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

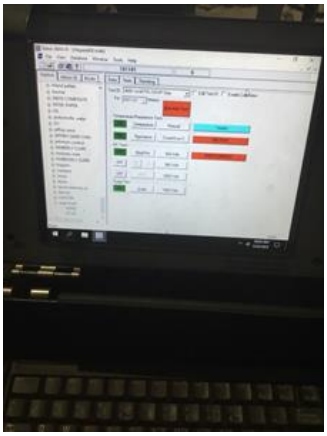
	4.	Describe the Overall Condition of the Equipment as Received ***Serviceable***	
Initial Mechanical/Electrical			
	5.	Does Shaft Turn Freely?	**(Yes) Yes**
	6.	Does Shaft Have Visible Damage?	**(No) No**
	7.	Assembled Shaft Runout	**0.007 Inches**
	8.	Assembled Shaft End Play	
	9.	Air Gap Variation <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

39. Growler Test

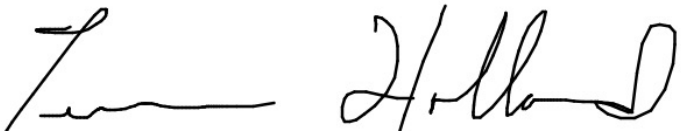
40. Number of Rotor Bars

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

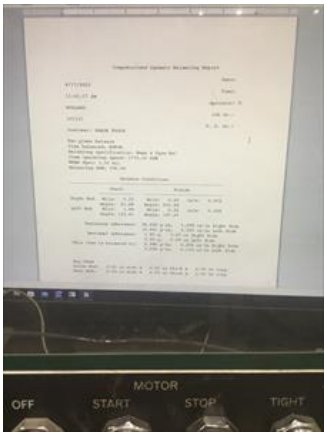
Rotor Weight	Balance Grade

62. Initial Balance Readings

Drive End	Opposite Drive End

63. Final Balance Readings

Drive End	Opposite Drive End



64. Technician **Terrence. Holland**

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 **0.001 inches** P10

Welded output shaft ,machined and cut keyway.

76. Rotor Runout Post Repair

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0.003	**0.002**	**0.003**

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 **Gary**

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 P20

0 Degrees	60 Degrees	120 Degrees
3.9376	**3.9376**	**3.9376**

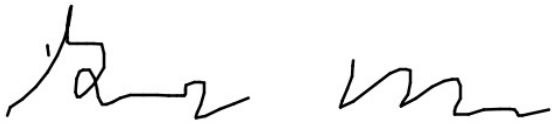
85. Bearing Cap Condition Post Repair

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 **Gary**

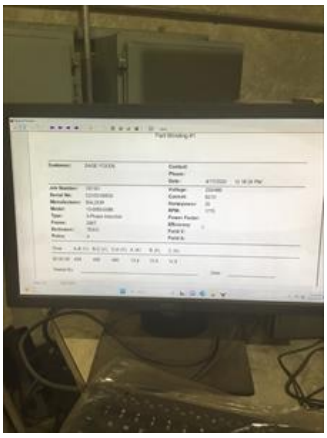


Assembly

88. QC Check All Parts for Cleanliness Prior to Assembly

89. Photograph All Major Components prior to assembly P17

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			P100



101. Final Pics and QC Review **Terrence. Holland** P101