



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

LR Motor Shop Repairs

**Job Number 100314**

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: *C0906010023*

**1.0**

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*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: 100314  
FormID: 14607577

### AC Recondition - Rev. 2

Location: MOTOR SHOP LR  
Serial Number: C0906010023  
Description: 50HP BALDOR 1800RPM 326TDZ

Hi-Speed Job Number:	100314
Manufacturer:	Baldor
Spec/ID #:	12F654W829G1
Serial Number:	C0906010026
HP/kW:	50 (HP)
RPM:	1775 (RPM)
Frame:	326TDZ
Voltage:	230 / 460
Current:	114/57
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
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: ● 1 - High ● 8 - Good

### Overall Condition

1. Report Date

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## 2. Nameplate Picture



3. Photos of all six sides of the machine.

4. Describe the Overall Condition of the Equipment as Received

### Initial Mechanical/Electrical

<input checked="" type="radio"/>	5. Does Shaft Turn Freely?	(Yes) Yes
<input type="radio"/>	6. Does Shaft Have Visible Damage?	
<input checked="" type="radio"/>	7. Assembled Shaft Runout	0.123 Inches
<input type="radio"/>	8. Assembled Shaft End Play	
<input type="radio"/>	9. Air Gap Variation <10%	

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10. Lead Condition

(P) Pass



11. Lead Length

9 Inches

12. Frame Condition

pass

13. Fan Condition

(P) Pass

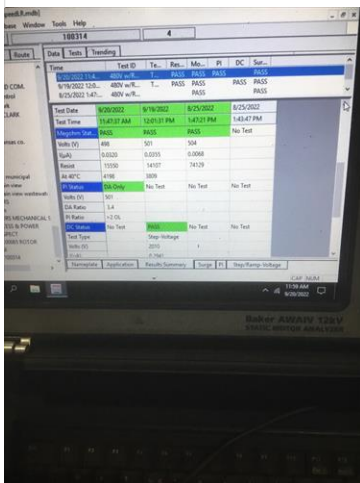


14. Broken or Missing Components

## Initial Electrical Inspection

15. Insulation Resistance/Megger

15550 Megohms



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## 16. Winding Resistance

1-2

1-3

2-3

.127

.127

.126

## 17. Perform Surge Test

(P) Pass

Test Date	11/4/21	12/01/21	1/4/21	1/4/21
Test Time	11:47:37 AM	12:01:31 PM	1:47:21 PM	1:43:47 PM
Test Status	No Test	PASS	No Test	No Test
Test Type	Step-Voltage			
Volts (V)	2010			
Volts (V)	0.2941			
Resist	6834			
At 40°C	1945			
Surge Status	PASS	PASS	PASS	No Test
Peak Volt/V1 L1	1500	1540	2080	
Peak Volt/V1 L2	1500	1540	2000	
Peak Volt/V1 L3	1500	1510	2000	
Max P-P EARR	0.4/0.4/0.4	2.2/2.1/2.1	1.1/1.2/1.0	
EAR 1-2/2-3/...	No Test	No Test	No Test	

## 18. Stator Condition



## 19. Number of Stator Slots

## Mechanical Inspection

20. Drive End Bearing Number-

6312 2RS

21. Drive End Bearing Qty.

1

22. Drive End Bearing Type

(Ball) Ball Bearing

23. Drive End Lubrication Type

(Grease) Grease Lubricated

24. Drive End Bearing Insulation or Grounding Device?

Aegis ring shaft 2.880



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

na

26. Drive End Bearing Condition

27. Opposite Drive End Bearing Number-

6311 2RS



28. Opposite Drive End Bearing Qty.

1

29. Opposite Drive End Bearing Type

(Ball) Ball Bearing

30. Opposite Drive End Lubrication Type

(Grease) Grease Lubricated

31. Opposite Drive End Bearing Insulation or Grounding Device?

na

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

wavy washer

33. Opposite Drive End Bearing Condition

34. Drive End Seal

improve seal



35. Opposite Drive End Seal

### Rotor Inspection

36. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast

37. Growler Test

38. Number of Rotor Bars

39. Rotor Condition

pass

40. List the Parts needed for the Repair Below

*Needs new shaft*



41. Signature of Technician that Disassembled Motor

RW

*RW*

### Mechanical Fits- Rotor

42. Shaft Runout

0.123 inches

43. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing


44. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

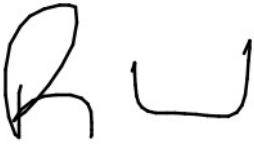
120 Degrees

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45.	Coupling Fit Closest to the end of the Shaft		
	0 Degrees	60 Degrees	120 Degrees
46.	Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
47.	Drive End Bearing Shaft Fit Condition		(P) Pass
48.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
49.	Opposite Drive End Bearing Shaft Fit Condition		(P) Pass
50.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings			
51.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
52.	Drive End - Endbell Bearing Fit Condition		(P) Pass
53.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
54.	Opposite Drive End - Endbell Bearing Fit Condition		(P) Pass
55.	Bearing Cap Condition		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	pass	na	
			
56.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
57.	List Machine Work Needed Below		
	New shaft		

58. Technician

RW


**Dynamic Balance Report**

59. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



60. Initial Balance Readings

Drive End

Opposite Drive End

0.09

1.07

61. Final Balance Readings

Drive End

Opposite Drive End

013

0.26

62. Technician

David Maclin


**Rewind**

63. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

64. Core Hot Spot Test

Pre-Burnout

Post-Burnout

65. Post Rewind Electrical Test- Insulation Resistance

66. Post Rewind Polarization Index

67. Post Rewind Winding Resistance

1-2

1-3

2-3

68. Post Rewind Surge Test

69. Post Rewind Hi-Pot

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70. Technician		
<b>Root Cause of Failure</b>		
71. Failure locations		
72. Root cause of failure		
<b>Mechanical Fits- Rotor - Post Repair</b>		
73. Shaft Runout Post Repair		
74. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
75. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
76. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
77. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
78. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
79. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
80. Shaft Repair Sign-off		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
81. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
82. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
83. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
84. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
85. End Bell Repair Sign-off		
<b>Assembly</b>		
86. Photograph All Major Components prior to assembly		

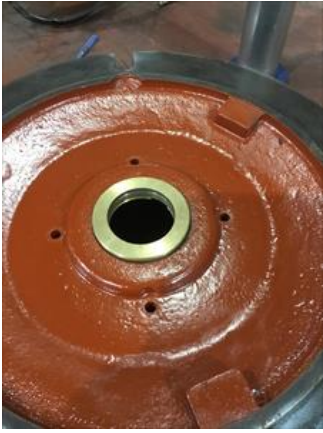


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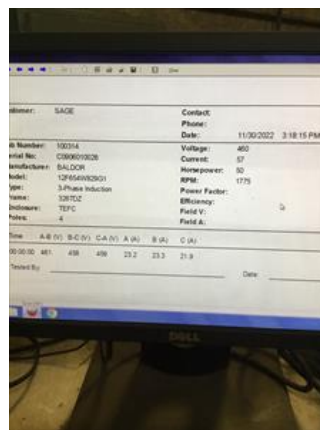
1.9



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87. Final Insulation Resistance Test		
88. Assembled Shaft Endplay		<b>0 inches</b>
89. Assembled Shaft Runout		
90. Test Run Voltage		
Volts	Volts	Volts
<b>461</b>	<b>458</b>	<b>459</b>



91. Test Run Amperage		
Amps	Amps	Amps
<b>23</b>	<b>23.2</b>	<b>21.8</b>

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92. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
<b>0.0321</b>	<b>0.0391</b>	<b>0.0159</b>
93. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
<b>0.0131</b>	<b>0.0231</b>	<b>0.0083</b>
94. Ambient Temperature - Fahrenheit		
95. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
96. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
97. Final Test Run Sign-off		David Maclin
		

98. Document Final Condition with Pictures after paint



99. Final Pics and QC Review



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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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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.
12. **ABANDONED EQUIPMENT.** Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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.