



**KEEPING YOUR FACILITY UP TO SPEED**  
— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 101486**

Prepared for Baldor Warranty Division

685 Mid America Blvd  
Hot Springs AR 71913

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AC Inspection as Found - *MOTOR SHOP LR*

AC Inspection - Rev. 2: *C2008250912*

**1.0**

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## AC Inspection as Found

### Baldor Warranty Division

685 Mid America Blvd  
Hot Springs, AR 71913

FolderID: 101486  
FormID: 17006195

#### AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number: C2008250912

Description: 50HP BALDOR 1800RPM 326T

Hi-Speed Job Number: 101486

Manufacturer: Baldor

Product Number: YT50869-11

Spec/ID #: 12G236Y141G1

Serial Number: C2008250912

HP/kW: 50 (HP)

RPM: 1775 (RPM)

Frame: 326T

Voltage: 230 / 460

Current: 116/58

Phase: Three

Hz: 60 (Hz)

Service Factor: 1.15

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:  4 - High

#### Overall Condition

1. Report Date
2. Nameplate Picture



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3. Photos of all six sides of the machine.





4. Describe the Overall Condition of the Equipment as Received

*Dirty*

#### Initial Mechanical/Electrical

|                                  |                                    |         |
|----------------------------------|------------------------------------|---------|
| <input checked="" type="radio"/> | 5. Does Shaft Turn Freely?         | (No) No |
| <input type="radio"/>            | 6. Does Shaft Have Visible Damage? |         |
| <input type="radio"/>            | 7. Assembled Shaft Runout          |         |
| <input type="radio"/>            | 8. Assembled Shaft End Play        |         |
| <input type="radio"/>            | 9. Air Gap Variation <10%          |         |

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|  |     |     |   |
|--|-----|-----|---|
| 10. Lead Condition   |     |     |   |
| 11. Lead Length  |     |     |   |
| 12. Frame Condition  |     |     |   |
| 13. Fan Condition  |     |     |   |
| 14. Broken or Missing Components                                     |     |     | na  |
| <b>Initial Electrical Inspection</b>                                 |     |     |   |
| 15. Insulation Resistance/Megger                                     |     |     |   |
| 16. Winding Resistance   |     |     |   |
| 1-2  | 1-3 | 2-3 |   |
|  |     |     |   |
| 17. Perform Surge Test   |     |     | (NA) Not Applicable                                 |
| 17. Windings blown   |     |     |   |
| 18. Number of Stator Slots   |     |     |   |
| 19. Stator Condition   |     |     |   |
| 20. Stator Thermistors/Ohms  |     |     |   |
| 21. Stator Overloads/Ohms  |     |     |   |
| <b>Mechanical Inspection</b>   |     |     |   |
| 22. Drive End Bearing Brand  |     |     |   |
| 23. Drive End Bearing Number-  |     |     |   |
| 24. Drive End Bearing Qty.   |     |     |   |
| 25. Drive End Bearing Type   |     |     |   |
| 26. Drive End Lubrication Type                                       |     |     |   |
| 27. Drive End Bearing Insulation or Grounding Device?                |     |     |   |
| 28. Drive End Wavy Washer/Snap-Ring Other Retention Device?          |     |     |   |
| 29. Drive End Bearing Condition                                      |     |     | signs of contamination and axial load               |
| 30. Opposite Drive End Bearing Brand                                 |     |     |   |
| 31. Opposite Drive End Bearing Number-                               |     |     |   |
| 32. Opposite Drive End Bearing Qty.                                  |     |     |   |
| 33. Opposite Drive End Bearing Type                                  |     |     |   |
| 34. Opposite Drive End Lubrication Type                              |     |     |   |
| 35. Opposite Drive End Bearing Insulation or Grounding Device?       |     |     |   |
| 36. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? |     |     |   |
| 37. Opposite Drive End Bearing Condition                             |     |     | signs of axial load                                 |
| 38. Drive End Seal   |     |     |   |
| 39. Opposite Drive End Seal  |     |     |   |
| <b>Rotor Inspection</b>  |     |     |   |
| 40. Rotor Type/Material  |     |     | (Squirrel Aluminum) Squirrel Cage Aluminum Die Cast |
| 41. Growler Test   |     |     |   |
| 42. Number of Rotor Bars   |     |     |   |
| 43. Rotor Condition  |     |     |   |
| 44. List the Parts needed for the Repair Below                       |     |     |   |
| 45. Signature of Technician that Disassembled Motor                  |     |     |   |
| <b>Mechanical Fits- Rotor</b>  |     |     |   |
| 46. Shaft Runout   |     |     |   |



|  |                             |                            |
|--|-----------------------------|----------------------------|
| 47. Rotor Runout                                   |                             |                            |
| Drive End Bearing Fit                              | Rotor Body                  | Opposite Drive End Bearing |
| 48. Coupling Fit Closest to Bearing Housing        |                             |                            |
| 0 Degrees  | 90 Degrees                  | 120 Degrees                |
| 49. Coupling Fit Closest to the end of the Shaft   |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 50. Drive End Bearing Shaft Fit                    |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 51. Drive End Bearing Shaft Fit Condition          |                             |                            |
| 52. Opposite Drive End Bearing Shaft Fit           |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 53. Opposite Drive End Bearing Shaft Fit Condition |                             |                            |
| 54. Shaft Air Seal Fits                            |                             |                            |
| Drive End Air Seal                                 | Opposite Drive End Air Seal |                            |
| <b>Mechanical Fits- Bearing Housings</b>           |                             |                            |
| 55. Drive End - Endbell Bearing Fit                |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 56. Drive End - Endbell Bearing Fit Condition      |                             | <b>(F) Fail</b>            |



|  |                                |             |
|--|--------------------------------|-------------|
| 57. Opposite Drive End - Endbell Bearing Fit           |                                |             |
| 0 Degrees  | 60 Degrees                     | 120 Degrees |
| 58. Opposite Drive End - Endbell Bearing Fit Condition |                                |             |
| 59. Bearing Cap Condition                              |                                |             |
| Drive End Bearing Cap                                  | Opposite Drive End Bearing Cap |             |
| 60. End Bell Air Seal Fits                             |                                |             |
| Drive End Air Seal                                     | Opposite Drive End Air Seal    |             |
| 61. List Machine Work Needed Below                     |                                |             |

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|  |                    |                            |  |
|--|--------------------|----------------------------|--|
| 62. Technician   |                    |                            |  |
| <b>Dynamic Balance Report</b>  |                    |                            |  |
| 63. Rotor Weight and Balance Grade   |                    |                            |  |
| Rotor Weight   | Balance Grade      |                            |  |
|  |                    |                            |  |
| 64. Initial Balance Readings   |                    |                            |  |
| Drive End  | Opposite Drive End |                            |  |
|  |                    |                            |  |
| 65. Final Balance Readings   |                    |                            |  |
| Drive End  | Opposite Drive End |                            |  |
|  |                    |                            |  |
| 66. Technician   |                    |                            |  |
| <b>Rewind</b>  |                    |                            |  |
| 67. Core Test Results - Watts loss per Pound   |                    |                            |  |
| Pre-Burnout  | Post Burnout       |                            |  |
|  |                    |                            |  |
| 68. Core Hot Spot Test   |                    |                            |  |
| Pre-Burnout  | Post-Burnout       |                            |  |
|  |                    |                            |  |
| 69. Post Rewind Electrical Test- Insulation Resistance   |                    |                            |  |
| 70. Post Rewind Polarization Index   |                    |                            |  |
| 71. Post Rewind Winding Resistance   |                    |                            |  |
| 1-2  | 1-3                | 2-3                        |  |
|  |                    |                            |  |
| 72. Post Rewind Surge Test   |                    |                            |  |
| 73. Post Rewind Hi-Pot   |                    |                            |  |
| 74. Technician   |                    |                            |  |
| <b>Root Cause of Failure</b>   |                    |                            |  |
| 75. Failure locations  |                    |                            |  |
| <i>Bearings and DE shaft bearing fit</i>   |                    |                            |  |
| 76. Root cause of failure  |                    |                            |  |
| <i>Motor was under axial load and moisture contamination causing the DE bearing fit to prematurely go down and rotor to drag iron and cause the windings to blow</i> |                    |                            |  |
| <b>Mechanical Fits- Rotor - Post Repair</b>  |                    |                            |  |
| 77. Shaft Runout Post Repair   |                    |                            |  |
| 78. Rotor Runout Post Repair   |                    |                            |  |
| Drive End Bearing Fit  | Rotor Body         | Opposite Drive End Bearing |  |
|  |                    |                            |  |
| 79. Coupling Fit Closest to Bearing Housing Post Repair  |                    |                            |  |
| 0 Degrees  | 90 Degrees         | 120 Degrees                |  |
|  |                    |                            |  |
| 80. Coupling Fit Closest to the end of the Shaft Post Repair   |                    |                            |  |
| 0 Degrees  | 60 Degrees         | 120 Degrees                |  |
|  |                    |                            |  |
| 81. Drive End Bearing Shaft Fit Post Repair  |                    |                            |  |
| 0 Degrees  | 60 Degrees         | 120 Degrees                |  |



|   |                                |             |  |
|---|--------------------------------|-------------|--|
| 82. Opposite Drive End Bearing Shaft Fit Post Repair          |                                |             |  |
| 0 Degrees   | 60 Degrees                     | 120 Degrees |  |
| 83. Shaft Air Seal Fits Post Repair                           |                                |             |  |
| Drive End Air Seal  | Opposite Drive End Air Seal    |             |  |
| 84. Shaft Repair Sign-off                                     |                                |             |  |
| <b>Mechanical Fits- Bearing Housings - Post Repair</b>        |                                |             |  |
| 85. Drive End - Endbell Bearing Fit Post Repair               |                                |             |  |
| 0 Degrees   | 60 Degrees                     | 120 Degrees |  |
| 86. Opposite Drive End - Endbell Bearing Fit Post Repair      |                                |             |  |
| 0 Degrees   | 60 Degrees                     | 120 Degrees |  |
| 87. Bearing Cap Condition Post Repair                         |                                |             |  |
| Drive End Bearing Cap   | Opposite Drive End Bearing Cap |             |  |
| 88. End Bell Air Seal Fits Post Repair                        |                                |             |  |
| Drive End Air Seal  | Opposite Drive End Air Seal    |             |  |
| 89. End Bell Repair Sign-off                                  |                                |             |  |
| <b>Assembly</b>   |                                |             |  |
| 90. QC Check All Parts for Cleanliness Prior to Assembly      |                                |             |  |
| 91. Photograph All Major Components prior to assembly         |                                |             |  |
| 92. Final Insulation Resistance Test                          |                                |             |  |
| 93. Assembled Shaft Endplay                                   |                                |             |  |
| 94. Assembled Shaft Runout                                    |                                |             |  |
| 95. Test Run Voltage  |                                |             |  |
| Volts   | Volts                          | Volts       |  |
| 96. Test Run Amperage   |                                |             |  |
| Amps  | Amps                           | Amps        |  |
| 97. Drive End Vibration Readings - Inches Per Second          |                                |             |  |
| Horizontal  | Vertical                       | Axial       |  |
| 98. Opposite Drive End Vibration Readings - Inches Per Second |                                |             |  |
| Horizontal  | Vertical                       | Axial       |  |
| 99. Ambient Temperature - Fahrenheit                          |                                |             |  |
| 100. Drive End Bearing Temps - Fahrenheit                     |                                |             |  |
| 5 Minutes   | 10 Minutes                     | 15 Minutes  |  |
| 101. Opposite Drive End Bearing Temps - Fahrenheit            |                                |             |  |
| 5 Minutes   | 10 Minutes                     | 15 Minutes  |  |
| 102. Document Final Condition with Pictures after paint       |                                |             |  |
| 103. Final Pics and QC Review                                 |                                |             |  |

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13. **FORCE MAJEURE.** Neither party shall be responsible for any delay or failure in performance of any party of the quotation, purchase order or these Standard Terms and Conditions to the extent that such delays or failures are caused by fire, flood, earthquake, explosion, war, embargo, government requirement, civil or military authority, acts of God, or any other circumstances beyond its reasonable control and not involving any fault or negligence on the party affected ("Condition"). If any such Condition occurs, the party delayed or unable to perform shall promptly give written notice to the other party and, if such Condition remains at the end of thirty (30) days, the party affected by the other party's delay and inability to perform may elect to (i) terminate such order or part thereof, or (ii) suspend the order for the duration of the Condition, if the Buyer is the suspending party, buy elsewhere comparable material to be sold under the order and apply to any commitment the purchase price of such purchase, and resume performance of the order once the Condition ceases, with an option in the affected party to extend the period of this order up to the length of the time the Condition endures.
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