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: 100910
FormID: 15980259

AC Recondition - Rev. 2

Location:	MOTOR SHOP LR
Serial Number:	08068245

Description:2.5HP MIDWESTERN SHAKER 1200RPM

Hi-Speed Job Number:	100910
Manufacturer:	Other
Product Number:	VB12-2510
Serial Number:	08068245
HP/kW:	2.5 (HP)
RPM:	1200 (RPM)
Voltage:	230 / 460
Current:	8.2/4.1
Phase:	Three
Hz:	60 (Hz)
Enclosure:	TENV
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: **3 - High** **1 - Good**

Overall Condition

1. Report Date

2. Nameplate Picture P37

3. Photos of all six sides of the machine. P44

	4.	Describe the Overall Condition of the Equipment as Received ***Dirty but serviceable.***	P55

	5.	Distance from the end of the shaft to the Coupling/Sheave	
Initial Mechanical/Electrical			
🔴	6.	Does Shaft Turn Freely?	**(No) No**
	7.	Does Shaft Have Visible Damage?	
	8.	Assembled Shaft Runout	
	9.	Assembled Shaft End Play	
	10.	Air Gap Variation <10%	
🟢	11.	Lead Condition	**(P) Pass**
	12.	Lead Length	**44 Inches**

13.	Stator Temperature Detector Rating and Function			
	Quantity	Rating	Quantity Passed	
14.	Bearing Temperature Detector Rating and Function			
	Quantity	Rating	Quantity Passed	
15.	Frame Condition			
16.	Fan Condition		**(N) NA**	
17.	Heater Quantity, Ratings			
	Quantity	Volts/Watts	Pass/Fail	
18.	Broken or Missing Components			
Initial Electrical Inspection				
19.	Insulation Resistance/Megger			
20.	Winding Resistance			
	1-2	1-3	2-3	
21.	Perform Surge Test			
22.	Number of Stator Slots			
23.	Stator Condition			
Mechanical Inspection				
24.	Drive End Bearing Brand		**Fag**	P16

25.	Drive End Bearing Number-	**NJ2314-E-XL-TVP2-QP51-C4**
26.	Drive End Bearing Qty.	**1**
27.	Drive End Bearing Type	**(Spherical) Spherical Roller Bearing**
28.	Drive End Lubrication Type	**(Grease) Grease Lubricated**
29.	Drive End Bearing Insulation or Grounding Device?	**none**
30.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**snap ring**
31.	Drive End Bearing Condition	**replace**
32.	Opposite Drive End Bearing Brand	**FAG**

33.	Opposite Drive End Bearing Number-	**NJ312-E-XL-TVP2-QP51-C4**	P96

34.	Opposite Drive End Bearing Qty.	**1**
35.	Opposite Drive End Bearing Type	**(Roller) Roller Bearing**
36.	Opposite Drive End Lubrication Type	**(Grease) Grease Lubricated**
37.	Opposite Drive End Bearing Insulation or Grounding Device?	**none**
38.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**snap ring**
39.	Opposite Drive End Bearing Condition	**replace**
40.	Drive End Seal	
41.	Opposite Drive End Seal	

42. DE Sleeve Bearing Inside Diameter

0 degrees	120 degrees	240 degrees

43. DE Sleeve Bearing Outside Diameter

0 degrees	120 degrees	240 degrees

44. DE Sleeve Bearing Housing Inside Diameter

0 degrees	120 degrees	240 degrees

45. DE Sleeve Bearing to Housing Clearance

0 degrees	120 degrees	240 degrees

46. ODE Sleeve Bearing Inside Diameter

0 degrees	120 degrees	240 degrees

47. ODE Sleeve Bearing Outside Diameter

0 degrees	120 degrees	240 degrees

48. ODE Sleeve Bearing Housing Inside Diameter

0 degrees	120 degrees	240 degrees

49. ODE Sleeve Bearing to Housing Clearance

0 degrees	120 degrees	240 degrees

Rotor Inspection

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

51.	Growler Test	**(Pass) Pass**
52.	Number of Rotor Bars	
53.	Rotor Condition	**pass**
54.	List the Parts needed for the Repair Below	
	Both key ways wallowed. Both seal surfaces worn. Both housing fits need re-sleeved.	
55.	Signature of Technician that Disassembled Motor	**Terrence Holland**

Mechanical Fits- Rotor

56. Shaft Runout

57. Rotor Runout

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

58. Coupling Fit Closest to Bearing Housing

0 Degrees	90 Degrees	120 Degrees

59. Coupling Fit Closest to the end of the Shaft

0 Degrees	60 Degrees	120 Degrees

60. Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees

61. Drive End Bearing Shaft Fit Condition

62. Opposite Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees

63. Opposite Drive End Bearing Shaft Fit Condition

64. Shaft Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

65. Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees

Excessive wear.

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

Excessive wear. Re-sleeve

67. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees

Excessive wear.

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

Resleeve housing fit.-

69. Bearing Cap Condition

Drive End Bearing Cap	Opposite Drive End Bearing Cap

70. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

71. List Machine Work Needed Below P67

Both key ways wallowed. Both housing fits bad. Both seal surfaces bad on screw side of rotor

72. Technician **Terrence Holland**

Dynamic Balance Report

73. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade

74. Initial Balance Readings

Drive End	Opposite Drive End

75. Final Balance Readings

Drive End	Opposite Drive End

76. Technician

Rewind

77. Core Test Results - Watts loss per Pound

Pre-Burnout	Post Burnout

78. Core Hot Spot Test

Pre-Burnout	Post-Burnout

79. Post Rewind Electrical Test- Insulation Resistance

80. Post Rewind Polarization Index

81. Post Rewind Winding Resistance

1-2	1-3	2-3

82. Post Rewind Surge Test

83. Post Rewind Hi-Pot

84. Technician

Root Cause of Failure

85. Failure locations

86. Root cause of failure

Mechanical Fits- Rotor - Post Repair

87. Shaft Runout Post Repair

88. Rotor Runout Post Repair

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

89. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees	90 Degrees	120 Degrees

90. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees	60 Degrees	120 Degrees

91. Drive End Bearing Shaft Fit Post Repair

0 Degrees	60 Degrees	120 Degrees

92. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees	60 Degrees	120 Degrees

93. Shaft Air Seal Fits Post Repair

Drive End Air Seal	Opposite Drive End Air Seal

94. Shaft Repair Sign-off

Mechanical Fits- Bearing Housings - Post Repair

95. Drive End - Endbell Bearing Fit Post Repair

0 Degrees	60 Degrees	120 Degrees

96. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees	60 Degrees	120 Degrees

97. Bearing Cap Condition Post Repair

Drive End Bearing Cap	Opposite Drive End Bearing Cap

98. End Bell Air Seal Fits Post Repair

Drive End Air Seal	Opposite Drive End Air Seal

99. DE Sleeve Bearing Inside ID Post Repair

Measure 1	Measure 2	Measure 3

100. DE Sleeve Bearing Outside ID Post Repair

Measure 1	Measure 2	Measure 3

101. DE Sleeve Bearing Inside OD Post Repair

Measure 1	Measure 2	Measure 3

102. DE Sleeve Bearing Outside OD Post Repair

Measure 1	Measure 2	Measure 3

103. End Bell Repair Sign-off

104.	ODE Sleeve Bearing Inside ID Post Repair		
	Measure 1	Measure 2	Measure 3
105.	ODE Sleeve Bearing Outside ID Post Repair		
	Measure 1	Measure 2	Measure 3
106.	ODE Sleeve Bearing Inside OD Post Repair		
	Measure 1	Measure 2	Measure 3
107.	ODE Sleeve Bearing Outside OD Post Repair		
	Measure 1	Measure 2	Measure 3

Assembly

108.	QC Check All Parts for Cleanliness Prior to Assembly		
109.	Photograph All Major Components prior to assembly		
110.	Final Insulation Resistance Test		
111.	Assembled Shaft Endplay		
112.	Assembled Shaft Runout		
113.	Test Run Voltage		
	Volts	Volts	Volts
114.	Test Run Amperage		
	Amps	Amps	Amps
115.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
116.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
117.	Ambient Temperature - Fahrenheit		
118.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
119.	Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
	20 Minutes	25 Minutes	30 Minutes
120.	Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
	35 Minutes	40 Minutes	45 Minutes
121.	Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
	50 Minutes	55 Minutes	60 Minutes
122.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes

123.	Opposite Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
	20 Minutes	25 Minutes	30 Minutes
124.	Opposite Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
	35 Minutes	40 Minutes	45 Minutes
125.	Opposite Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
	50 Minutes	55 Minutes	60 Minutes
126.	Stator Temperatures- Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
127.	Stator Temperatures- Fahrenheit 20-30 Minutes		
	20 Minutes	25 Minutes	30 Minutes
128.	Stator Temperatures- Fahrenheit 35-45 Minutes		
	35 Minutes	40 Minutes	45 Minutes
129.	Stator Temperatures- Fahrenheit 50-60 Minutes		
	50 Minutes	55 Minutes	60 Minutes
130.	Document Final Condition with Pictures after paint		
131.	Final Pics and QC Review		