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

AC Recondition Repair Report

FolderID: 98027
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CoorsTek Inc.
3315 Boone Road
Benton, AR 72015

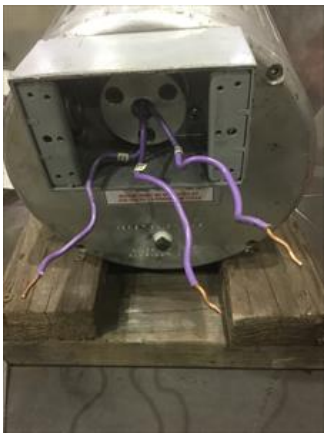
Priorities Found: **2 - High** **13 - Good**

General

1.	Job Number	**98027**
2.	Report Date	**03/30/2021**
3.	Customer	**COORS TEK**

Name Plate Information

4.	Manufacturer	**TEK SPECIALTIES**	P5



5.	Model	**VIGM-5-3450-3-220-60**
6.	Serial Number	**4 2210**
7.	Horsepower	**5**
8.	KW	
9.	Volts	**220**
10.	Amps	
11.	RPM	**3450**
12.	Frame	
13.	Enclosure	**TEFC**
14.	Cycles	**60**
15.	Phase	**3**

	16. Service Factor		
	17. Motor Mount Position		
Initial Inspection			
	18. Number of Leads	**3**	
	19. Lead Length	**6 Inches**	
	20. Lead Size		
●	21. Lead Condition	**(P) Pass**	
	22. Lead Markings	**1-3**	
	23. Lug Size, Condition, and Type		
	24. Winding RTD's		
	25. Winding Rtd's Condition		
	26. Shaft Run Out	**0.001**	
	27. Does Shaft Turn Freely	**no**	
	28. Does Shaft Have Visible Damage	**no**	
	29. Bearing Rtd's		
	30. Bearing Rtd's Condition		
	31. Contamination		
●	32. Frame Condition	**(P) Pass**	
●	33. Fan Condition	**(P) Pass**	
	34. Broken or missing components		
Initial Electric Test			
	35. Resistance to Ground		
	36. Winding Resistance 1-2		
	37. Winding Resistance 2-3		
	38. Winding Resistance 1-3		
	39. Resistive Imbalance		
	40. Hi-Pot		
●	41. Surge Test	**(F) Fail**	
	42. Stator Condition	**pass**	
	43. Failure Location	**windings shorted by impact with bearing fragments**	
Initial Rotor Inspection			
	44. Rotor Type	**squirrel cage**	P4

	45. Air Gap <10% Variation		
	46. Number of Rotor Bars		
	47. Number of Broken Rotor Bars		

48.	Growler Test	**(P) Pass**	
49.	Rotor Condition	**(P) Pass**	P50

Mechanical Inspection

50.	Bearing Manufacture		P1

51.	Bearing DE Size	**6206**	
52.	Bearing DE Type	**regular ball bearing**	
53.	DE Bearing Qty.	**1**	
54.	Bearing ODE Size	**6305**	P43

55.	Bearing ODE Type	**regular ball bearing**	
56.	ODE Bearing Qty.	**1**	
57.	Insulated Bearing	**no**	

	58.	Lubrication Type	**grease**
●	59.	Grease Condition	**(F) Fail**
	60.	Bearing Retainers	**(NA) Not Applicable**
	61.	Shaft Grounding Device	**(NA) Not Applicable**
	62.	DE Seal	
	63.	DE Seal Type/Size	
	64.	ODE Seal	
	65.	ODE Seal Type/Size	

Root Cause of Failure

	66.	Component Failure	**D.E. bearing suffered catastrophic cage failure**
	67.	Cause of Failure	

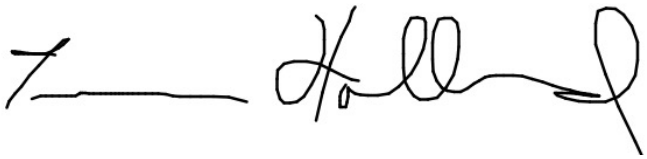
Insufficient amount of grease in D.E. housing contributed to bearing cage failure. This caused pieces of it to impact with the stator windings.

	68.	Comments	
	69.	Service Technician	**Terrence Holland**

Machine Fit Inspection Report

●	70.	Shaft Run Out	**(P) Pass**
	71.	Initial Shaft Run Out	**0.001 "**
	72.	Final Shaft Run Out	
●	73.	DE Bearing Shaft Fit	**(P) Pass**
	74.	DE Initial Shaft Bearing Fit Size 1	**1.1812 "**
	75.	DE Initial Shaft Bearing Fit Size 2	**1.1812 "**
	76.	DE Initial Shaft Bearing Fit Size 3	**1.1812 "**
	77.	DE Finial Shaft Bearing Fit Size 1	**"**
	78.	DE Finial Shaft Bearing Fit Size 2	
	79.	DE Finial Shaft Bearing Fit Size 3	
●	80.	ODE Bearing Shaft Fit	**(P) Pass**
	81.	ODE Initial Shaft Bearing Fit Size 1	**0.9847 "**
	82.	ODE Initial Shaft Bearing Fit Size 2	**0.9847 "**
	83.	ODE Initial Shaft Bearing Fit Size 3	**0.9847 "**
	84.	ODE Finial Shaft Bearing Fit Size 1	
	85.	ODE Finial Shaft Bearing Fit Size 2	
	86.	ODE Finial Shaft Bearing Fit Size 3	
	87.	DE Air Seal Shaft Fit	
	88.	DE Initial Air Seal Shaft Size	
	89.	DE Final Air Seal Shaft Size	
	90.	ODE Air Seal Shaft Fit	
	91.	ODE Initial Air Seal Shaft Size	
	92.	ODE Final Air Seal Shaft Size	
●	93.	DE Endbell Fit	**(P) Pass**
	94.	DE Initial Endbell Fit Size 1	**2.441 "**
	95.	DE Initial Endbell Fit Size 2	**2.4409 "**
	96.	DE Initial Endbell Fit Size 3	**2.4411 "**

97.	DE Final Endbell Fit Size 1	
98.	DE Finial Endbell Fit Size 2	
99.	DE Final Endbell Fit Size 3	
100.	DE Endbell Fit Insulated	**(NA) Not Applicable**
101.	DE Endbell Air Seal Fit	
102.	Initial Endbell Air Seal Fit Size	
103.	Finial Endbell Air Seal Fit Size	
104.	ODE Endbell Fit	**(P) Pass**
105.	ODE Initial Endbell Fit Size 1	**2.441 "**
106.	ODE Initial Endbell Fit Size 2	**2.4411 "**
107.	ODE Initial Endbell Fit Size 3	**2.4412 "**
108.	ODE Final Endbell Fit Size 1	
109.	ODE Final Endbell Fit Size 2	
110.	ODE Final Endbell Fit Size 3	
111.	ODE Endbell Fit Insulated	
112.	ODE Endbell Air Seal Fit	
113.	ODE Initial Endbell Seal Fit Size	
114.	ODE Finial Endbell Seal Fit Size	
115.	Foot Flatness	**(NA) Not Applicable**
116.	Foot Condition	**(NA) Not Applicable**
117.	Flange Condition	**(P) Pass**
118.	Service Technician	**Terrence Holland**



Balancing Report

119.	Balance Type	
120.	Balance Operating Speed	
121.	Start Left End	
122.	Start Right End	
123.	Balancing Specification	
124.	Finish Left End	
125.	Finish Right End	
126.	Service Technician	

Assembly and Final Test

127.	Meggar Testing Reading	
128.	Surge Test	
129.	Hi-Pot	
130.	Winding Resistance 1-2	
131.	Winding Resistance 2-3	
132.	Winding Resistance 1-3	
133.	Test Run Voltage Phase A	
134.	Test Run Amps A	
135.	Test Run Voltage Phase B	
136.	Test Run Amps B	
137.	Test Run Voltage Phase C	

138.	Test Run Amps C
139.	DE Horizontal Vibration Reading
140.	DE Vertical Vibration Reading
141.	DE Axial Vibration Reading
142.	ODE Horizontal Vibration Reading
143.	ODE Vertical Vibration Reading
144.	ODE Axial Vibration Reading
145.	Ambient Temp at start of Test Run
146.	Temp at 5 minutes
147.	Temp at 10 minutes
148.	Temp at 15 minutes
149.	Temp at 20 minutes
150.	Temp at 25 minutes
151.	Temp at 30 minutes
152.	Temp at 35 minutes
153.	Temp at 40 minutes
154.	Temp at 45 minutes
155.	Temp at 50 minutes
156.	Temp at 55 minutes
157.	Temp at 60 minutes
158.	Motor Paint
159.	Service Technician