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

AC Recondition As Found

Kroger
20820 interstate 30 N
Benton, AR 72019

FolderID: 99933
FormID: 13880267

AC Recondition - Rev. 2

Location:	Motor Shop
Serial Number:	32-12-200A
Description:	6HP ILG INDUSTRIES 900RPM 32 FRAME

Hi-Speed Job Number:	99933
Manufacturer:	Other
Product Number:	32-12-200A
Serial Number:	32-12-200A
HP/kW:	6 (HP)
RPM:	855 (RPM)
Frame:	32
Voltage:	220-240
Current:	13
Phase:	Three
Hz:	60 (Hz)
Enclosure:	TENV
Coupling/Sheave:	None
Date Received:	06/15/2022
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Teardown Inspection
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **3 - High** **4 - Good**

Overall Condition

1. Report Date

2. Nameplate Picture P21










3. Describe the Overall Condition of the Equipment as Received

Initial Mechanical/Electrical

4. Does Shaft Turn Freely? **(No) No** P1

ODE bearing destroyed.

Resolved: (6/20/2022)


5. Does Shaft Have Visible Damage? **(No) No**
6. Assembled Shaft Runout
7. Assembled Shaft End Play
8. Air Gap Variation <10%
9. Lead Condition **(P) Pass** P31

10.	Lead Length	**16.5 Inches**	
11.	Frame Condition	**good**	
12.	Fan Condition	**(N) NA**	
13.	Broken or Missing Components	**none**	

Initial Electrical Inspection

14.	Insulation Resistance/Megger	**Megohms**	
15.	Winding Resistance		

1-2	1-3	2-3

16.	Perform Surge Test	**(NA) Not Applicable**	P32

17.	Stator Condition	**good**	

Mechanical Inspection

18.	Drive End Bearing Number-	**6208**	P8

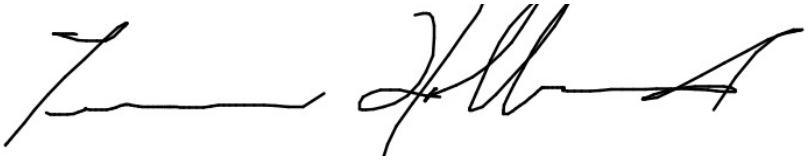
19.	Drive End Bearing Qty.	**1**
20.	Drive End Bearing Type	**(Ball) Ball Bearing**
21.	Drive End Lubrication Type	**(Grease) Grease Lubricated**
22.	Drive End Bearing Insulation or Grounding Device?	**none**
23.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**
24.	Drive End Bearing Condition	**failed. complete cage failure.**
25.	Opposite Drive End Bearing Number-	**6206**
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?	**none**
30.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**
31.	Opposite Drive End Bearing Condition	**destroyed.** P55

32.	Drive End Seal	
33.	Opposite Drive End Seal	

Rotor Inspection

34.	Rotor Type/Material	**(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast**	P3

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	**Terrence. Holland**



Mechanical Fits- Rotor

40.	Shaft Runout			
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	
	1.5754	**1.5753**	**1.5754**	
45.	Drive End Bearing Shaft Fit Condition			**(P) Pass**
46.	Opposite Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	1.1811	**1.1814**	**1.1814**	
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

Bad. Lip worn in.

50. Drive End - Endbell Bearing Fit Condition **(F) Fail** P7

Groove worn in

51. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees

Bad

52. Opposite Drive End - Endbell Bearing Fit Condition **(F) Fail** P22

Pitted

53. Bearing Cap Condition

Drive End Bearing Cap	Opposite Drive End Bearing Cap

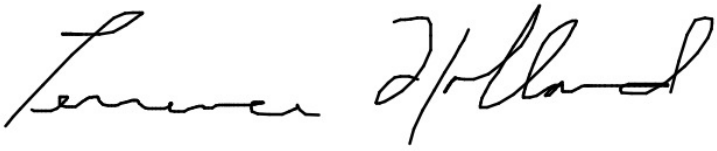
54. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

55. List Machine Work Needed Below

Sleeve both end bell housing fits

56. Technician **Terrence. Holland**



Root Cause of Failure

57. Failure locations P6

Windings overloaded.

58. Root cause of failure