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

AC Inspection as Found

Sage V Foods
5901 SLOAN DRIVE
LITTLE ROCK, AR 72206

FolderID: 101633
FormID: 17363892

AC Inspection - Rev. 2

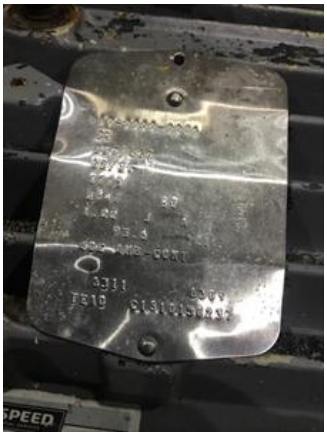
Location:	MOTOR SHOP LR
Serial Number:	
Description:	25 HP BROKEN SHAFT

Hi-Speed Job Number:	101633
Manufacturer:	Baldor
Serial Number:	C1810130237
HP/kW:	25 (HP)
RPM:	1775 (RPM)
Frame:	284T
Voltage:	230 / 460
Current:	62/31
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
J-box Included:	Half
Coupling/Sheave:	None
Date Received:	07/19/2023
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Shaft Machined Fit Repairs Required:	Yes
Heaters:	No
Bearing Type:	Rolling Element

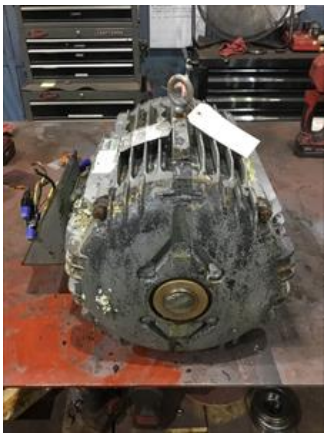
Priorities Found: **5 - Good**

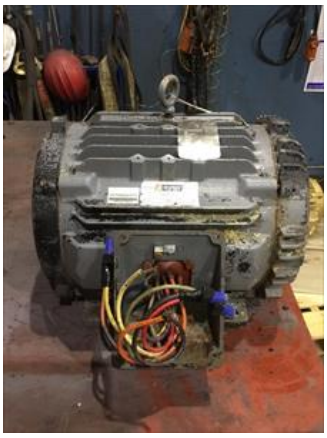
Overall Condition

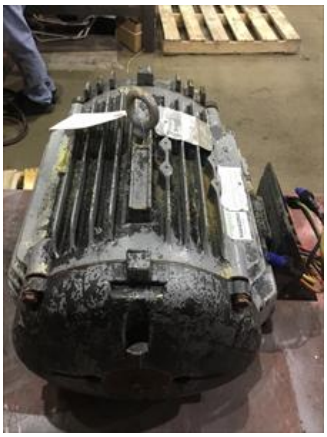
1. Report Date
2. Nameplate Picture P37

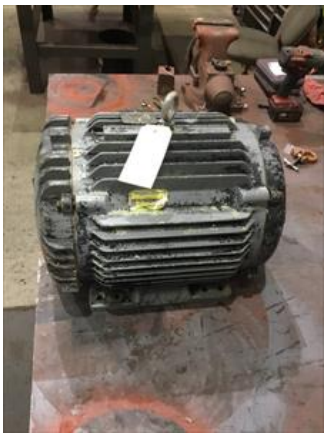


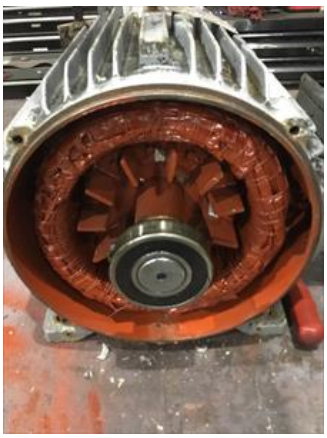
3. Photos of all six sides of the machine. P45

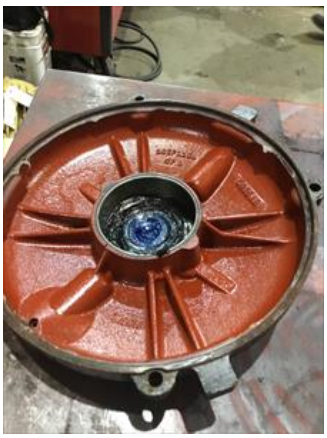


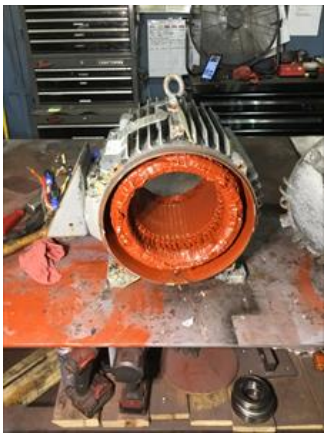


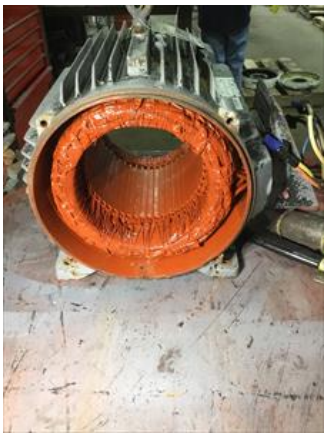


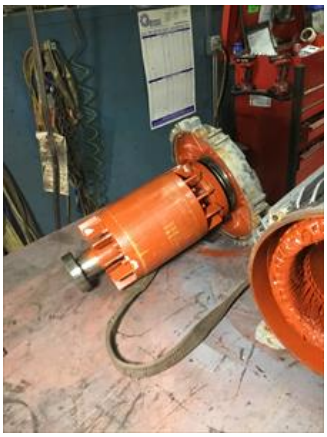


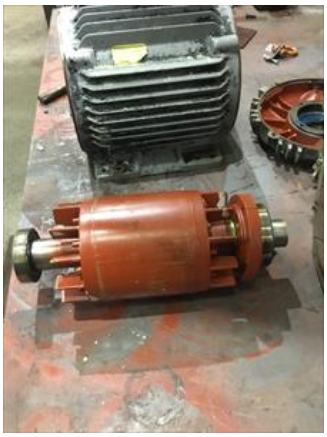


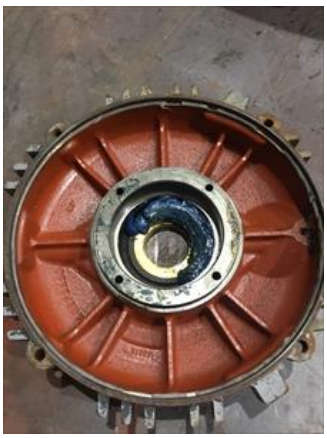










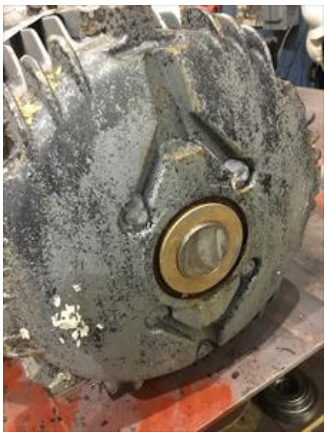


4. Describe the Overall Condition of the Equipment as Received P54

D.E. shaft broken off.

Initial Mechanical/Electrical

●	5.	Does Shaft Turn Freely?	**(Yes) Yes**	
	6.	Does Shaft Have Visible Damage?	**(Yes) Yes**	P20
		Broken off.		

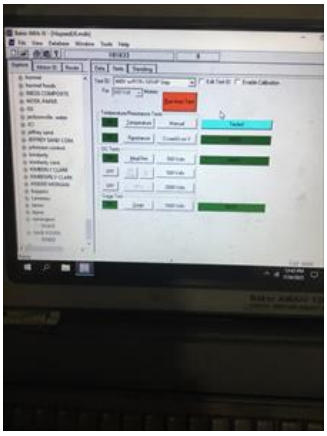


7.	Assembled Shaft Runout	**Inches**	
8.	Assembled Shaft End Play	**inches**	
9.	Air Gap Variation <10%		
● 10.	Lead Condition	**(P) Pass**	
11.	Lead Length	**9 Inches**	
12.	Lead Numbers	**1-9**	
13.	Frame Condition	**pass**	
14.	Fan Condition	**(N) NA**	
15.	Broken or Missing Components	**D.E. shaft**	

Initial Electrical Inspection

16.	Insulation Resistance/Megger			
17.	Winding Resistance			
	1-2	1-3	2-3	

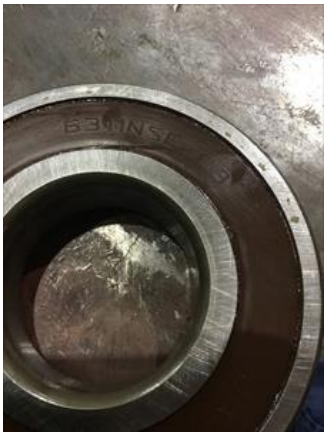
18.	Perform Surge Test	**(P) Pass**	P58



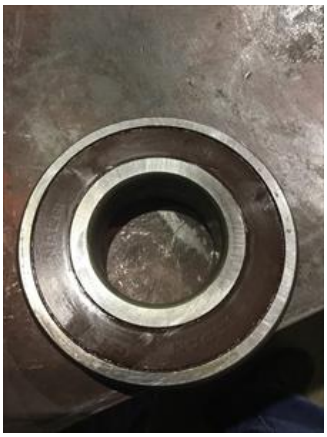
19.	Number of Stator Slots	**48 Megohms**	
20.	Stator Condition	**pass**	
21.	Stator Thermistors/Ohms	**none**	
22.	Stator Overloads/Ohms	**none**	

Mechanical Inspection

23.	Drive End Bearing Brand	**Nachi**	
24.	Drive End Bearing Number-	**6311 NSE**	P29

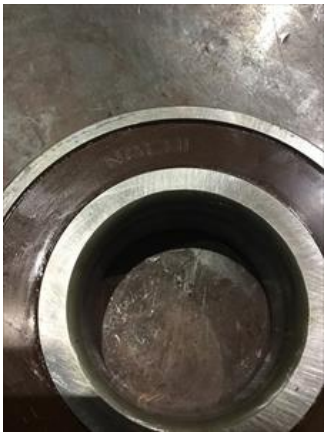


25.	Drive End Bearing Qty.	**1**	
26.	Drive End Bearing Type	**(Ball) Ball Bearing**	P52

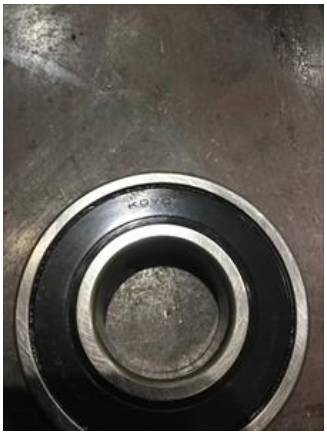


27.	Drive End Lubrication Type	**(Grease) Grease Lubricated**

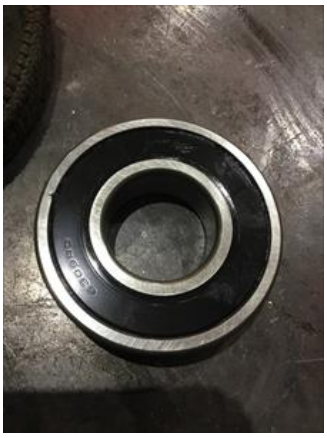
28.	Drive End Bearing Insulation or Grounding Device?	**none**	
29.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**	
30.	Drive End Bearing Condition	**replace**	P82



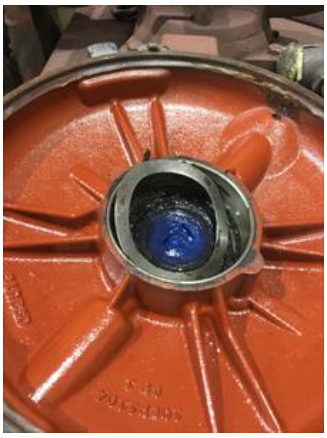
31.	Opposite Drive End Bearing Brand	**koyo**	P91



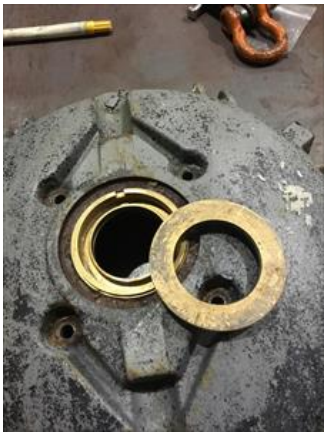
32.	Opposite Drive End Bearing Number-	**6309 2RS**	
33.	Opposite Drive End Bearing Qty.	**1**	
34.	Opposite Drive End Bearing Type	**(Ball) Ball Bearing**	P102



35.	Opposite Drive End Lubrication Type	**(Grease) Grease Lubricated**	
36.	Opposite Drive End Bearing Insulation or Grounding Device?	**none**	
37.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**wavy washer**	P113



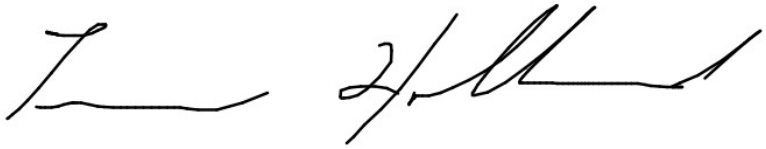
38.	Opposite Drive End Bearing Condition	**replace**	
39.	Drive End Seal	**in pro**	P117



40.	Opposite Drive End Seal	**none**	

Rotor Inspection

41.	Rotor Type/Material	**(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast**	
42.	Growler Test	**(Pass) Pass**	
43.	Number of Rotor Bars	**40**	
44.	Rotor Condition	**shaft replacement needed**	
45.	List the Parts needed for the Repair Below ***New shaft, and new in pro seal.***		
46.	Signature of Technician that Disassembled Motor	**Terrence Holland**	



Mechanical Fits- Rotor

47.	Shaft Runout	**inches**	
	Shaft broken off		
48.	Rotor Runout		

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

49. Coupling Fit Closest to Bearing Housing

0 Degrees	90 Degrees	120 Degrees

50. Coupling Fit Closest to the end of the Shaft

0 Degrees	60 Degrees	120 Degrees

51. Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees

New shaft needed

52. Drive End Bearing Shaft Fit Condition

53. Opposite Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees

54. Opposite Drive End Bearing Shaft Fit Condition

New shaft needed

55. Shaft Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

56. Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
4.7246	**4.7246**	**4.7247**

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

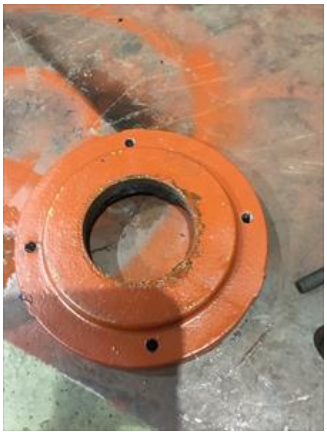
58. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
3.9373	**3.9373**	**3.9374**

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

60. Bearing Cap Condition P51

Drive End Bearing Cap	Opposite Drive End Bearing Cap
pass	



61. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

62. List Machine Work Needed Below

63. Technician **Terrence Holland**

Dynamic Balance Report

64. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade

65. Initial Balance Readings

Drive End	Opposite Drive End

66. Final Balance Readings

Drive End	Opposite Drive End

67. Technician

Rewind

68. Core Test Results - Watts loss per Pound

Pre-Burnout	Post Burnout

69. Core Hot Spot Test

Pre-Burnout	Post-Burnout

70. Post Rewind Electrical Test- Insulation Resistance

71. Post Rewind Polarization Index

72. Post Rewind Winding Resistance

1-2	1-3	2-3

73. Post Rewind Surge Test

74. Post Rewind Hi-Pot

75. Technician

Root Cause of Failure

76. Failure locations

77. Root cause of failure

Mechanical Fits- Rotor - Post Repair

78. Shaft Runout Post Repair

79. Rotor Runout Post Repair

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

80. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees	90 Degrees	120 Degrees

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

0 Degrees	60 Degrees	120 Degrees

82.	Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
83.	Opposite Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
84.	Shaft Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
85.	Shaft Repair Sign-off		
Mechanical Fits- Bearing Housings - Post Repair			
86.	Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
87.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
88.	Bearing Cap Condition Post Repair		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
89.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
90.	End Bell Repair Sign-off		
Assembly			
91.	QC Check All Parts for Cleanliness Prior to Assembly		
92.	Photograph All Major Components prior to assembly		
93.	Final Insulation Resistance Test		
94.	Assembled Shaft Endplay		
95.	Assembled Shaft Runout		
96.	Test Run Voltage		
	Volts	Volts	Volts
97.	Test Run Amperage		
	Amps	Amps	Amps
98.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
99.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
100.	Ambient Temperature - Fahrenheit		
101.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes

102.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
103.	Stator Temperatures- Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
104.	Document Final Condition with Pictures after paint		
105.	Final Pics and QC Review		