

AC Inspection as Found APPLIED INDUSTRIAL TECHNOLOGY

P.O. BOX 93018 CLEVELAND, OH 44101

Location:	LR MOTOR SHOP
Serial Number:	CZ412111
Description:60 H	P BALDOR

FolderID: 104351 FormID: 23853032

Hi-Speed Job Number:	104351
Manufacturer:	Baldor
Product Number:	12H618Y875G1
Spec/ID #:	ECR9504T
Serial Number:	CZ412111
HP/kW:	60 (HP)
RPM:	1775 (RPM)
Frame:	326T
Voltage:	230 / 460
Current:	122 / 61 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.25
Enclosure:	TEFC
# of Leads:	9
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	03/24/2025
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	Yes
Shaft Machined Fit Repairs Required:	No
Bearing Housing Machined Fit Repairs Required:	Yes
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **3 - High**

gh 🛛 🕘 8 - Good

Overall Condition

1. Report Date

03/27/2025

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2. Nameplate Picture



3. Photos of all six sides of the machine.









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P45







Drive end



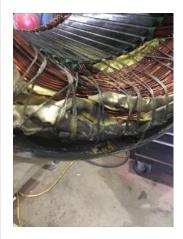




Drive end



Opposite drive end



Rust on opposite drive end.

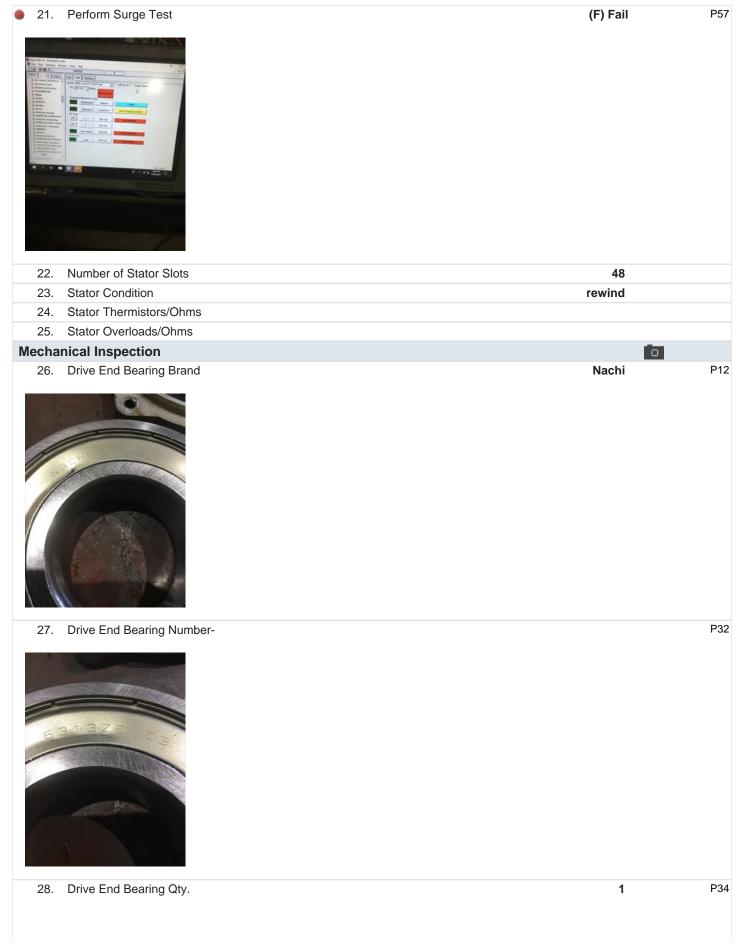


Opposite drive end



	4.	Describe the Overall Condition of the Equipment as Received	
		Serviceable	
Ini	itial I	Mechanical/Electrical	
	5.	Does Shaft Turn Freely?	(N) No
	6.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
	7.	Does Shaft Have Visible Damage?	(No) No
	8.	Assembled Shaft Runout	Inches
	•	Unable to perform due to locked up shaft.	
	9.	Assembled Shaft End Play	0 inches
	10.	Air Gap Variation <10%	

• 11.	Lead Condition			(P) Pass	P69
12.	Lead Length			16 Inches	
13.	Does it have Lugs?, If so what is the	ne Stud Size?		(No) No	
14.	Lead Numbers			1-9	
15. ● 16.	Frame Condition Fan Condition			pass (P) Pass	P115
17.	Does motor have internal fan?			(No) No	
18.	Broken or Missing Components			none	
	Electrical Inspection				D
19.	Insulation Resistance/Megger See item 22.			Megohms	
20.	Winding Resistance				
	1-2	1-3	2-3		
	See item 22				









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	FAG	P92





35. Opposite Drive End Bearing Number-







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?	wavy washer	P114
1	E .		



41.	Opposite Drive End Bearing Condition replace
42.	Drive End Seal
43.	Opposite Drive End Seal
Rotor	Inspection

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6312-B-C3

	44.	Rotor Type/Material		(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast	
	45.	Growler Test		(Pass) Pass	
	46.	Number of Rotor Bars		40	
	47.	Rotor Condition		pass	
	48.	List the Parts needed for the Rep	pair Below		
		(1) 6313 ZE C3 (1) 6312-B-C3			
	49.	Signature of Technician that Disa	assembled Motor	Terrence Holland	
M	echa	nical Fits- Rotor			
	50.	Shaft Runout		0.002 inches	
	51.	Rotor Runout			
		Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
	52.	Coupling Fit Closest to Bearing H	lousing		
		0 Degrees	90 Degrees	120 Degrees	
	53.	Coupling Fit Closest to the end o	f the Shaft		
		0 Degrees	60 Degrees	120 Degrees	
		C .	<u> </u>	C.	
	54.	Drive End Bearing Shaft Fit			
		0 Degrees	60 Degrees	120 Degrees	
		2.5595	2.5594	2.5595	
	55.	Drive End Bearing Shaft Fit Cond	dition	(P) Pass	
	56.	Opposite Drive End Bearing Sha	ft Fit		
		0 Degrees	60 Degrees	120 Degrees	
		2.3624	2.3623	2.3623	
	57.	Opposite Drive End Bearing Sha	ft Fit Condition	(P) Pass	
	58.	Shaft Air Seal Fits			
		Drive End Air Seal	Opposite Drive End Air Seal		
M	echa	nical Fits- Bearing Housings			
	59.	Drive End - Endbell Bearing Fit			
		0 Degrees	60 Degrees	120 Degrees	
		5.5123	5.5122	5.5123	
	60.	Drive End - Endbell Bearing Fit C		(P) Pass	
	61.	Opposite Drive End - Endbell Be	aring Fit		
		0 Degrees	60 Degrees	120 Degrees	
		5.1172	5.1173	5.1175	
	•	Minimum allowed is 5.1181			
	62.	Opposite Drive End - Endbell Be	aring Fit Condition	(F) Fail	

Drive End Bearing Cap Opposite Drive End Bearing Cap pass pass Good Good 64. End Bell Air Seal Fits Drive End Air Seal Opposite Drive End Air Seal 65. List Machine Work Needed Below ODE housing fit measures too small . 008 difference 66. Technician Terrence Holland Impose Seal Impose Seal Impose Seal Co sign : Impose Seal				
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Participant Second	68.	Root cause of failure		P18
69. Rotor Weight and Balance GradeRotor WeightBalance Grade70. Initial Balance Readings70. Initial Balance Readings71. Final Balance Readings71. Final Balance Readings72. Technician		Water seeped inside the stator wi	ndings on the ODE side causing them to sl	hort to ground. See pics below.
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71. Final Balance Readings Drive End 72. Technician	70.			
Drive End Opposite Drive End 72. Technician Composite Drive End		Drive End	Opposite Drive End	
Drive End Opposite Drive End 72. Technician Composite Drive End				
72. Technician	71.			
		Drive End	Opposite Drive End	
Rewind	72.			
		Technician		

73.	Core Test Results - Watts loss per	r Pound		
	Pre-Burnout	Post Burnout		
	The Balliout	r oot Damoat		
74.	Core Hot Spot Test			
	Pre-Burnout	Post-Burnout		
		r oot Banloat		
75.	Post Rewind Electrical Test- Insula	ation 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			
Mechai	nical Fits- Bearing Housings -	Post Repair		
	Drive End - Endbell Bearing Fit Po	-		
	0 Degrees	60 Degrees	120 Degrees	
	5	5	<u> </u>	
82.	Opposite Drive End - Endbell Bea	ring Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees	
83.	Bearing Cap Condition Post Repa	ir		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap		
84.	End Bell Air Seal Fits Post Repair			
	Drive End Air Seal	Opposite Drive End Air Seal		
85.	End Bell Repair Sign-off			
Assem	bly			
86.	QC Check All Parts for Cleanlines	•		
87.	Photograph All Major Components	s prior to assembly		
88.	Final Insulation Resistance Test			
89.	Assembled Shaft Endplay			
90.	Assembled Shaft Runout			
91.	Test Run Voltage			
	Volts	Volts	Volts	
	Test Due Areas			
92.	Test Run Amperage	•		
	Amps	Amps	Amps	
00	Drive End Vibratian Deadings - In	abaa Dar Saaand		
93.	Drive End Vibration Readings - Inc		Avial	
	Horizontal	Vertical	Axial	
0.4	Opposite Drive End Vibration Date	dings Inches Per Second		
94.	Opposite Drive End Vibration Rea	-	Avia	
	Horizontal	Vertical	Axial	

95. Ambient Temperature - Fahrenheit

96.	Drive End Bearing Temps - Fahre	nheit	
	5 Minutes	10 Minutes	15 Minutes
97.	Opposite Drive End Bearing Temp	os - Fahrenheit	
	5 Minutes	10 Minutes	15 Minutes
98.	Document Final Condition with Pie	ctures after paint	
99.	Final Pics and QC Review		