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

AC Recondition Repair Report

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Molex, Inc. (10511)
801 Murphy Dr.
Maumelle, AR 72113

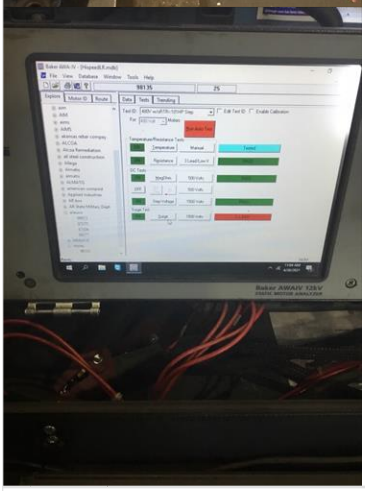
Priorities Found: **1 - High** **13 - Good**

General

1.	Job Number	**98135**
2.	Report Date	**04/22/2021**
3.	Customer	**MOLEX**

Name Plate Information

4.	Manufacturer	**BALDOR**	P5



5.	Model	**CAT# EM2547T**
6.	Serial Number	**Z0510100310**
7.	Horsepower	**60**
8.	KW	
9.	Volts	**460**
10.	Amps	**68**
11.	RPM	**1775**
12.	Frame	**364T**
13.	Enclosure	**TEFC**
14.	Cycles	**60**
15.	Phase	**3**

16.	Service Factor	**1.15**	
17.	Motor Mount Position		

Initial Inspection

18.	Number of Leads	**9**	P13

19.	Lead Length	**12 Inches**	
20.	Lead Size		
21.	Lead Condition	**(P) Pass**	P42

22.	Lead Markings	**1-9**	
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	**yes**	
28.	Does Shaft Have Visible Damage	**no**	
29.	Bearing Rtd's	**(NA) Not Applicable**	
30.	Bearing Rtd's Condition	**(NA) Not Applicable**	
31.	Contamination		P104

Dirty

	32.	Frame Condition	**(P) Pass**	P106

	33.	Fan Condition	**(NA) Not Applicable**
	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	**(P) Pass**
		Tested bad with new machine. Retested with old machine and stator tested good.	
	42.	Stator Condition	**pass**
	43.	Failure Location	

Initial Rotor Inspection

	44.	Rotor Type	**laminate press squirrel cage**	P4

	45.	Air Gap <10% Variation		
	46.	Number of Rotor Bars		
	47.	Number of Broken Rotor Bars	**0**	
●	48.	Growler Test	**(P) Pass**	
●	49.	Rotor Condition	**(P) Pass**	P50

Mechanical Inspection

	50.	Bearing Manufacture	**SKF**	

51.	Bearing DE Size	**6313 Z C3**	P15

52.	Bearing DE Type	**deep groove ball bearing**	
53.	DE Bearing Qty.	**1**	
54.	Bearing ODE Size	**6311 Z C3**	P43

55.	Bearing ODE Type	**deep groove ball bearing**	
56.	ODE Bearing Qty.	**1**	
57.	Insulated Bearing		
58.	Lubrication Type	**grease**	
59.	Grease Condition	**(F) Fail**	P74

60.	Bearing Retainers	**(NA) Not Applicable**	
61.	Shaft Grounding Device	**(NA) Not Applicable**	
62.	DE Seal	**(NA) Not Applicable**	
63.	DE Seal Type/Size		
64.	ODE Seal	**(NA) Not Applicable**	
65.	ODE Seal Type/Size		

Root Cause of Failure

66.	Component Failure	**bearings worn**
67.	Cause of Failure	
	Contaminated grease	
68.	Comments	
	Stator windings tested bad with new tester. Retested windings with old machine, windings tested good.	
69.	Service Technician	**Terrence. Holland**

Machine Fit Inspection Report

	70.	Shaft Run Out	
	71.	Initial Shaft Run Out	
	72.	Final Shaft Run Out	
●	73.	DE Bearing Shaft Fit	**(P) Pass**
	74.	DE Initial Shaft Bearing Fit Size 1	**2.559 "**
	75.	DE Initial Shaft Bearing Fit Size 2	**2.559 "**
	76.	DE Initial Shaft Bearing Fit Size 3	**2.559 "**
	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	**2.1653 "**
	82.	ODE Initial Shaft Bearing Fit Size 2	**2.1652 "**
	83.	ODE Initial Shaft Bearing Fit Size 3	**2.1652 "**
	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	P129

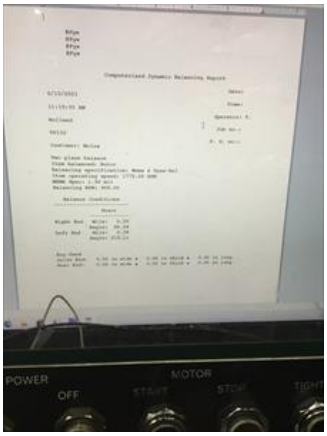
	94.	DE Initial Endbell Fit Size 1	**5.5129 "**
	95.	DE Initial Endbell Fit Size 2	**5.5124 "**
	96.	DE Initial Endbell Fit Size 3	**5.5122 "**
	97.	DE Final Endbell Fit Size 1	
	98.	DE Finial Endbell Fit Size 2	
	99.	DE Final Endbell Fit Size 3	
	100.	DE Endbell Fit Insulated	
	101.	DE Endbell Air Seal Fit	
	102.	Initial Endbell Air Seal Fit Size	
	103.	Finial Endbell Air Seal Fit Size	
	104.	ODE Endbell Fit	

	105. ODE Initial Endbell Fit Size 1	**4.7244 "**	
	106. ODE Initial Endbell Fit Size 2	**4.7246 "**	
	107. ODE Initial Endbell Fit Size 3	**4.7247 "**	
	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	**(NA) Not Applicable**	
	112. ODE Endbell Air Seal Fit		
	113. ODE Initial Endbell Seal Fit Size		
	114. ODE Finial Endbell Seal Fit Size		
●	115. Foot Flatness	**(P) Pass**	
●	116. Foot Condition	**(P) Pass**	
●	117. Flange Condition	**(NA) Not Applicable**	
	118. Service Technician	**Terrence. Holland**	

Rewind stator.

Balancing Report

	119. Balance Type	**nema standard**	P6



	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	**Mohm**	
	128. Surge Test		
	129. Hi-Pot	**Ua**	
	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	**0.05 In/Sec**	
140.	DE Vertical Vibration Reading	**0.03 In/Sec**	
141.	DE Axial Vibration Reading	**0.03 In/Sec**	
142.	ODE Horizontal Vibration Reading	**0.04 In/Sec**	
143.	ODE Vertical Vibration Reading	**0.05 In/Sec**	
144.	ODE Axial Vibration Reading	**0.02 In/Sec**	
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	**(P) Pass**	P136

159. Service Technician **Terrence. Holland**