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: 100566
FormID: 15171193

AC Recondition - Rev. 2

Location:	MOTOR SHOP LR
Serial Number:	NO NP
Description:	2.5HP BALDOR 1200RPM 213Z SHAKER

Hi-Speed Job Number:	100566
Manufacturer:	Baldor
Product Number:	07J015W322G1
Spec/ID #:	07J015W332G1
HP/kW:	2.5 (HP)
RPM:	1120 (RPM)
Frame:	213Z
Voltage:	230 / 460
Current:	10.2/5.1
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TENV
J-box Included:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **3 - High** **4 - Good**

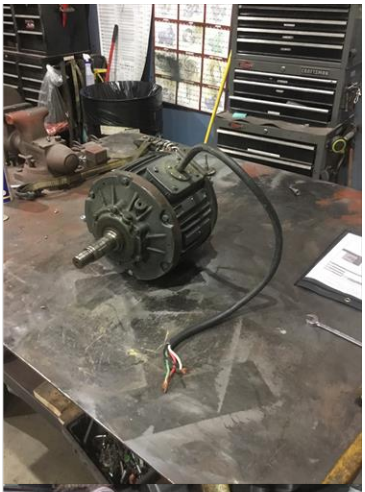
Overall Condition

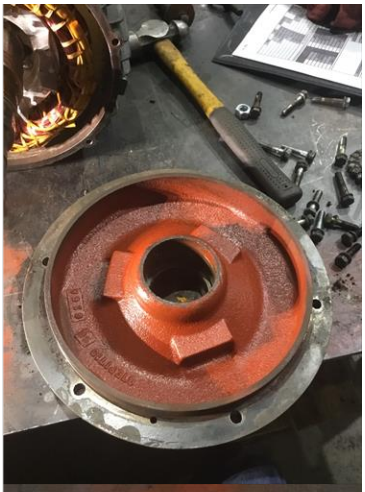
1. Report Date

2. Nameplate Picture — **none**

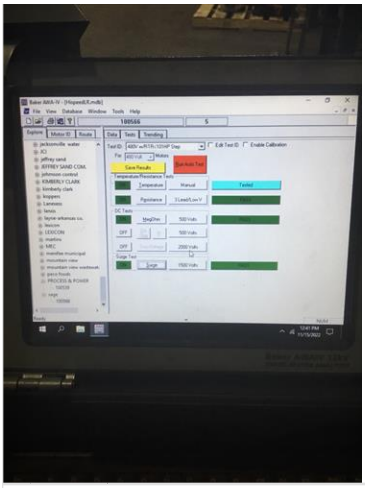
Name plate missing.

3. Photos of all six sides of the machine. P27







4.	Describe the Overall Condition of the Equipment as Received ***Serviceable***		
5.	Distance from the end of the shaft to the Coupling/Sheave		

Initial Mechanical/Electrical

6.	Does Shaft Turn Freely?	**(Yes) Yes**	
7.	Does Shaft Have Visible Damage?	**(No) No**	
8.	Assembled Shaft Runout		
9.	Assembled Shaft End Play		
10.	Air Gap Variation <10%		
11.	Lead Condition	**(P) Pass**	P32

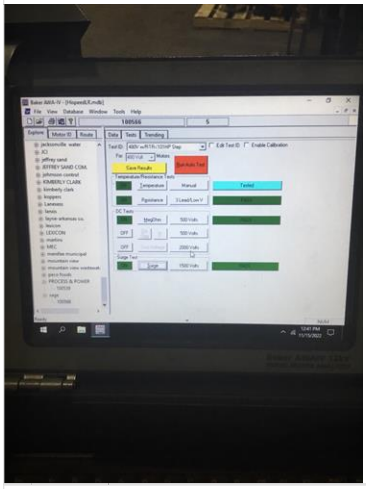
12.	Lead Length	**35 Inches**	
13.	Frame Condition	**pass**	
14.	Fan Condition	**(N) NA**	
15.	Broken or Missing Components	**none**	

Initial Electrical Inspection

16.	Insulation Resistance/Megger	**Megohms**	
17.	Winding Resistance		

1-2	1-3	2-3

18.	Perform Surge Test	**(P) Pass**	P35



19.	Stator Condition	**pass**	
20.	Number of Stator Slots		

Mechanical Inspection

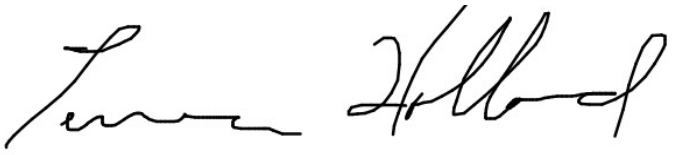
21.	Drive End Bearing Number-	**nu 311-E-XL-M1-C4**	P8

22.	Drive End Bearing Qty.	**1**
23.	Drive End Bearing Type	**(Ball) Ball Bearing**
24.	Drive End Lubrication Type	**(Grease) Grease Lubricated**
25.	Drive End Bearing Insulation or Grounding Device?	**none**
26.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**
27.	Drive End Bearing Condition	**replace**
28.	Opposite Drive End Bearing Number-	
29.	Opposite Drive End Bearing Qty.	**1**
30.	Opposite Drive End Bearing Type	**(Spherical) Spherical Roller Bearing**
31.	Opposite Drive End Lubrication Type	**(Grease) Grease Lubricated**
32.	Opposite Drive End Bearing Insulation or Grounding Device?	**none**
33.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**
34.	Opposite Drive End Bearing Condition	**replace**
35.	Drive End Seal	**CR 31135**
36.	Opposite Drive End Seal	**none**

Rotor Inspection

37.	Rotor Type/Material	**(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast**

38.	Growler Test	**(Pass) Pass**
39.	Number of Rotor Bars	
40.	Rotor Condition	**pass**
41.	List the Parts needed for the Repair Below	
42.	Signature of Technician that Disassembled Motor	**Terrence Holland**



Mechanical Fits- Rotor

43.	Shaft Runout	**inches**
44.	Rotor Runout	

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

45.	Coupling Fit Closest to Bearing Housing	

0 Degrees	90 Degrees	120 Degrees

46.	Coupling Fit Closest to the end of the Shaft	

0 Degrees	60 Degrees	120 Degrees

47.	Drive End Bearing Shaft Fit	

0 Degrees	60 Degrees	120 Degrees
2.5575	**2.5576**	**2.5575**

48.	Drive End Bearing Shaft Fit Condition		**(F) Fail**
49.	Opposite Drive End Bearing Shaft Fit		

0 Degrees	60 Degrees	120 Degrees
2.1639	**2.164**	**2.164**

50.	Opposite Drive End Bearing Shaft Fit Condition	**(F) Fail**
51.	Shaft Air Seal Fits	

Drive End Air Seal	Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

52.	Drive End - Endbell Bearing Fit	

0 Degrees	60 Degrees	120 Degrees

Bad. Excessive wear.

53.	Drive End - Endbell Bearing Fit Condition	**(F) Fail**

Excessive wear.

54.	Opposite Drive End - Endbell Bearing Fit	

0 Degrees	60 Degrees	120 Degrees
4.7243	**4.7242**	**4.7244**

Pass

55.	Opposite Drive End - Endbell Bearing Fit Condition	**(P) Pass**
56.	Bearing Cap Condition	

Drive End Bearing Cap	Opposite Drive End Bearing Cap
pass	**pass**

57.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	
58.	List Machine Work Needed Below		
59.	Technician		

Dynamic Balance Report

60.	Rotor Weight and Balance Grade		
	Rotor Weight	Balance Grade	
61.	Initial Balance Readings		
	Drive End	Opposite Drive End	
62.	Final Balance Readings		
	Drive End	Opposite Drive End	
63.	Technician		

Rewind

64.	Core Test Results - Watts loss per Pound		
	Pre-Burnout	Post Burnout	
65.	Core Hot Spot Test		
	Pre-Burnout	Post-Burnout	
66.	Post Rewind Electrical Test- Insulation Resistance		
67.	Post Rewind Polarization Index		
68.	Post Rewind Winding Resistance		
	1-2	1-3	2-3
69.	Post Rewind Surge Test		
70.	Post Rewind Hi-Pot		
71.	Technician		

Root Cause of Failure

72.	Failure locations		
73.	Root cause of failure		

Mechanical Fits- Rotor - Post Repair

74.	Shaft Runout Post Repair		
75.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
76.	Coupling Fit Closest to Bearing Housing Post Repair		
	0 Degrees	90 Degrees	120 Degrees
77.	Coupling Fit Closest to the end of the Shaft Post Repair		
	0 Degrees	60 Degrees	120 Degrees

78.	Drive End Bearing Shaft Fit Post Repair		P400
	0 Degrees	60 Degrees	120 Degrees
	2.165	**2.165**	**2.165**

79.	Opposite Drive End Bearing Shaft Fit Post Repair		P500
	0 Degrees	60 Degrees	120 Degrees
	2.559	**2.559**	**2.559**

80.	Shaft Air Seal Fits Post Repair	
	Drive End Air Seal	Opposite Drive End Air Seal

81. Shaft Repair Sign-off

Mechanical Fits- Bearing Housings - Post Repair

82.	Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees

83.	Opposite Drive End - Endbell Bearing Fit Post Repair			P100
	0 Degrees	60 Degrees	120 Degrees	
	5.5117	**5.5117**	**5.5118**	

84.	Bearing Cap Condition Post Repair	
	Drive End Bearing Cap	Opposite Drive End Bearing Cap

85.	End Bell Air Seal Fits Post Repair	
	Drive End Air Seal	Opposite Drive End Air Seal

86. End Bell Repair Sign-off

Assembly

87. Photograph All Major Components prior to assembly
88. Final Insulation Resistance Test
89. Assembled Shaft Endplay
90. Assembled Shaft Runout

91.	Test Run Voltage		
	Volts	Volts	Volts

92.	Test Run Amperage		
	Amps	Amps	Amps

93.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial

94.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial

95. Ambient Temperature - Fahrenheit

96.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes

97.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes

98. Final Test Run Sign-off

100. Final Pics and QC Review **Terrence Holland**