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

AC Inspection as Found

Peco Foods
625 S. Allen Street
Batesville, AR 72501

FolderID: 103525
FormID: 21668673

AC Inspection - Rev. 2

Location:	Shop
Serial Number:	ZJE723C108U04
Description:	25HP TECO 1170RPM

Hi-Speed Job Number:	103525
Manufacturer:	TECO Westinghouse
Product Number:	TYPE: AEUH8R
Serial Number:	ZJE723C108U04
HP/kW:	25 (HP)
RPM:	1180 (RPM)
Frame:	324LPZ
Voltage:	230 / 460
Current:	60.6/30.3 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TEFC
# of Leads:	12
J-box Included:	Half
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	Yes
Shaft Machined Fit Repairs Required:	No
Bearing Housing Machined Fit Repairs Required:	No
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **1 - High** **10 - Good**

Overall Condition

1.	Report Date	**10/09/2024**

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***	
	5.	Report Date [COPY]	**10/09/2024**
Initial Mechanical/Electrical			
	6.	Does Shaft Turn Freely?	**(NA) Not Applicable**
	7.	Does the shaft require T.I.R in Lathe to identify additional repairs?	
●	8.	Does Shaft Have Visible Damage?	
	9.	Assembled Shaft Runout	**Inches**
	10.	Assembled Shaft End Play	**inches**
	11.	Air Gap Variation <10%	
●	12.	Lead Condition	**(P) Pass** P69

	13.	Lead Length	**15 Inches**
●	14.	Does it have Lugs?, If so what is the Stud Size?	**(No) No**
	15.	Lead Numbers	**1-12**
	16.	Frame Condition	**pass**

17.	Fan Condition	**(P) Pass**	P116

18.	Broken or Missing Components	**none**

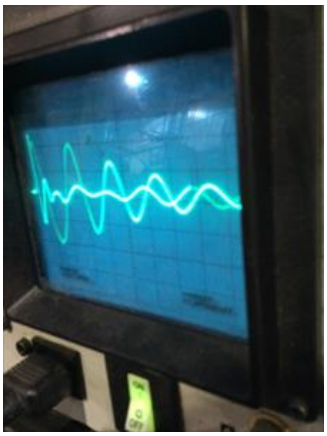
Initial Electrical Inspection

19.	Insulation Resistance/Megger	**0 Megohms**
20.	Winding Resistance	

1-2	1-3	2-3

Na

21.	Perform Surge Test	**(F) Fail**	P57



22.	Number of Stator Slots	**54**
23.	Stator Condition	**rewind** P85

24.	Stator Thermistors/Ohms		
25.	Stator Overloads/Ohms		

Mechanical Inspection

26.	Drive End Bearing Brand	**SKF**	
27.	Drive End Bearing Number-	**7313**	P32

28.	Drive End Bearing Qty.	**2**	
29.	Drive End Bearing Type	**(Thrust) Thrust**	
30.	Drive End Lubrication Type	**(Grease) Grease Lubricated**	
31.	Drive End Bearing Insulation or Grounding Device?	**na**	
32.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**spanner nut**	
33.	Drive End Bearing Condition	**normal wear**	P83

34.	Opposite Drive End Bearing Brand	**NSK**	

35.	Opposite Drive End Bearing Number-	**6212**	P100

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?	**NA**
40.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**Na**
41.	Opposite Drive End Bearing Condition	P119

Debris in bearing grease

42.	Drive End Seal	**yes 60-82-12**	P121

43.	Opposite Drive End Seal

Na

Rotor Inspection

44.	Rotor Type/Material	**(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast**	P3

45.	Growler Test	**(Pass) Pass**	
46.	Number of Rotor Bars	**40**	
47.	Rotor Condition	**pass**	P41

48. List the Parts needed for the Repair Below

2-7313 thrust bearing 1- 6212 C3

49.	Signature of Technician that Disassembled Motor	**RW**	

Mechanical Fits- Rotor

50.	Shaft Runout	**0.008 inches**	
51.	Rotor Runout		

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

Na

52. Coupling Fit Closest to Bearing Housing

0 Degrees	90 Degrees	120 Degrees

Na

53. Coupling Fit Closest to the end of the Shaft

0 Degrees	60 Degrees	120 Degrees

Na

54. Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
2.5597	**2.5597**	**2.5597**

55. Drive End Bearing Shaft Fit Condition **(P) Pass** P81

56. Opposite Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
2.3627	**2.3627**	**2.3627**

57. Opposite Drive End Bearing Shaft Fit Condition **(P) Pass** P96

58. Shaft Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal
pass	**pass**

Mechanical Fits- Bearing Housings

59. Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
5.5122	**5.5122**	**5.5122**

60. Drive End - Endbell Bearing Fit Condition **(P) Pass** P15

61. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
4.3311	**4.3311**	**4.3311**

62. Opposite Drive End - Endbell Bearing Fit Condition **(P) Pass** P39

63. Bearing Cap Condition

Drive End Bearing Cap	Opposite Drive End Bearing Cap
pass	**pass**

64. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

Pass

65. List Machine Work Needed Below

None

66. Technician **RW**

Co sign TRH

Root Cause of Failure

67. Failure locations

Insulation brake down shorting slot

68. Root cause of failure

Bad insulation

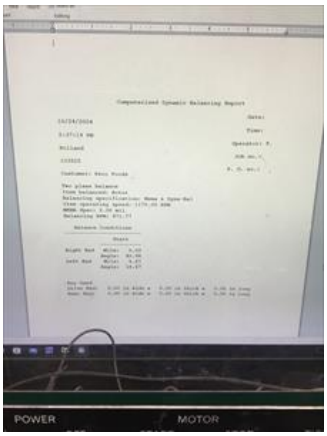
Dynamic Balance Report

69. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade

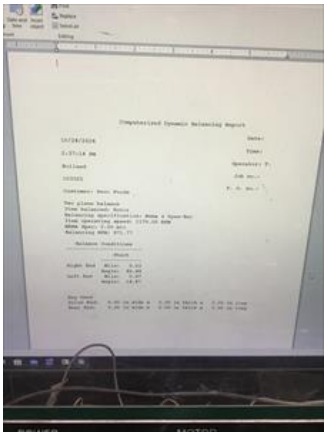
70. Initial Balance Readings P11

Drive End	Opposite Drive End



71. Final Balance Readings P27

Drive End	Opposite Drive End



72. Technician

Rewind

73. Core Test Results - Watts loss per Pound

Pre-Burnout	Post Burnout

74. Core Hot Spot Test

Pre-Burnout	Post-Burnout

75. Post Rewind Electrical Test- Insulation Resistance

76.	Post Rewind Polarization Index		
77.	Post Rewind Winding Resistance		
	1-2	1-3	2-3
78.	Post Rewind Surge Test		
79.	Post Rewind Hi-Pot		
80.	Technician		

Assembly

81. QC Check All Parts for Cleanliness Prior to Assembly **Terrence Holland**

82. Photograph All Major Components prior to assembly **(Complete) Complete** P17

	83.	Final Insulation Resistance Test	**Megohms**	
	84.	Assembled Shaft Endplay	**0 inches**	
●	85.	Assembled Shaft Runout	**0.003 inches**	
	86.	Test Run Voltage		P56

Volts	Volts	Volts
458	**457**	**458**

87. Test Run Amperage

Amps	Amps	Amps
8.4	**8.5**	**8.4**

88. Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial

89. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal	Vertical	Axial

90. Ambient Temperature - Fahrenheit

91. Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes

92. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes	10 Minutes	15 Minutes

93. Document Final Condition with Pictures after paint

94. Final Pics and QC Review **Terrence Holland** P132

Co sign: CW