description:** 25HP BALDOR 1800RPM 284T

<b>Hi-Speed Job Number:</b>	100321
<b>Manufacturer:</b>	Baldor
<b>Spec/ID #:</b>	10-0000-0086
<b>Serial Number:</b>	C181050237
<b>HP/kW:</b>	25 (HP)
<b>RPM:</b>	1775 (RPM)
<b>Frame:</b>	284T
<b>Voltage:</b>	230 / 460
<b>Current:</b>	62/31
<b>Phase:</b>	Three
<b>Hz:</b>	60 (Hz)
<b>Service Factor:</b>	1.15
<b>Enclosure:</b>	TEFC
<b>J-box Included:</b>	Complete
<b>Coupling/Sheave:</b>	None
<b>Bearing RTDs:</b>	No
<b>Stator RTDs:</b>	No
<b>Repair Stage:</b>	Final
<b>Heaters:</b>	No
<b>Winding Type :</b>	Random Wound
<b>Bearing Type:</b>	Rolling Element

Priorities Found: ● 1 - High ● 6 - Good

### Overall Condition

1. Report Date
2. Nameplate Picture



3. Photos of all six sides of the machine.

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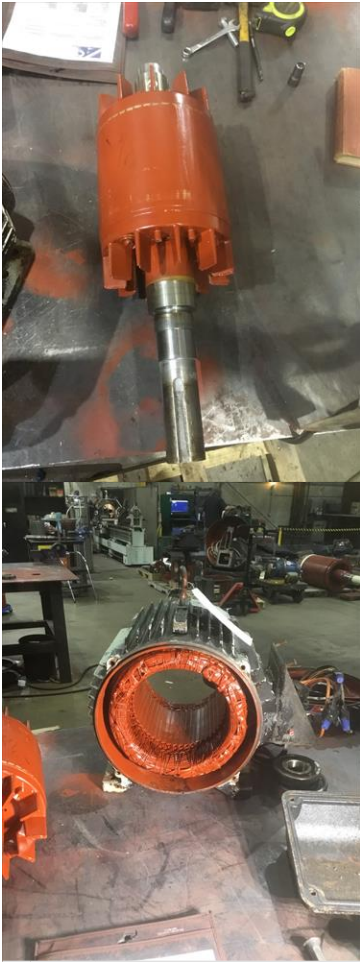




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4. Describe the Overall Condition of the Equipment as Received  
*Serviceable*

**Initial Mechanical/Electrical**

- |                                  |                                    |                  |
|----------------------------------|------------------------------------|------------------|
| <input checked="" type="radio"/> | 5. Does Shaft Turn Freely?         | <b>(Yes) Yes</b> |
| <input type="radio"/>            | 6. Does Shaft Have Visible Damage? | <b>(No) No</b>   |



- |                          |                             |
|--------------------------|-----------------------------|
| <input type="checkbox"/> | 7. Assembled Shaft Runout   |
| <input type="checkbox"/> | 8. Assembled Shaft End Play |
| <input type="checkbox"/> | 9. Air Gap Variation <10%   |

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10. Lead Condition

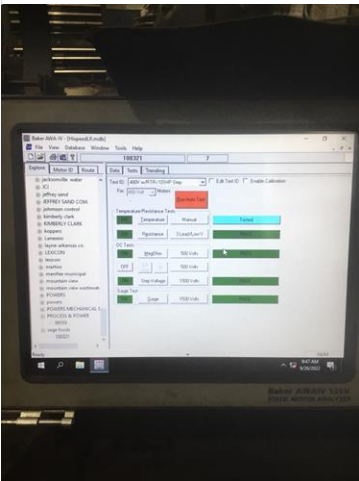
(P) Pass



11. Lead Length			13 Inches
12. Frame Condition			serviceable
13. Fan Condition			(N) NA
14. Broken or Missing Components			none
<b>Initial Electrical Inspection</b>			
15. Insulation Resistance/Megger			Megohms
16. Winding Resistance	1-2	1-3	2-3

17. Perform Surge Test

(P) Pass



18. Stator Condition			
<b>Mechanical Inspection</b>			

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19. Drive End Bearing Number-

6311 2RSR



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	replace
26. Opposite Drive End Bearing Number-	6309 2RS



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?	yes

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32. Opposite Drive End Bearing Condition

replace

33. Drive End Seal

In Pro seal



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

38. Rotor Condition

pass

39. List the Parts needed for the Repair Below

40. Signature of Technician that Disassembled Motor

Terrence. Holland

**Mechanical Fits- Rotor**

41. Shaft Runout


inches

42. Rotor Runout

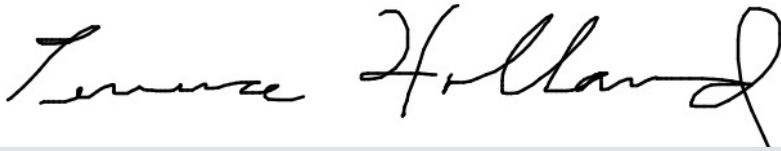
Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

43. Coupling Fit Closest to Bearing Housing	0 Degrees	90 Degrees	120 Degrees	
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	
	<b>2.1657</b>	<b>2.1658</b>	<b>2.1658</b>	
● 46. Drive End Bearing Shaft Fit Condition				<b>(P) Pass</b>
47. Opposite Drive End Bearing Shaft Fit	0 Degrees	60 Degrees	120 Degrees	
	<b>1.772</b>	<b>1.7718</b>	<b>1.7718</b>	
● 48. Opposite Drive End Bearing Shaft Fit Condition				<b>(P) Pass</b>
49. Shaft Air Seal Fits	Drive End Air Seal	Opposite Drive End Air Seal		
<b>Mechanical Fits- Bearing Housings</b>				
50. Drive End - Endbell Bearing Fit	0 Degrees	60 Degrees	120 Degrees	
	<b>4.725</b>	<b>4.725</b>	<b>4.7251</b>	
● 51. Drive End - Endbell Bearing Fit Condition				<b>(P) Pass</b>
52. Opposite Drive End - Endbell Bearing Fit	0 Degrees	60 Degrees	120 Degrees	
	<b>3.938</b>	<b>3.9381</b>	<b>3.9381</b>	
● 53. Opposite Drive End - Endbell Bearing Fit Condition				<b>(F) Fail</b>
54. Bearing Cap Condition	Drive End Bearing Cap	Opposite Drive End Bearing Cap		
	<b>pass</b>			
				
55. End Bell Air Seal Fits	Drive End Air Seal	Opposite Drive End Air Seal		
56. List Machine Work Needed Below	<i>Re-sleeve ODE housing fit.</i>			

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### 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

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

*Ode housing fit out of tolerance.*

71. Root cause of failure

*Housing fit measures too large. Bearing grease contaminated.*

### 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			
<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	
<b>3.9376</b>	<b>3.9375</b>	<b>3.9375</b>	
			
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	Volts	Volts	
90. Test Run Amperage			
Amps	Amps	Amps	

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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		



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.
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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.
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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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, earth quake, 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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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.