



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

LR Motor Shop Repairs

Job Number 100275

Prepared for Twin Rivers (12049)

3501 Jefferson Parkway
Pine Bluff AR 71602

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

AC Recondition As Found

Twin Rivers (12049)
3501 Jefferson Parkway
Pine Bluff, AR 71602

FolderID: 100275
FormID: 14549111

AC Recondition - Rev. 2

Location: Shop

Serial Number: 3285

Description: 25HP US MOTORS AERATOR
1200RPM 324LPHZ

Hi-Speed Job Number: 100275

Manufacturer: US Motors/Nidec

Spec/ID #: 3285

HP/kW: 20 (HP)

RPM: 1190 (RPM)

Voltage: 460

Current: 29

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

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 ● 6 - Good

Overall Condition

1. Report Date
2. Nameplate Picture



3. Photos of all six sides of the machine.

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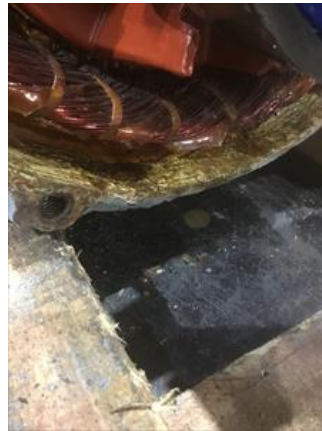




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4. Describe the Overall Condition of the Equipment as Received
Serviceable

Initial Mechanical/Electrical

5.	Does Shaft Turn Freely?	(Yes) Yes
6.	Does Shaft Have Visible Damage?	(No) No
7.	Assembled Shaft Runout	0.001 Inches
8.	Assembled Shaft End Play	
9.	Air Gap Variation <10%	
10.	Lead Condition	(P) Pass



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11. Lead Length	8 Inches
12. Frame Condition	pass
13. Fan Condition	(P) Pass



14. Broken or Missing Components	none
Initial Electrical Inspection	
15. Insulation Resistance/Megger	Megohms



16. Winding Resistance			
1-2		1-3	2-3
17. Perform Surge Test			
<div><div></div></div>	18. Stator Condition		
<div><div></div></div>	Fail		
<div><div></div></div>	High no-load current - 20.1NLA out of 29FLA		
Mechanical Inspection			

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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-	6210



27. Opposite Drive End Bearing Qty.	1
28. Opposite Drive End Bearing Type	(Ball) Ball Bearing

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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?	none
32. Opposite Drive End Bearing Condition	replace
33. Drive End Seal	national 471138



34. Opposite Drive End Seal	none
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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	good
39. List the Parts needed for the Repair Below	
40. Signature of Technician that Disassembled Motor	Terrence. Holland


Mechanical Fits- Rotor

41. Shaft Runout	0.001 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	
2.5597	2.5597	2.5597	
46. Drive End Bearing Shaft Fit Condition	(P) Pass		

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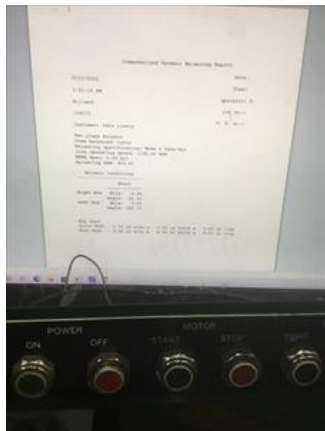
47.	Opposite Drive End Bearing Shaft Fit		
	0 Degrees	60 Degrees	120 Degrees
	1.9687	1.9687	1.9686
<div></div> 48.	Opposite Drive End Bearing Shaft Fit Condition		(P) Pass
49.	Shaft Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
Mechanical Fits- Bearing Housings			
50.	Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
51.	Drive End - Endbell Bearing Fit Condition		
52.	Opposite Drive End - Endbell Bearing Fit		
	0 Degrees	60 Degrees	120 Degrees
53.	Opposite Drive End - Endbell Bearing Fit Condition		
54.	Bearing Cap Condition		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	pass	pass	



55.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
56.	List Machine Work Needed Below		
	Seal surface worn		
57.	Technician		Terrence. Holland
			
Dynamic Balance Report			
58.	Rotor Weight and Balance Grade		
	Rotor Weight	Balance Grade	

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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		

71. Root cause of failure

Motor pulls high amps with no load. Possibly wound with wrong data. Both housing fits in stator and on end bells not clean. Also found water inside stator which indicates improper sealing.



Mechanical Fits- Rotor - Post Repair

72. Shaft Runout Post Repair

0.012 inches

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		
Mechanical Fits- Bearing Housings - Post Repair		
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		
Assembly		
85. Photograph All Major Components prior to assembly		

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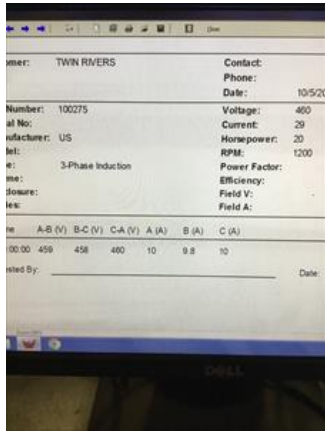


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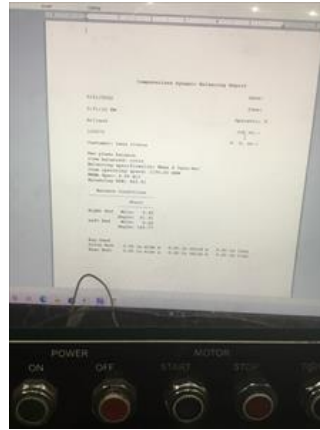
86. Final Insulation Resistance Test		
87. Assembled Shaft Endplay		
88. Assembled Shaft Runout		0.005 inches
89. Test Run Voltage		
Volts	Volts	Volts
459	458	460

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90. Test Run Amperage		
Amps	Amps	Amps
10	9.8000000000000001	10
91. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.0112	0.0155	0.0112
92. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
0.0134	0.0144	0.0132
93. Ambient Temperature - Fahrenheit		70
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		David Maclin
		

97. Document Final Condition with Pictures after paint



98. Final Pics and QC Review

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

AC Random Coil Rewind Report

FolderID: 100275
FormID: 14635808

Twin Rivers (12049)
3501 Jefferson Parkway
Pine Bluff, AR 71602

Priorities Found: ● 1 - Good

General

1. Job Number	100275
2. Report Date	09/20/2022
3. Customer	Twin Rivers



Stator Winding

4. Core Length	7.125 "
5. Core ID	8.5 "
6. Back Iron Depth	0.625 "
7. Slot Depth	0.875 "
8. Tooth Width	0.23 "
9. Number of Vents	
10. Vent Width	
11. Before Burnout Core loss	
12. Flux Before Burnout	
13. Watts before burnout	
14. Watts loss per lb. before burnout	
15. After Burnout Core Loss	
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	
19. Core Iron Condition	
20. RTD's	
21. RTD's Reading	
22. Motor Heaters	

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2.0

23. Heater Qty.	
24. Heater Voltage	
25. Heater Wattage	
26. Thermistors	
27. Number of Poles	6
28. Slots	54
29. Number of Coils	54
30. Coil Weight	Lbs.
31. Lead Markings	
32. Grouping 18 of 3	
33. Multiple Wires	(Y) Yes
34. Wire Size 19,20	
35. Turns per coil	36
36. Pitch 1 to:	9
37. Connection 3 Delta	
38. Lead Length	"
39. Lead Size	
40. Number of Leads	
41. Megger Reading After Rewind	
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	
46. Surge Pattern After Rewind	
47. Service Technician	Robert H Roberson
	



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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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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.