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

AC Inspection as Found

Riceland Foods (11100-RLF)
Hwy 79 & N. Park Ave.
Stuttgart, AR 72160

FolderID: 104149
FormID: 23409317

AC Inspection - Rev. 2

Location:	MOTOR SHOP LR
Serial Number:	
Description:	50HP US 1770 RPM

Hi-Speed Job Number:	104149
Manufacturer:	US Motors/Nidec
Spec/ID #:	B097711ER-A1
HP/kW:	50 (HP)
RPM:	1770 (RPM)
Frame:	526T
Voltage:	230 / 460
Current:	116.6/58.3 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
Enclosure:	TE
# of Leads:	3
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	02/13/2025
Bearing RTDs:	No
Stator RTDs:	No
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** **11 - Good**

Overall Condition

1.	Report Date	**02/17/2025**

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***		
Initial Mechanical/Electrical				
	5.	Does Shaft Turn Freely? ***Fan assembly rubbing against dented in fan cover.***	**(N) No**	
	6.	Does the shaft require T.I.R in Lathe to identify additional repairs?		
	7.	Does Shaft Have Visible Damage?	**(No) No**	P26

	8.	Assembled Shaft Runout	**0.001 Inches**	
	9.	Assembled Shaft End Play	**0 inches**	
	10.	Air Gap Variation <10%		

11.	Lead Condition	**(P) Pass**	P69

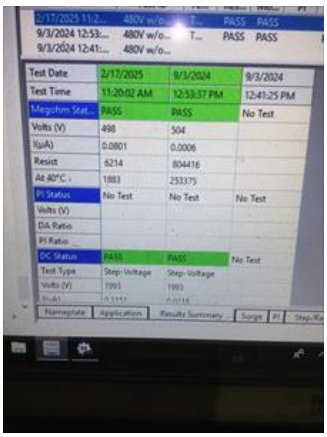
12.	Lead Length	**10 Inches**	
13.	Does it have Lugs?, If so what is the Stud Size?	**(No) No**	
14.	Lead Numbers	**1-3**	
15.	Frame Condition	**pass**	
16.	Fan Condition	**(P) Pass**	P115

17.	Does motor have internal fan?	**(No) No**	
18.	Broken or Missing Components	**none**	

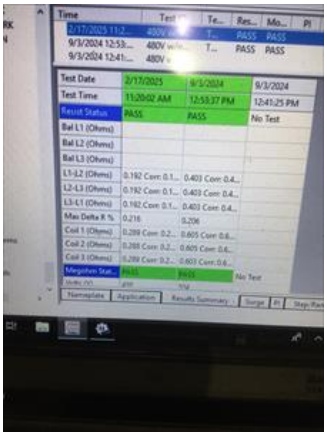
Fan cover is dented but can be straightened.

Initial Electrical Inspection

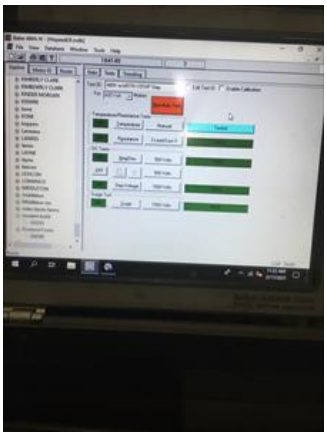
19.	Insulation Resistance/Megger	**Megohms**	P8



20.	Winding Resistance			P20
	1-2	1-3	2-3	



21.	Perform Surge Test	**(P) Pass**	P57



22.	Number of Stator Slots	**48**	
23.	Stator Condition	**pass**	
24.	Stator Thermistors/Ohms		
25.	Stator Overloads/Ohms		

Mechanical Inspection

26.	Drive End Bearing Brand	**MRC**	P12

27.	Drive End Bearing Number-		P32

28.	Drive End Bearing Qty.	**1**	
29.	Drive End Bearing Type	**(Ball) Ball Bearing**	
30.	Drive End Lubrication Type	**(Grease) Grease Lubricated**	
31.	Drive End Bearing Insulation or Grounding Device?	**none**	
32.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**	
33.	Drive End Bearing Condition	**replace**	
34.	Opposite Drive End Bearing Brand	**MRC**	P92

35.	Opposite Drive End Bearing Number-		P99

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?	**none**	
40.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**	
41.	Opposite Drive End Bearing Condition	**replace**	
42.	Drive End Seal	**USEM 344625**	P120

43.	Opposite Drive End Seal	**none**	

Rotor Inspection

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

45.	Growler Test	**(Pass) Pass**	
46.	Number of Rotor Bars	**56**	
47.	Rotor Condition	**pass**	
48.	List the Parts needed for the Repair Below		

211 & 311 2RS bearings
Remove multiple dents from fan cover and replace grease overload tube. Recondition motor

49.	Signature of Technician that Disassembled Motor	**Terrence Holland**	

Mechanical Fits- Rotor

50.	Shaft Runout	**0.001 inches**	

51.	Rotor Runout			
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
52.	Coupling Fit Closest to Bearing Housing			
	0 Degrees	90 Degrees	120 Degrees	
53.	Coupling Fit Closest to the end of the Shaft			
	0 Degrees	60 Degrees	120 Degrees	
	2.1247	**2.1246**	**2.1247**	
54.	Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	2.1655	**2.1654**	**2.1654**	
55.	Drive End Bearing Shaft Fit Condition			**(P) Pass**
56.	Opposite Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	2.1655	**2.1655**	**2.1655**	
57.	Opposite Drive End Bearing Shaft Fit Condition			**(P) Pass**
58.	Shaft Air Seal Fits			
	Drive End Air Seal	Opposite Drive End Air Seal		

Mechanical Fits- Bearing Housings

59.	Drive End - Endbell Bearing Fit			
	0 Degrees	60 Degrees	120 Degrees	
	4.7254	**4.7253**	**4.7254**	
60.	Drive End - Endbell Bearing Fit Condition			**(P) Pass**
61.	Opposite Drive End - Endbell Bearing Fit			
	0 Degrees	60 Degrees	120 Degrees	
	3.9375	**3.9376**	**3.9376**	
62.	Opposite Drive End - Endbell Bearing Fit Condition			**(P) Pass**
63.	Bearing Cap Condition			P52
	Drive End Bearing Cap	Opposite Drive End Bearing Cap		

64.	End Bell Air Seal Fits		
	Drive End Air Seal	Opposite Drive End Air Seal	

65. List Machine Work Needed Below

None

66. Technician **Terrence Holland**

Root Cause of Failure

67. Failure locations

Fan cover

68. Root cause of failure P18

Fan cover was dented inward which allowed the fan to rub against the cover

Dynamic Balance Report

69. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade

70. Initial Balance Readings

Drive End	Opposite Drive End

71. Final Balance Readings

Drive End	Opposite Drive End

72. Technician

Assembly

73. QC Check All Parts for Cleanliness Prior to Assembly
74. Photograph All Major Components prior to assembly
75. Final Insulation Resistance Test
76. Assembled Shaft Endplay
77. Assembled Shaft Runout
78. Test Run Voltage

Volts	Volts	Volts

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