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: 101101
FormID: 16242892

AC Recondition - Rev. 2

Location:	MOTOR SHOP LR
Serial Number:	C2103100532
Description:	25HP BALDOR 1800RPM 284T

Hi-Speed Job Number:	101101
Manufacturer:	Baldor
Product Number:	10-0000-0086
Spec/ID #:	10-0000-0086
Serial Number:	C2103100532
HP/kW:	25 (HP)
RPM:	1775 (RPM)
Frame:	284T
Voltage:	230 / 460
Current:	62/31
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: **3 - High** **5 - 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?	**(No) No**	
●	7.	Assembled Shaft Runout	**0.007 Inches**	
	8.	Assembled Shaft End Play		
	9.	Air Gap Variation <10%		
●	10.	Lead Condition	**(P) Pass**	P54

	11.	Lead Length		
	12.	Frame Condition	**pass**	

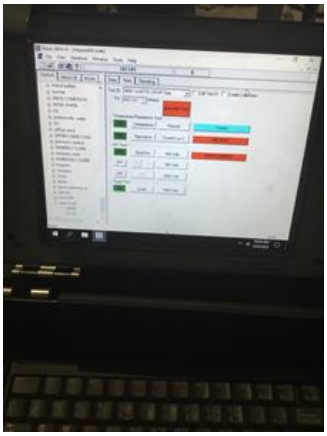
13.	Fan Condition	**(N) NA**	
14.	Broken or Missing Components		

Initial Electrical Inspection

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

1-2	1-3	2-3

17.	Perform Surge Test	**(F) Fail**	P57



18.	Number of Stator Slots		
19.	Stator Condition	**water logged**	P68

Mechanical Inspection

20.	Drive End Bearing Brand	**fag**

21.	Drive End Bearing Number-	**6311 2rs**	P32

22.	Drive End Bearing Qty.	**1**	
23.	Drive End Bearing Type	**(Ball) Ball Bearing**	P50

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 Brand	**nachi**	
29.	Opposite Drive End Bearing Number-	**6309**	P86

30.	Opposite Drive End Bearing Qty.	**1**	
31.	Opposite Drive End Bearing Type	**(Ball) Ball Bearing**	P90

32.	Opposite Drive End Lubrication Type	**(Grease) Grease Lubricated**	
33.	Opposite Drive End Bearing Insulation or Grounding Device?	**none**	
34.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**wavy washer**	P96

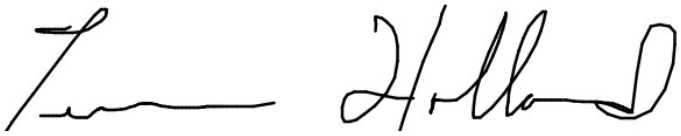
35.	Opposite Drive End Bearing Condition	**replace**	
36.	Drive End Seal	**in pro**	P98

37.	Opposite Drive End Seal	**none**	

Rotor Inspection

38. Rotor Type/Material P3

39.	Growler Test	
40.	Number of Rotor Bars	
41.	Rotor Condition	**shaft bent .007**
42.	List the Parts needed for the Repair Below ***Shaft bent .007 re-sleeve ode housing fit.***	
43.	Signature of Technician that Disassembled Motor	**Terrence Holland**



Mechanical Fits- Rotor

44.	Shaft Runout			**0.007 inches**
45.	Rotor Runout			
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
46.	Coupling Fit Closest to Bearing Housing			
	0 Degrees	90 Degrees	120 Degrees	
47.	Coupling Fit Closest to the end of the Shaft			
	0 Degrees	60 Degrees	120 Degrees	
48.	Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	2.1663	**2.1661**	**2.1662**	
49.	Drive End Bearing Shaft Fit Condition			**(P) Pass**
50.	Opposite Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	1.7725	**1.7723**	**1.7725**	
51.	Opposite Drive End Bearing Shaft Fit Condition			**(P) Pass**
52.	Shaft Air Seal Fits			
	Drive End Air Seal	Opposite Drive End Air Seal		

Mechanical Fits- Bearing Housings

53. Drive End - Endbell Bearing Fit

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

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

55. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
3.9382		

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

Lip worn in.

57. Bearing Cap Condition P51

Drive End Bearing Cap	Opposite Drive End Bearing Cap
pass	

58. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

59. List Machine Work Needed Below

ODE housing fit. Shaft bent .007

60. Technician **Terrence Holland**

Dynamic Balance Report

61. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade

62. Initial Balance Readings

Drive End	Opposite Drive End

63. Final Balance Readings

Drive End	Opposite Drive End

64. Technician

Rewind

65.	Core Test Results - Watts loss per Pound		
	Pre-Burnout	Post Burnout	
66.	Core Hot Spot Test		
	Pre-Burnout	Post-Burnout	
67.	Post Rewind Electrical Test- Insulation Resistance		
68.	Post Rewind Polarization Index		
69.	Post Rewind Winding Resistance		
	1-2	1-3	2-3
70.	Post Rewind Surge Test		
71.	Post Rewind Hi-Pot		
72.	Technician		
Root Cause of Failure			
73.	Failure locations		
74.	Root cause of failure		
Mechanical Fits- Rotor - Post Repair			
75.	Shaft Runout Post Repair		
76.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
77.	Coupling Fit Closest to Bearing Housing Post Repair		
	0 Degrees	90 Degrees	120 Degrees
78.	Coupling Fit Closest to the end of the Shaft Post Repair		
	0 Degrees	60 Degrees	120 Degrees
79.	Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
80.	Opposite Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
81.	Shaft Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
82.	Shaft Repair Sign-off		
Mechanical Fits- Bearing Housings - Post Repair			
83.	Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
84.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees

85.	Bearing Cap Condition Post Repair		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
86.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
87.	End Bell Repair Sign-off		
Assembly			
88.	QC Check All Parts for Cleanliness Prior to Assembly		
89.	Photograph All Major Components prior to assembly		
90.	Final Insulation Resistance Test		
91.	Assembled Shaft Endplay		
92.	Assembled Shaft Runout		
93.	Test Run Voltage		
	Volts	Volts	Volts
94.	Test Run Amperage		
	Amps	Amps	Amps
95.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
96.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
97.	Ambient Temperature - Fahrenheit		
98.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
99.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
100.	Document Final Condition with Pictures after paint		
101.	Final Pics and QC Review		