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:	Final
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

4. Photos of all six sides of the machine.

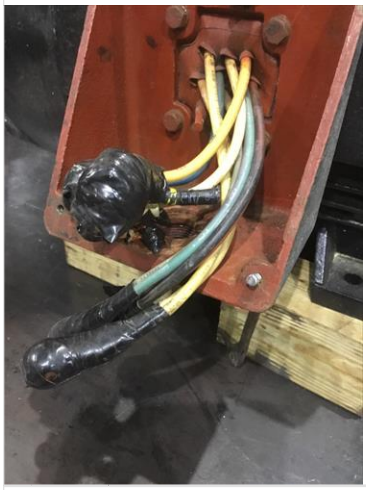
Initial Mechanical/Electrical

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

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

Bent key way. Chunk missing out of shaft.

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

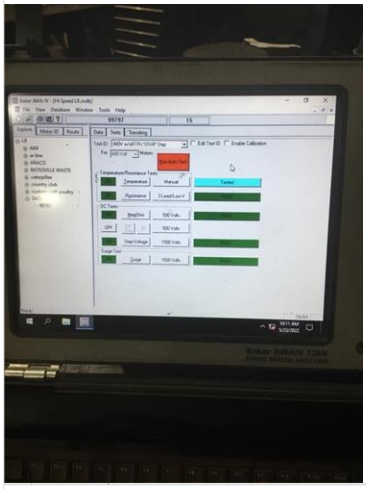


11.	Lead Length	**10.5 Inches**	
12.	Frame Condition	**good**	
13.	Fan Condition	**(P) Pass**	P52

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

Initial Electrical Inspection

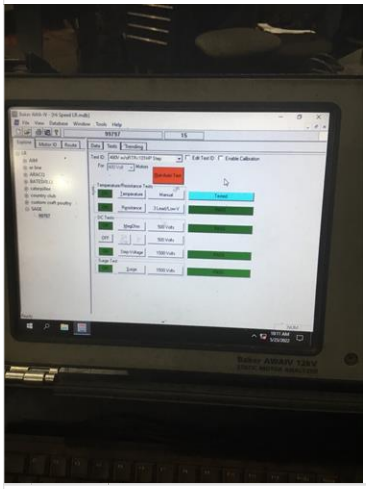
15. Insulation Resistance/Megger **Megohms** P5



16. Winding Resistance

1-2	1-3	2-3

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



18.	Stator Condition	**pass**	P39

Mechanical Inspection

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

20.	Drive End Bearing Qty.	**1**	

21.	Drive End Bearing Type	**(Ball) Ball Bearing**	P20

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

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

26.	Opposite Drive End Bearing Number-		P46

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

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

30.	Opposite Drive End Bearing Insulation or Grounding Device?		

31. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? P54

32. Opposite Drive End Bearing Condition P55

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

34. Opposite Drive End Seal **replace** P58

Rotor Inspection

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

Mechanical Fits- Rotor

41.	Shaft Runout			**2 inches**
42.	Rotor Runout			
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
43.	Coupling Fit Closest to Bearing Housing			
	0 Degrees	90 Degrees	120 Degrees	
44.	Coupling Fit Closest to the end of the Shaft			
	0 Degrees	60 Degrees	120 Degrees	
45.	Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	2.3625	**2.3626**	**2.3625**	
46.	Drive End Bearing Shaft Fit Condition			**(P) Pass**
47.	Opposite Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	2.166	**2.1659**	**2.166**	
48.	Opposite Drive End Bearing Shaft Fit Condition			**(P) Pass**

49. Shaft Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

50. Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
5.1187	**5.1189**	**5.1188**

51. Drive End - Endbell Bearing Fit Condition **(P) Pass**

52. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees
4.7247	**4.7249**	**4.7249**

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

54. Bearing Cap Condition

Drive End Bearing Cap	Opposite Drive End Bearing Cap
pass	**none**

55. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

56. List Machine Work Needed Below

New shaft.

57. Technician **Terrence. Holland**

Dynamic Balance Report

58. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade

59. Initial Balance Readings

Drive End	Opposite Drive End

60. Final Balance Readings

Drive End	Opposite Drive End

61. Technician

Rewind

62. Core Test Results - Watts loss per Pound

Pre-Burnout	Post Burnout

63. Core Hot Spot Test

Pre-Burnout	Post-Burnout

64. Post Rewind Electrical Test- Insulation Resistance

65. Post Rewind Polarization Index

66. Post Rewind Winding Resistance

1-2	1-3	2-3

67. Post Rewind Surge Test

68. Post Rewind Hi-Pot

69. Technician

Root Cause of Failure

70. Failure locations

D.E. Rotor shaft bent beyond repair

71. Root cause of failure

Bent shaft

Mechanical Fits- Rotor - Post Repair

72. Shaft Runout Post Repair

73. Rotor Runout Post Repair

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

74. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees	90 Degrees	120 Degrees

75. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees	60 Degrees	120 Degrees

76. Drive End Bearing Shaft Fit Post Repair

0 Degrees	60 Degrees	120 Degrees

77. Opposite Drive End Bearing Shaft Fit Post Repair

0 Degrees	60 Degrees	120 Degrees

78. Shaft Air Seal Fits Post Repair

Drive End Air Seal	Opposite Drive End Air Seal

79. Shaft Repair Sign-off

Mechanical Fits- Bearing Housings - Post Repair

80. Drive End - Endbell Bearing Fit Post Repair

0 Degrees	60 Degrees	120 Degrees

81. Opposite Drive End - Endbell Bearing Fit Post Repair

0 Degrees	60 Degrees	120 Degrees

82. Bearing Cap Condition Post Repair

Drive End Bearing Cap	Opposite Drive End Bearing Cap

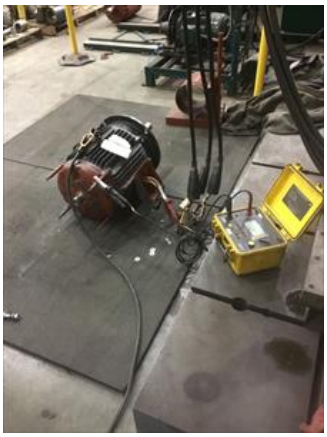
83. End Bell Air Seal Fits Post Repair

Drive End Air Seal	Opposite Drive End Air Seal

84. End Bell Repair Sign-off

Assembly

85. Photograph All Major Components prior to assembly P0



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

98. Final Pics and QC Review **Terrence. Holland**