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: 100621
FormID: 15343513

AC Recondition - Rev. 2

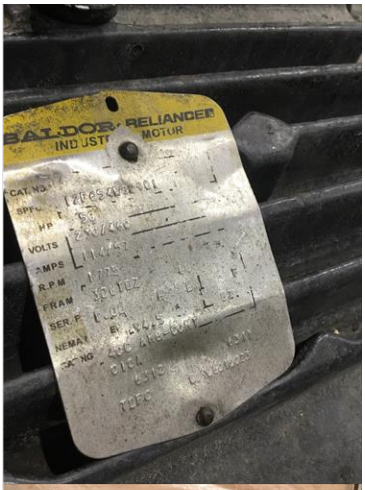
Location:	MOTOR SHOP LR
Serial Number:	C0906010023
Description:	50HP BALDOR 1800RPM 326TDZ

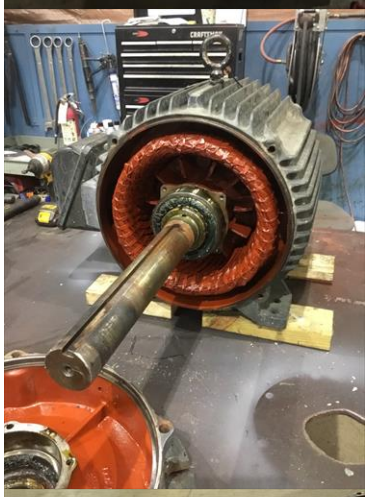
Hi-Speed Job Number:	100621
Manufacturer:	Baldor
Product Number:	12F654W829G1
Spec/ID #:	12F654W829G1
Serial Number:	C0906010023
HP/kW:	50 (HP)
RPM:	1775 (RPM)
Frame:	326TDZ
Voltage:	230 / 460
Current:	114/57
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

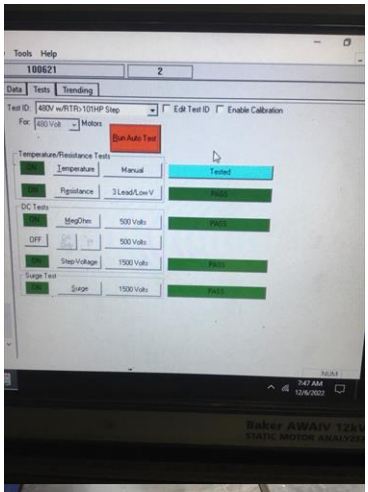
Priorities Found: **1 - High** **7 - Good**

Overall Condition

1. Report Date
2. Nameplate Picture P20







	3.	Photos of all six sides of the machine.	
	4.	Describe the Overall Condition of the Equipment as Received ***Dirty***	
Initial Mechanical/Electrical			
●	5.	Does Shaft Turn Freely?	**(Yes) Yes**
	6.	Does Shaft Have Visible Damage?	**(No) No**
	7.	Assembled Shaft Runout	
	8.	Assembled Shaft End Play	
	9.	Air Gap Variation <10%	
●	10.	Lead Condition	**(P) Pass**
	11.	Lead Length	**8 Inches**

12.	Frame Condition	**pass**	
13.	Fan Condition	**(P) Pass**	P54

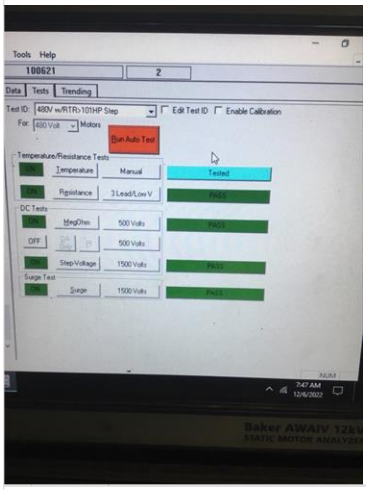
14.	Broken or Missing Components	**two j-box bolts**	

Initial Electrical Inspection

15.	Insulation Resistance/Megger		
16.	Winding Resistance		

1-2	1-3	2-3

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



18.	Number of Stator Slots	**Megohms**
19.	Stator Condition	**pass**

Mechanical Inspection

20.	Drive End Bearing Number-	**6312**
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?	**na**
25.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**na**
26.	Drive End Bearing Condition	**worn**
27.	Opposite Drive End Bearing Number-	**6311**
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	**worn**
34.	Drive End Seal	**inprobe**
35.	Opposite Drive End Seal	**inprobe**

Rotor Inspection

36.	Rotor Type/Material	**(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast**
37.	Growler Test	**(Pass) Pass**
38.	Number of Rotor Bars	**40**
39.	Rotor Condition	**pass**
40.	List the Parts needed for the Repair Below ***6312*** ***6311*** ***Bearing fit sleeve for ODE end bell***	
41.	Signature of Technician that Disassembled Motor	**Cw**

Mechanical Fits- Rotor

42.	Shaft Runout	**0.004 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

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

2.3626x3

47.	Drive End Bearing Shaft Fit Condition	**(P) Pass**
48.	Opposite Drive End Bearing Shaft Fit	

0 Degrees	60 Degrees	120 Degrees

2.1657x3

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

51190x2
5.1189

52. Drive End - Endbell Bearing Fit Condition **(P) Pass**

53. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees

Egg shaped

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

55. Bearing Cap Condition P30

Drive End Bearing Cap	Opposite Drive End Bearing Cap

Pass

56. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

57. List Machine Work Needed Below

ODE end bell bearing fit

58. Technician **Cw**

Dynamic Balance Report

59. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade

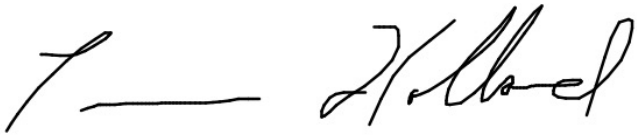
60. Initial Balance Readings

Drive End	Opposite Drive End

61. Final Balance Readings

Drive End	Opposite Drive End

62. Technician **Terrence Holland**



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

70. Technician

Root Cause of Failure

71. Failure locations

Bearings and ODE end bell bearing fit

72. Root cause of failure

Wear

Mechanical Fits- Rotor - Post Repair

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

Mechanical Fits- Bearing Housings - Post Repair

81. Drive End - Endbell Bearing Fit Post Repair

0 Degrees	60 Degrees	120 Degrees

82. Opposite Drive End - Endbell Bearing Fit Post Repair P100

0 Degrees	60 Degrees	120 Degrees
4.725	**4.725**	**4.725**

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

Assembly

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

90.	Test Run Voltage		
	Volts	Volts	Volts
91.	Test Run Amperage		
	Amps	Amps	Amps
92.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
93.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
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		
98.	Document Final Condition with Pictures after paint		
99.	Final Pics and QC Review		P2300