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

AC Recondition As Found

Sage V Foods
5901 SLOAN DRIVE
LITTLE ROCK, AR 72206

FolderID: 99786
FormID: 13612524

AC Recondition - Rev. 2

Location:	MOTOR SHOP LR
Serial Number:	C0906200023
Description:	50HP Baldor 1800RPM 326TDZ

Hi-Speed Job Number:	99786
Manufacturer:	Baldor
Product Number:	12F654X859G1
Spec/ID #:	12F654X859G1
Serial Number:	C0906200023
HP/kW:	50 (HP)
RPM:	1775 (RPM)
Frame:	326TDZ
Voltage:	230 / 460
Current:	114/57
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.00
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	None
Date Received:	05/11/2022
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **1 - High** **6 - Good**

Overall Condition

	1.	Report Date	
	2.	Nameplate Picture	
	3.	Describe the Overall Condition of the Equipment as Received	

Initial Mechanical/Electrical

●	4.	Does Shaft Turn Freely?	**(Yes) Yes**
	5.	Does Shaft Have Visible Damage?	**(Yes) Yes**

6.	Assembled Shaft Runout	**2.897 Inches**	P6

7.	Assembled Shaft End Play		
8.	Air Gap Variation <10%		
9.	Lead Condition	**(P) Pass**	P9

10.	Lead Length	**12 Inches**	
11.	Frame Condition		
12.	Fan Condition	**(P) Pass**	P12

13.	Broken or Missing Components		

Initial Electrical Inspection

14.	Insulation Resistance/Megger	**Megohms**	

15.	Winding Resistance		
	1-2	1-3	2-3

16.	Perform Surge Test	**(P) Pass**	
17.	Stator Condition		P17

Mechanical Inspection

18.	Drive End Bearing Number-	**6312**	
19.	Drive End Bearing Qty.	**1**	
20.	Drive End Bearing Type	**(Ball) Ball Bearing**	
21.	Drive End Lubrication Type	**(Grease) Grease Lubricated**	
22.	Drive End Bearing Insulation or Grounding Device?	**Aegis**	P22

23.	Drive End Wavy Washer/Snap-Ring Other Retention Device?		

24.	Drive End Bearing Condition		P24

25.	Opposite Drive End Bearing Number-	**6311**	
26.	Opposite Drive End Bearing Qty.	**1**	
27.	Opposite Drive End Bearing Type	**(Ball) Ball Bearing**	
28.	Opposite Drive End Lubrication Type	**(Grease) Grease Lubricated**	
29.	Opposite Drive End Bearing Insulation or Grounding Device?	**no**	
30.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**wavy washer**	P30

31.	Opposite Drive End Bearing Condition		P31

32.	Drive End Seal	**Inpro**	P32

33.	Opposite Drive End Seal	**Inpro**	

Rotor Inspection

34.	Rotor Type/Material	**(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast**	P34

35.	Growler Test	**(Pass) Pass**	
36.	Number of Rotor Bars		
37.	Rotor Condition	**good**	
38.	List the Parts needed for the Repair Below		
39.	Signature of Technician that Disassembled Motor		

Mechanical Fits- Rotor

40.	Shaft Runout		**inches**	
41.	Rotor Runout			
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
42.	Coupling Fit Closest to Bearing Housing			
	0 Degrees	90 Degrees	120 Degrees	
43.	Coupling Fit Closest to the end of the Shaft			
	0 Degrees	60 Degrees	120 Degrees	
44.	Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
45.	Drive End Bearing Shaft Fit Condition			
46.	Opposite Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
47.	Opposite Drive End Bearing Shaft Fit Condition			
48.	Shaft Air Seal Fits			
	Drive End Air Seal	Opposite Drive End Air Seal		

Mechanical Fits- Bearing Housings

49.	Drive End - Endbell Bearing Fit			
	0 Degrees	60 Degrees	120 Degrees	
	5.1188	**5.1188**	**5.1188**	
50.	Drive End - Endbell Bearing Fit Condition		**(P) Pass**	P50

51.	Opposite Drive End - Endbell Bearing Fit			
	0 Degrees	60 Degrees	120 Degrees	
	4.7253	**4.7253**	**4.7253**	

52. Opposite Drive End - Endbell Bearing Fit Condition **(P) Pass** P52

53. Bearing Cap Condition

Drive End Bearing Cap	Opposite Drive End Bearing Cap

54. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

55. List Machine Work Needed Below

New shaft

56. Technician **RW**

Dynamic Balance Report

57. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade

58. Initial Balance Readings

Drive End	Opposite Drive End

59. Final Balance Readings

Drive End	Opposite Drive End

60. Technician

Rewind

61. Core Test Results - Watts loss per Pound

Pre-Burnout	Post Burnout

62. Core Hot Spot Test

Pre-Burnout	Post-Burnout

63. Post Rewind Electrical Test- Insulation Resistance

64. Post Rewind Polarization Index

65.	Post Rewind Winding Resistance		
	1-2	1-3	2-3
66.	Post Rewind Surge Test		
67.	Post Rewind Hi-Pot		
68.	Technician		

Root Cause of Failure

69.	Failure locations		
70.	Root cause of failure		

Mechanical Fits- Rotor - Post Repair

71.	Shaft Runout Post Repair		
72.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
73.	Coupling Fit Closest to Bearing Housing Post Repair		
	0 Degrees	90 Degrees	120 Degrees
74.	Coupling Fit Closest to the end of the Shaft Post Repair		
	0 Degrees	60 Degrees	120 Degrees
75.	Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
76.	Opposite Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
77.	Shaft Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
78.	Shaft Repair Sign-off		

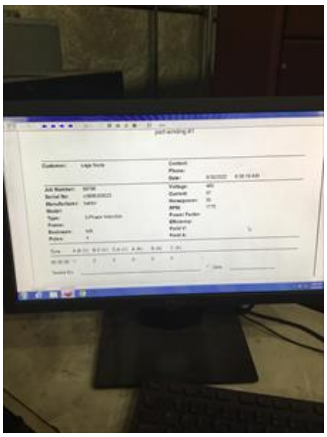
Mechanical Fits- Bearing Housings - Post Repair

79.	Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
80.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
81.	Bearing Cap Condition Post Repair		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
82.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
83.	End Bell Repair Sign-off		

Assembly

84.	Photograph All Major Components prior to assembly	

85.	Final Insulation Resistance Test		
86.	Assembled Shaft Endplay		
87.	Assembled Shaft Runout		
88.	Test Run Voltage		
	Volts	Volts	Volts
89.	Test Run Amperage		
	Amps	Amps	Amps
90.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
91.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
92.	Ambient Temperature - Fahrenheit		
93.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
94.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
95.	Final Test Run Sign-off		
96.	Document Final Condition with Pictures after paint		P2200



97.	Final Pics and QC Review	**Terrence. Holland**	P2300