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: 99797
FormID: 13597507

AC Recondition - Rev. 2

Location:	MOTOR SHOP LR
Serial Number:	C0906200018
Description:	50HP Baldor 1800RPM 326TDZ

Hi-Speed Job Number:	99797
Manufacturer:	Baldor
Product Number:	12F654W829G1
Spec/ID #:	12F654W829G1
Serial Number:	C0906200018
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:	05/13/2022
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Teardown Inspection
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **1 - High** **8 - Good**

Overall Condition

1. Report Date

2. Nameplate Picture P21







3. Describe the Overall Condition of the Equipment as Received

Shaft excessively bent...greater than 2.987

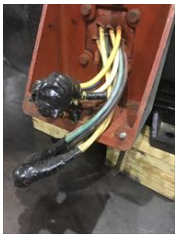
Initial Mechanical/Electrical

4. Does Shaft Turn Freely? **(Yes) Yes** P1

5. Does Shaft Have Visible Damage? **(Yes) Yes** P12

Bent key way. Chunk missing out of shaft.

6. Assembled Shaft Runout **2.987 Inches**
7. Assembled Shaft End Play **0 inches**
8. Air Gap Variation <10%
9. Lead Condition **(P) Pass** P31

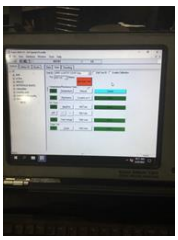


10.	Lead Length	**10.5 Inches**	
11.	Frame Condition	**good**	
12.	Fan Condition	**(P) Pass**	P52

13.	Broken or Missing Components	**in pro seals worn**	P56

Initial Electrical Inspection

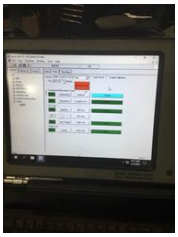
14.	Insulation Resistance/Megger	**Megohms**	P5



15. Winding Resistance

1-2	1-3	2-3

16.	Perform Surge Test	**(P) Pass**	P32



17.	Stator Condition	**pass**	P39

Mechanical Inspection

18.	Drive End Bearing Number-	**63122RSR**	P8

19.	Drive End Bearing Qty.	**1**	
20.	Drive End Bearing Type	**(Ball) Ball Bearing**	P20

21.	Drive End Lubrication Type	**(Grease) Grease Lubricated**	
22.	Drive End Bearing Insulation or Grounding Device?	**none**	
23.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**one**	P36

24.	Drive End Bearing Condition	**fail**	P41

25.	Opposite Drive End Bearing Number-		P46

26.	Opposite Drive End Bearing Qty.	**1**	P47

27.	Opposite Drive End Bearing Type	**(Ball) Ball Bearing**	
28.	Opposite Drive End Lubrication Type	**(Grease) Grease Lubricated**	P51

29.	Opposite Drive End Bearing Insulation or Grounding Device?		
30.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?		P54

31.	Opposite Drive End Bearing Condition		P55

32.	Drive End Seal	**worn/ replace**	P57

33.	Opposite Drive End Seal	**replace**

Rotor Inspection

34.	Rotor Type/Material	**(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast**
35.	Growler Test	**(Pass) Pass**
36.	Number of Rotor Bars	**40**
37.	Rotor Condition	**fail. shaftbent**
38.	List the Parts needed for the Repair Below ***In pro seal,***	
39.	Signature of Technician that Disassembled Motor	**Terrence. Holland**

Mechanical Fits- Rotor

40.	Shaft Runout	**2 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
2.3625	**2.3626**	**2.3625**

45.	Drive End Bearing Shaft Fit Condition	**(P) Pass**

46. Opposite Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
2.166	**2.1659**	**2.166**

47.	Opposite Drive End Bearing Shaft Fit Condition	**(P) Pass**

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	
	5.1187	**5.1189**	**5.1188**	
50.	Drive End - Endbell Bearing Fit Condition			**(P) Pass**
51.	Opposite Drive End - Endbell Bearing Fit			
	0 Degrees	60 Degrees	120 Degrees	
	4.7247	**4.7249**	**4.7249**	
52.	Opposite Drive End - Endbell Bearing Fit Condition			**(P) Pass**
53.	Bearing Cap Condition			
	Drive End Bearing Cap	Opposite Drive End Bearing Cap		
	pass	**none**		
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			**Terrence. Holland**

Root Cause of Failure

57.	Failure locations	
	D.E. Rotor shaft bent beyond repair	
58.	Root cause of failure	
	Bent shaft	