



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

LR Motor Shop Repairs

**Job Number 102916**

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

**1.0**

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## AC Inspection as Found

Sage V Foods  
5901 SLOAN DRIVE  
LITTLE ROCK, AR 72206

FolderID: 102916  
FormID: 20363517

### AC Inspection - Rev. 2

Location: MOTOR SHOP LR

Serial Number:

Description: 50HP BALDOR 326TDZ FOR EVAL

Hi-Speed Job Number: 102916

Manufacturer: Baldor

HP/kW: 50 (HP)

RPM: 1775 (RPM)

Frame: 326TDZ

Voltage: 230 / 460

Phase: Three

Hz: 60 (Hz)

Enclosure: TEFC

Date Received: 05/13/2024

Repair Stage: Final

Rewind: No

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

- Report Date
- Nameplate Picture

05/28/2024



- Photos of all six sides of the machine.

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|                                      |   |                    |
|--------------------------------------|---|--------------------|
| 4.                                   | Describe the Overall Condition of the Equipment as Received           |                    |
|                                      | <i>Ok</i>   |                    |
| 5.                                   | Distance from the end of the shaft to the Coupling/Sheave             | <b>0 inches</b>    |
| <b>Initial Mechanical/Electrical</b> |   |                    |
| ● 6.                                 | Does Shaft Turn Freely?   | <b>(Y) Yes</b>     |
| ● 7.                                 | Does the shaft require T.I.R in Lathe to identify additional repairs? | <b>(No) No</b>     |
| 8.                                   | Does Shaft Have Visible Damage?                                       | <b>(No) No</b>     |
| ● 9.                                 | Assembled Shaft Runout  | <b>0.03 Inches</b> |
| 10.                                  | Assembled Shaft End Play  | <b>0 inches</b>    |

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|  |             |                 |
|--|-------------|-----------------|
| 11. Air Gap Variation <10%                           | none        |                 |
| 12. Lead Condition                                   | (P) Pass    |                 |
| 13. Lead Length                                      | 12 Inches   |                 |
| 14. Does it have Lugs?, If so what is the Stud Size? | (No) No     |                 |
| 15. Lead Numbers                                     | 1-9         |                 |
| 16. Stator Temperature Detector Rating and Function  |             |                 |
| Quantity   | Rating      | Quantity Passed |
| 0  |             |                 |
| 17. Bearing Temperature Detector Rating and Function |             |                 |
| Quantity   | Rating      | Quantity Passed |
| 0  |             |                 |
| 18. Frame Condition                                  | good        |                 |
| 19. Fan Condition                                    | (P) Pass    |                 |
| 20. Broken or Missing Components                     | none        |                 |
| Initial Electrical Inspection                        |             |                 |
| 21. Insulation Resistance/Megger                     | 200 Megohms |                 |
| 22. Winding Resistance                               |             |                 |
| 1-2  | 1-3         | 2-3             |
| .649   | .649        | .649            |
| 23. Perform Surge Test                               | (P) Pass    |                 |
| 24. Number of Stator Slots                           | 48          |                 |
| 25. Stator Condition                                 | good        |                 |
| 26. Stator Thermistors/Ohms                          | none        |                 |
| 27. Stator Overloads/Ohms                            | 0           |                 |
| Mechanical Inspection                                |             |                 |
| 28. Drive End Bearing Brand                          | Peer        |                 |



|   |                              |
|---|------------------------------|
| 29. Drive End Bearing Number-                               | 6312 2RS                     |
| 30. Drive End Bearing Qty.                                  | 1                            |
| 31. Drive End Bearing Type                                  | (Ball) Ball Bearing          |
| 32. Drive End Lubrication Type                              | (Grease) Grease Lubricated   |
| 33. Drive End Bearing Insulation or Grounding Device?       | no                           |
| 34. Drive End Wavy Washer/Snap-Ring Other Retention Device? | spanner nut and locking ring |
| 35. Drive End Bearing Condition                             | normal                       |
| 36. Opposite Drive End Bearing Brand                        | Peer                         |

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|   |  |                            |
|---|--|----------------------------|
| 37. Opposite Drive End Bearing Number-  | 6311 2RS   |                            |
| 38. Opposite Drive End Bearing Qty.   | 1  |                            |
| 39. Opposite Drive End Bearing Type   | (Ball) Ball Bearing                                    |                            |
| 40. Opposite Drive End Lubrication Type   | (Grease) Grease Lubricated                             |                            |
| 41. Opposite Drive End Bearing Insulation or Grounding Device?                    | none   |                            |
| 42. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?              | wavy   |                            |
| 43. Opposite Drive End Bearing Condition  | frosting   |                            |
| 44. Drive End Seal  | ok   |                            |
| 45. Opposite Drive End Seal   | ok   |                            |
| <b>Rotor Inspection</b>   |  |                            |
| 46. Rotor Type/Material   | (Squirrel Aluminum) Squirrel<br>Cage Aluminum Die Cast |                            |
| 47. Growler Test  | (Pass) Pass  |                            |
| 48. Number of Rotor Bars  | 44   |                            |
| 49. Rotor Condition   | good   |                            |
| 50. List the Parts needed for the Repair Below                                    | 6312 2RS, 6311 2RS                                     |                            |
| 51. Signature of Technician that Disassembled Motor                               | David Maclin   |                            |
|  |  |                            |
| <b>Mechanical Fits- Rotor</b>   |  |                            |
| 52. Shaft Runout  | 0.03 inches  |                            |
| 53. Rotor Runout  |  |                            |
| Drive End Bearing Fit   | Rotor Body   | Opposite Drive End Bearing |
| 0   | 0  | 0                          |
| 54. Coupling Fit Closest to Bearing Housing                                       |  |                            |
| 0 Degrees   | 90 Degrees   | 120 Degrees                |
| 0   |  |                            |
| 55. Coupling Fit Closest to the end of the Shaft                                  |  |                            |
| 0 Degrees   | 60 Degrees   | 120 Degrees                |
| 0   |  |                            |
| 56. Drive End Bearing Shaft Fit   |  |                            |
| 0 Degrees   | 60 Degrees   | 120 Degrees                |
| 2.3625  | 2.3625   | 2.3625                     |
| 57. Drive End Bearing Shaft Fit Condition   | (P) Pass   |                            |
| 58. Opposite Drive End Bearing Shaft Fit  |  |                            |
| 0 Degrees   | 60 Degrees   | 120 Degrees                |
| 2.1655  | 2.1655   | 2.1655                     |
| 59. Opposite Drive End Bearing Shaft Fit Condition                                | (P) Pass   |                            |
| 60. Shaft Air Seal Fits   |  |                            |
| Drive End Air Seal  | Opposite Drive End Air Seal                            |                            |
| ok  | ok   |                            |
| <b>Mechanical Fits- Bearing Housings</b>  |  |                            |

|   |   |                                |              |
|---|---|--------------------------------|--------------|
| 61.   | Drive End - Endbell Bearing Fit                                   |                                |              |
|   | 0 Degrees   | 60 Degrees                     | 120 Degrees  |
|   | 5.1185  | 5.1185                         | 5.1185       |
| 62.   | Drive End - Endbell Bearing Fit Condition                         |                                | (P) Pass     |
| 63.   | Opposite Drive End - Endbell Bearing Fit                          |                                |              |
|   | 0 Degrees   | 60 Degrees                     | 120 Degrees  |
|   | 4.7248  | 4.7248                         | 4.7248       |
| 64.   | Opposite Drive End - Endbell Bearing Fit Condition                |                                | (P) Pass     |
| 65.   | Bearing Cap Condition   |                                |              |
|   | Drive End Bearing Cap   | Opposite Drive End Bearing Cap |              |
|   | ok  | na                             |              |
| 66.   | End Bell Air Seal Fits  |                                |              |
|   | Drive End Air Seal  | Opposite Drive End Air Seal    |              |
|   | ok  | ok                             |              |
| 67.   | List Machine Work Needed Below<br><i>New shaft (.030" runout)</i> |                                |              |
| 68.   | Technician  |                                | David Maclin |
|  |   |                                |              |
| <b>Root Cause of Failure</b>  |   |                                |              |
| 69.   | Failure locations<br><i>Shaft bent</i>                            |                                |              |
| 70.   | Root cause of failure<br><i>Fan ice likely.</i>                   |                                |              |
| <b>Dynamic Balance Report</b>   |   |                                |              |
| 71.   | Rotor Weight and Balance Grade                                    |                                |              |
|   | Rotor Weight  | Balance Grade                  |              |
| 72.   | Initial Balance Readings  |                                |              |
|   | Drive End   | Opposite Drive End             |              |
| 73.   | Final Balance Readings  |                                |              |
|   | Drive End   | Opposite Drive End             |              |
| 74.   | Technician  |                                |              |
| <b>Assembly</b>   |   |                                |              |
| 75.   | QC Check All Parts for Cleanliness Prior to Assembly              |                                |              |
| 76.   | Photograph All Major Components prior to assembly                 |                                |              |
| 77.   | Final Insulation Resistance Test                                  |                                |              |
| 78.   | Assembled Shaft Endplay   |                                |              |
| 79.   | Assembled Shaft Runout  |                                |              |
| 80.   | Test Run Voltage  |                                |              |
|   | Volts   | Volts                          | Volts        |



|   |            |            |  |
|---|------------|------------|--|
| 81. Test Run Amperage   |            |            |  |
| Amps  | Amps       | Amps       |  |
|   |            |            |  |
| 82. Drive End Vibration Readings - Inches Per Second          |            |            |  |
| Horizontal  | Vertical   | Axial      |  |
|   |            |            |  |
| 83. Opposite Drive End Vibration Readings - Inches Per Second |            |            |  |
| Horizontal  | Vertical   | Axial      |  |
|   |            |            |  |
| 84. Ambient Temperature - Fahrenheit                          |            |            |  |
| 85. Drive End Bearing Temps - Fahrenheit                      |            |            |  |
| 5 Minutes   | 10 Minutes | 15 Minutes |  |
|   |            |            |  |
| 86. Opposite Drive End Bearing Temps - Fahrenheit             |            |            |  |
| 5 Minutes   | 10 Minutes | 15 Minutes |  |
|   |            |            |  |
| 87. Document Final Condition with Pictures after paint        |            |            |  |
| 88. Final Pics and QC Review                                  |            |            |  |



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