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: 100844
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AC Recondition - Rev. 2

Location:	MOTOR SHOP LR
Serial Number:	C0906200018
Description:	50HP Baldor 1800RPM 326TDZ

Hi-Speed Job Number:	99797
Manufacturer:	Baldor
Product Number:	12F654W829G1
Spec/ID #:	12F654W829G1
Serial Number:	C0906200018
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
Date Received:	05/13/2022
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **2 - High** **6 - Good**

Overall Condition

1. Report Date

2. Nameplate Picture P37

3. Photos of all six sides of the machine. P45

	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?	**(Yes) Yes** P20

	7.	Assembled Shaft Runout	
	8.	Assembled Shaft End Play	
	9.	Air Gap Variation <10%	
●	10.	Lead Condition	**(P) Pass**
	11.	Lead Length	**6 Inches**
	12.	Frame Condition	**pass**

13.	Fan Condition	**(P) Pass**	P89

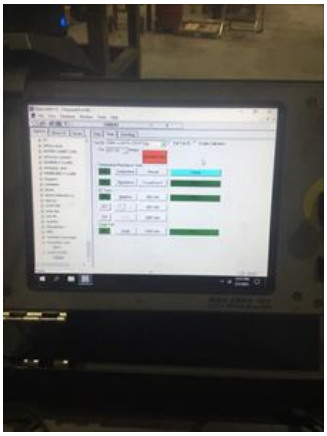
14.	Broken or Missing Components	

Initial Electrical Inspection

15.	Insulation Resistance/Megger	
16.	Winding Resistance	

1-2	1-3	2-3

17.	Perform Surge Test	**(P) Pass**	P55



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

Mechanical Inspection

20.	Drive End Bearing Number-	**6312**	P12

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?	**none**	
25.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**	
26.	Drive End Bearing Condition	**worn**	
27.	Opposite Drive End Bearing Number-	**6311**	P81

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**	P87

31.	Opposite Drive End Bearing Insulation or Grounding Device?	**none**	
32.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**yes**	P92

33.	Opposite Drive End Bearing Condition	**replace**	
34.	Drive End Seal	**in pro seal**	
35.	Opposite Drive End Seal	**In pro 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				
40.	List the Parts needed for the Repair Below				
41.	Signature of Technician that Disassembled Motor				

Mechanical Fits- Rotor

42.	Shaft Runout			**0.022 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		

Excessive wear.

47.	Drive End Bearing Shaft Fit Condition		**(F) Fail**	P75

Bearing came off by hand

48.	Opposite Drive End Bearing Shaft Fit				
	0 Degrees	60 Degrees	120 Degrees		
	2.166	**2.166**	**2.166**		
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		

Bad Lip worn in.

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

53. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
4.725	**4.7249**	**4.7251**

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

55. Bearing Cap Condition

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

D.E shaft bent .022. D.E. housing fit has lip worn in. D.E. Shaft bearing journal worn out of tolerance.

58. Technician **Terrence Holland**

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

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

72. Root cause of failure

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

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

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		