

# LR Motor Shop Repairs

## **Job Number 101933**

Prepared for Sage V Foods

5901 SLOAN DRIVE LITTLE ROCK AR 72206

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AC Inspection as Found - MOTOR SHOP LR

AC Inspection - Rev. 2: E0204805ION-55-11/22

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### **AC Inspection as Found**

Sage V Foods 5901 SLOAN DRIVE LITTLE ROCK, AR 72206

AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Description: 2.5HP SWECO SHAKER MOTOR

E0204805ION-55-11/22

1200RPM 213T

Serial Number:

Hi-Speed Job Number:	101933
Manufacturer:	US Motors/Nidec
Product Number:	FMPC
Serial Number:	E0204805ION-55-11/22
HP/kW:	2.5 (HP)
RPM:	1160 (RPM)
Frame:	213T
Voltage:	460
Current:	4.3
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
Enclosure:	TENV
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: 9 - Good

#### **Overall Condition**

- 1. Report Date
- Nameplate Picture



Photos of all six sides of the machine.



































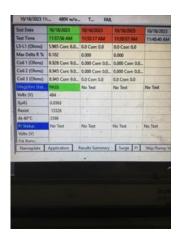






**Initial Electrical Inspection** 

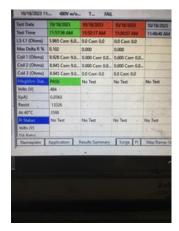




Describe the Overall Condition of the Equipment as Received Dirty **Initial Mechanical/Electrical** Does Shaft Turn Freely? (Yes) Yes Does Shaft Have Visible Damage? (No) No 7. Assembled Shaft Runout 0.003 Millimeters 8. Assembled Shaft End Play inches Air Gap Variation <10% 9. Na 10. Lead Condition (P) Pass 46 Inches 11. Lead Length 12. Lead Numbers 1-3 13. Frame Condition good 14. Fan Condition (N) NA 15. Broken or Missing Components na

#### 16. Insulation Resistance/Megger

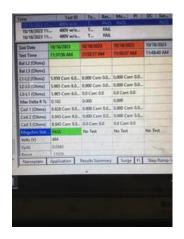
13326 Megohms



#### 17. Winding Resistance

1-2 1-3 2-3

5.959 5.969 5.969



#### 18. Perform Surge Test

(P) Pass



#### 19. Number of Stator Slots

21. Stator Thermistors/Ohms

36

20. Stator Condition

pass

Na

22.	Stator Overloads/Ohms	
-	Na	
Mecha	anical Inspection	
23.	Drive End Bearing Brand	nsk
24.	Drive End Bearing Number-	
-	2313 roller bearing	
25.	Drive End Bearing Qty.	1
26.	Drive End Bearing Type	(Roller) Roller Bearing
27.	Drive End Lubrication Type	(Grease) Grease Lubricated
28.	Drive End Bearing Insulation or Grounding Device?	na
29.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
30.	Drive End Bearing Condition	signs of wear and contamination



nsk	31. Opposite Drive End Bearing Brand
22312	32. Opposite Drive End Bearing Number-
1	33. Opposite Drive End Bearing Qty.
(Spherical) Spherical Roller Bearing	34. Opposite Drive End Bearing Type
(Grease) Grease Lubricated	35. Opposite Drive End Lubrication Type
na	36. Opposite Drive End Bearing Insulation or Grounding Device?
snap ring	37. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?
signs of fluting, frosting, and chemical burn	38. Opposite Drive End Bearing Condition



39.	Drive End Seal	LUP 10319
40.	Opposite Drive End Seal	LUP 10319
Rotor	Inspection	
41.	Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
42.	Growler Test	(Pass) Pass
43.	Number of Rotor Bars	34
44.	Rotor Condition	pass



45. List the Parts needed for the Repair Below

22313 E4-VS4 bearing 2313 EPS bearing LUP 10319 x2

46. Signature of Technician that Disassembled Motor

Cw

#### **Mechanical Fits- Rotor**

IV	Mechanical Fits- Notol			
	47.	Shaft Runout		0.002 millimeters
	48.	Rotor Runout		
		Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
	-	Na		
	49.	Coupling Fit Closest to Bearing Housi	ng	
		0 Degrees	90 Degrees	120 Degrees
	-	Na		
	50.	Coupling Fit Closest to the end of the	Shaft	
		0 Degrees	60 Degrees	120 Degrees
	-	Na		
	51.	Drive End Bearing Shaft Fit		
		0 Degrees	60 Degrees	120 Degrees
		2.559	2.559	2.559
	52.	Drive End Bearing Shaft Fit Condition		(P) Pass

53.	Opposite Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	2.5591	2.5591	2.559	
<b>5</b> 4.	Opposite Drive End Bearing Shaft Fit	Condition		(P) Pass
55.	Shaft Air Seal Fits			
	Drive End Air Seal	Opposite Drive End Air Seal		
-	Na			
Mech	anical Fits- Bearing Housings			
56.	Drive End - Endbell Bearing Fit			
	0 Degrees	60 Degrees	120 Degrees	
	5.5118	5.5118	5.5118	
57.	Drive End - Endbell Bearing Fit Condi	tion		(P) Pass
58.	Opposite Drive End - Endbell Bearing	Fit		
	0 Degrees	60 Degrees	120 Degrees	
	5.5117	5.5118	5.5117	
<b>9</b> 59.	Opposite Drive End - Endbell Bearing	Fit Condition		(P) Pass
60.	Bearing Cap Condition			
	Drive End Bearing Cap	Opposite Drive End Bearing Cap		
-	Pass			





63.	Technician  Ma  Technician	_	Cw
62.	List Machine Work Needed Below		
-	Na		
	Drive End Air Seal	Opposite Drive End Air Seal	
61.	End Bell Air Seal Fits		

**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		
Rewin			
	Core Test Results - Watts loss per Po	und	
00.	Pre-Burnout	Post Burnout	
	FIE-Bulliout	Post Bulliout	
69.	Core Hot Spot Test		
	Pre-Burnout	Post-Burnout	
70.	Post Rewind Electrical Test- Insulation	n 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		
	5. Technician		
Root	oot Cause of Failure		
76.	Failure locations		
	Bearings		
77.	Root cause of failure		
	Contamination, fluting, frosting, and ch	emical burn	
Mecha	anical Fits- Rotor - Post Repair		
78.	Shaft Runout Post Repair		
79.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
00	0 1: 5:01 5 11	D 10 :	
80.	1 0		400 5
	0 Degrees	90 Degrees	120 Degrees
81.	Coupling Fit Closest to the end of the	Shaft Post Repair	
01.	0 Degrees	60 Degrees	120 Degrees
	o Degrees	00 Degrees	120 Degrees
82.	Drive End Bearing Shaft Fit Post Repa	air	
	0 Degrees	60 Degrees	120 Degrees
			<u> </u>
83.	Opposite Drive End Bearing Shaft Fit	Post Repair	
	0 Degrees	60 Degrees	120 Degrees

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84.	Shaft Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
		opposite 2 mile 2 mile oce.	
85.	Shaft Repair Sign-off		
Mecha	anical Fits- Bearing Housings - P	ost Repair	
86.	Drive End - Endbell Bearing Fit Post F	Repair	
	0 Degrees	60 Degrees	120 Degrees
87.	Opposite Drive End - Endbell Bearing	·	
	0 Degrees	60 Degrees	120 Degrees
88	Bearing Cap Condition Post Repair		
00.	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
	21110 Ena 20aming Cap	opposite Brive Eric Boaring Cap	
89.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
	End Bell Repair Sign-off		
Asser			
	QC Check All Parts for Cleanliness P		
	Photograph All Major Components prior to assembly		
	Final Insulation Resistance Test		
	Assembled Shaft Endplay		
	Assembled Shaft Runout		
90.	Test Run Voltage Volts	Volts	Volts
	VOIIS	VOIIS	VOIIS
97.	Test Run Amperage		
	Amps	Amps	Amps
98.	Drive End Vibration Readings - Inches	s Per Second	
	Horizontal	Vertical	Axial
QQ	Opposite Drive End Vibration Reading	rs - Inches Per Second	
33.	Horizontal	Vertical	Axial
	Honzontal	Vertical	ANIAI
100.	Ambient Temperature - Fahrenheit		
101.	Drive End Bearing Temps - Fahrenhe	it	
	5 Minutes	10 Minutes	15 Minutes
102.	Opposite Drive End Bearing Temps -		
	5 Minutes	10 Minutes	15 Minutes
102	Document Final Condition with Distur	os after paint	
	Document Final Condition with Picture Final Pics and QC Review	es alter parrit	
104.	Filial Fics alid QC Review		

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