



QualiTest® Diagnostics

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The following is a summary of findings from the December 2019 monthly vibration survey at the USG Greenville, MS Plant. Please let us know if there are any questions or comments.

QualiTest® uses a four step rating system for defects.

Class I: Defect is present, but effect on reliability is not clear; no immediate action is required. Continue to normally monitor.

Class II: Defect (s) present that may cause problem in long term (2-6 months). Repair during normal maintenance scheduling. Continue to monitor.

Class III: Defect (s) present that may cause failure in short term (less than 2 months). This should be addressed as soon as practical, with a high maintenance priority. Increase monitoring frequency.

Class IV: Defect (s) present that makes continued reliability unpredictable, and possibility of secondary damage is high. Repairs should be made ASAP. An unscheduled shutdown should be considered for repairs

Hi-Speed Industrial Service tests and inspects industrial machinery and equipment and makes recommendations concerning maintenance and repairs based on its experience in the field of industrial repair and maintenance. The information contained herein is provided as an opinion only, not as a guaranty or warranty of the matters discussed herein.

Defects

Perlite

#7 Combustion Blower

Spectral data still shows some looseness/wear in the ODE blower bearing. DE bearing has a high 2 x rpm vibration which may due to looseness/wear also. There may be some sheave/belts issues such as wear or misalignment that could also be causing the 2 x rpm vibration. Inspect unit for these issues as time allows. Rated as a **CLASS II** defect.

#5 Expander Dust Collector

High 1 x rpm vibration indicates imbalance of the fan wheel. **Fan wheel needs to be inspected and cleaned soon.** Rated as a **CLASS II** defect.

#6 Expander Dust Collector

1 x fan rpm vibration remains above low alarm limit. This is most likely due to a combination of imbalance and deteriorated grout around the fan base. Inspect and clean fan wheel. Base needs to be re-grouted in the near future. Rated as a **CLASS II** defect.

#7 Expander Dust Collector

Data still shows high fan rpm vibration in the fan bearings. This is due to some imbalance of the fan wheel. **Fan wheel needs to be inspected and cleaned soon.** Rated as a **CLASS III** defect.

#8 Expander Dust Collector

High 1 x rpm vibration indicates imbalance of the fan wheel. **Fan wheel needs to be inspected and cleaned soon.** Drive end fan bearing data also shows possible bearing looseness. Inspect fan bearings for excessive axial movement and perform a lift check of the shaft (belts should be loose while performing the lift check). Rated as a **CLASS III** defect.

Hydropulper

Vibration data of the gearbox shows some gear mesh vibration along with input speed harmonics. Previous oil reports have also shown some metal contents which further indicates internal wear of the gearbox components. Unit should be inspected for wear as scheduling allows. Rated as a **CLASS II** defect.

Mix-up/Reclaim

Dump Chest Agitator

Motor still has a significant increase in 2 x rpm motor axial vibration since replacing the motor. This is a strong indication of angular misalignment. Coupling may also have issue. **Inspect coupling and re-align motor ASAP.** Rated as a **CLASS III** defect.

Starch Blower

The high pressure blower still has an extreme amount of acceleration throughout the blower. There are several high amplitude harmonics of blower rpm present as well. This is a good indication of internal wear of the blower. It is recommend replacing the blower in the near future due to the high acceleration. Rated as a **CLASS II** defect.

Beater (Broke) Agitator

Agitator bearings are showing signs of wear. Rated as a **CLASS II** defect for now.

#1 White Water Loop Pump

Motor vibration data shows defects are present in the motor bearings and vibration is getting worse. Pump is also showing some signs of bearing wear as well. **Motor will need attention soon.** Rated as a **CLASS III** defect.

Ultra-Sorter Screen

Screen bearings are showing signs of wear. Bearings may need to be replaced in the near future. We will continue to monitor this issue closely. Rated as a **CLASS II** defect.

Board Line 3

#2 Top Press Roll Drive

Motor data shows possible defects of the motor bearings. It is recommended to inspect the motor bearings for defects/wear soon. Electrical fluting of the bearing races may be present. Rated as a **CLASS III** defect.

Board Line Main Drive

Motor has a significant increase in 1 x rpm vibration this survey. Motor sheave may be the issue. Inspect sheave/belt and sheave alignment SOON. Rated as a **CLASS II** defect.

#1 Former White Water Pit Pump

Vibration spectra of the motor signs of bearing defects of the drive end bearing. Inspect motor as scheduling allows. Rated as a **CLASS II** defect.

#2 Former White Water Pit Pump

Equipment was not in service this month; however, the following still applies: Motor is showing some signs of bearing defects in the spectral data. We will monitor this closely. Rated as a **CLASS II** defect.

Vacuum Pump #2

Motor has a higher than normal 1 x motor rpm vibration. This is likely due to the motor base not being secured properly to the concrete base. Motor base needs to be anchored properly. Rated as a **CLASS II** defect.

Low Vacuum Fan

Motor axial is higher than usual. Data suggests misalignment of the sheaves. Sheaves should be checked for offset and angular misalignment. Ensure sheaves are not worn and that the belts are in good order as well. Rated as a **CLASS II** defect.

Wet End Combustion Blower

Blower bearings are starting to trend upward on defect frequency vibration. Acceleration has also increased. These are signs of bearing defects/wear. Bearings should be scheduled for replacement in the near future. Rated as a **CLASS II** defect for now.

Finishing

#1 Grinder Baghouse Dust Collector

Vibration has increased in the fan bearings. Fan data still shows some imbalance. Fan wheel may still have some build up or fan wheel may need to be balanced. Clean fan ASAP. Rated as a **CLASS II** defect.

#3 Grinder Baghouse Dust Collector

Vibration has increased in the fan bearings. Fan data still shows some imbalance. Fan wheel may still have some build up or fan wheel may need to be balanced. Inspect and clean fan soon. Fan bearings also show some looseness. Check bearing clearances also especially the outboard bearing. Rated as a **CLASS III** defect.

Kiln Lube Oil Pump

The pump is showing signs of wear. Impacting can be seen in the vibration data along with pump vane harmonics. We will monitor this closely. Rated as a **CLASS II** defect.

Blue Oven 1 Zone 1 Circulation Fan 1

Vibration data indicates that the fan is out of balance. It is recommended to inspect the fan wheel for build-up and damage. Ensure sheaves are aligned properly and belts are in good shape and properly tightened. Rated as a **CLASS II** defect.

Blue Oven 1 Zone 1 Circulation Fan 2

Vibration data of the fan bearing indicates bearing faults more so in the bottom fan bearing. It is recommended to replace fan bearings as scheduling allows. Rated as a **CLASS II** defect.

Blue Oven 1 Exhaust Fan

Data shows imbalance of the fan. Fan shaft may also be bent. Sheaves misalignment may also influence this vibration. Sheaves should be checked for misalignment and wear and perform a field balance of the fan. Rated as a **CLASS II** defect.

Blue Oven 1 Zone 2 Circulation Fan 1

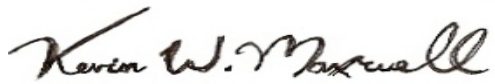
Motor and fan vibration remains high. Vibration is at fan speed in the motor and fan. This may be due to build-up on the fan. Inspect fan wheel for build- up and damage ASAP. Highest amplitude is at the fan inboard horizontal measured at 1.4 ips-pk. Inspect sheaves and belts as well. Rated as a **CLASS III** defect.

Blue Oven 1 Zone 2 Circulation Fan 2

Motor and fan vibration remains high. Vibration is at fan speed in the motor and fan. This may be due to build-up on the fan. Inspect fan wheel for build- up and damage ASAP. Highest amplitude is at the motor inboard axial measured at 1.0 ips-pk. Inspect sheaves and belts as well Rated as a **CLASS III** defect.

As always, it has been a pleasure to serve USG Greenville, MS. If there are any comments or questions, do not hesitate to contact us.

Sincerely,

A handwritten signature in black ink that reads "Kevin W. Maxwell". The signature is fluid and cursive, with the first name "Kevin" and last name "Maxwell" clearly legible.

ISO Certified Vibration Analyst, Category III



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