Hi-Speed Industrial Service
7030 Ryburn Dr
Millington, Tn 38053
901-873-5300

AC Inspection as Found

MKT FASTENING LLC
1 GUNNEBO DR`
LONOKE, AR 72086

FolderID: 101188
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AC Inspection - Rev. 2

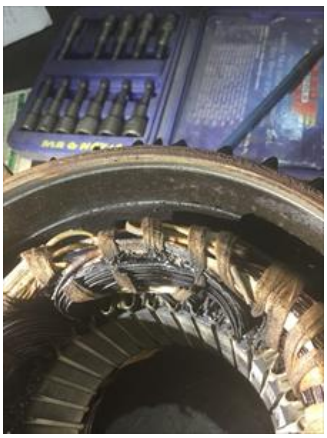
Location:	Shop
Serial Number:	F494

Hi-Speed Job Number:	99584
Manufacturer:	Baldor
Product Number:	35E110-74
Serial Number:	F494
HP/kW:	1 (HP)
RPM:	1725 (RPM)
Voltage:	220-240
Current:	6.6
Phase:	Single
Hz:	60 (Hz)
Enclosure:	DP
Date Received:	03/30/2022
Repair Stage:	Teardown Inspection
Rewind:	No
Shaft Machined Fit Repairs Required:	No

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

Overall Condition

1. Report Date
2. Nameplate Picture P20



3.	Photos of all six sides of the machine.		
4.	Describe the Overall Condition of the Equipment as Received		
5.	Distance from the end of the shaft to the Coupling/Sheave		

Initial Mechanical/Electrical

6.	Does Shaft Turn Freely?	**(Yes) Yes**	
7.	Does Shaft Have Visible Damage?	**(No) No**	
8.	Assembled Shaft Runout	**Inches**	
9.	Assembled Shaft End Play		
10.	Air Gap Variation <10%		
11.	Lead Condition	**(P) Pass**	
12.	Lead Length	**8 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	**pass**	
16.	Fan Condition	**(P) Pass**	P68

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	**(F) Fail**	P32

Attached brake assembly tested good.

22.	Number of Stator Slots	
23.	Stator Condition	**rewind**
24.	Stator Thermistors/Ohms	
25.	Stator Overloads/Ohms	

Mechanical Inspection

26.	Drive End Bearing Brand	**ntn**	
27.	Drive End Bearing Number-		P16

28.	Drive End Bearing Qty.	**1**
29.	Drive End Bearing Type	**(Ball) Ball Bearing**
30.	Drive End Lubrication Type	**(Grease) Grease Lubricated**
31.	Drive End Bearing Insulation or Grounding Device?	**none**
32.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**
33.	Drive End Bearing Condition	**replace**

34.	Opposite Drive End Bearing Brand	**nachi**	P57

35.	Opposite Drive End Bearing Number-	**6205**	P61

36.	Opposite Drive End Bearing Qty.	**1**	
37.	Opposite Drive End Bearing Type	**(Ball) Ball Bearing**	
38.	Opposite Drive End Lubrication Type	**(Grease) Grease Lubricated**	
39.	Opposite Drive End Bearing Insulation or Grounding Device?	**none**	
40.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**wavy washer**	P73

41.	Opposite Drive End Bearing Condition	**replace**	
42.	Drive End Seal	**dust seal**	P75

43.	Opposite Drive End Seal			**none**
44.	DE Sleeve Bearing Inside Diameter			
	0 degrees	120 degrees	240 degrees	
45.	DE Sleeve Bearing Outside Diameter			
	0 degrees	120 degrees	240 degrees	
46.	DE Sleeve Bearing Housing Inside Diameter			
	0 degrees	120 degrees	240 degrees	
47.	DE Sleeve Bearing to Housing Clearance			
	0 degrees	120 degrees	240 degrees	
48.	ODE Sleeve Bearing Inside Diameter			
	0 degrees	120 degrees	240 degrees	
49.	ODE Sleeve Bearing Outside Diameter			
	0 degrees	120 degrees	240 degrees	
50.	ODE Sleeve Bearing Housing Inside Diameter			
	0 degrees	120 degrees	240 degrees	
51.	ODE Sleeve Bearing to Housing Clearance			
	0 degrees	120 degrees	240 degrees	

Rotor Inspection

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

53.	Growler Test	**(Pass) Pass**
54.	Number of Rotor Bars	
55.	Rotor Condition	**pass**
56.	List the Parts needed for the Repair Below ***205 sleeve for D.E housing fit***	
57.	Signature of Technician that Disassembled Motor	**Terrence Holland**

Mechanical Fits- Rotor

58.	Shaft Runout	**0.001 inches**
59.	Rotor Runout	

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

60. Coupling Fit Closest to Bearing Housing

0 Degrees	90 Degrees	120 Degrees

61. Coupling Fit Closest to the end of the Shaft

0 Degrees	60 Degrees	120 Degrees

62. Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
0.9847	**0.9846**	**0.9846**

63.	Drive End Bearing Shaft Fit Condition	**(P) Pass**
64.	Opposite Drive End Bearing Shaft Fit	

0 Degrees	60 Degrees	120 Degrees
0.9846	**0.9846**	**0.9846**

65.	Opposite Drive End Bearing Shaft Fit Condition	**(P) Pass**
66.	Shaft Air Seal Fits	

Drive End Air Seal	Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

67. Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
2.0482	**2.0484**	**2.0483**

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

69. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
2.0475	**2.0474**	**2.0475**

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

71. Bearing Cap Condition

Drive End Bearing Cap	Opposite Drive End Bearing Cap

72. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

73. List Machine Work Needed Below

D.E housing fit bad.

74. Technician **Terrence Holland**

Root Cause of Failure

75. Failure locations

76. Root cause of failure

Mechanical Fits- Bearing Housings - Post Repair

77. DE Sleeve Bearing Inside ID Post Repair

Measure 1	Measure 2	Measure 3

78. DE Sleeve Bearing Outside ID Post Repair

Measure 1	Measure 2	Measure 3

79. DE Sleeve Bearing Inside OD Post Repair

Measure 1	Measure 2	Measure 3

80. DE Sleeve Bearing Outside OD Post Repair

Measure 1	Measure 2	Measure 3

81. ODE Sleeve Bearing Inside ID Post Repair

Measure 1	Measure 2	Measure 3

82. ODE Sleeve Bearing Outside ID Post Repair

Measure 1	Measure 2	Measure 3

83.	ODE Sleeve Bearing Inside OD Post Repair		
	Measure 1	Measure 2	Measure 3
84.	ODE Sleeve Bearing Outside OD Post Repair		
	Measure 1	Measure 2	Measure 3