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:	Final
Rewind:	Yes
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

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	3.	Describe the Overall Condition of the Equipment as Received	
	4.	Photos of all six sides of the machine.	

Initial Mechanical/Electrical

🔴	5.	Does Shaft Turn Freely?	**(No) No**	P1
		ODE bearing destroyed.		
		Resolved: (6/20/2022)		

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

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

Initial Electrical Inspection

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

1-2	1-3	2-3

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

18.	Stator Condition	**good**	

Mechanical Inspection

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

20.	Drive End Bearing Qty.	**1**
21.	Drive End Bearing Type	**(Ball) Ball Bearing**
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?	**none**
25.	Drive End Bearing Condition	**failed. complete cage failure.**
26.	Opposite Drive End Bearing Number-	**6206**
27.	Opposite Drive End Bearing Qty.	**1**
28.	Opposite Drive End Bearing Type	**(Ball) Ball Bearing**
29.	Opposite Drive End Lubrication Type	**(Grease) Grease Lubricated**

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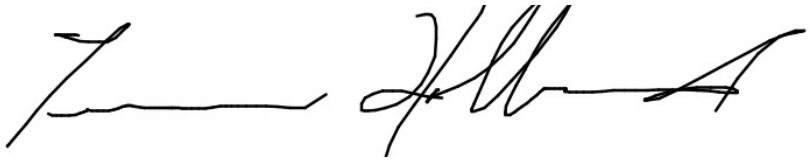
30.	Opposite Drive End Bearing Insulation or Grounding Device?	**none**	
31.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**	
32.	Opposite Drive End Bearing Condition	**destroyed.**	P55

33.	Drive End Seal		
34.	Opposite Drive End Seal		

Rotor Inspection

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

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



Mechanical Fits- Rotor

41.	Shaft Runout		
42.	Rotor Runout		

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

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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
1.5754	**1.5753**	**1.5754**

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

47. Opposite Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees
1.1811	**1.1814**	**1.1814**

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

Bad. Lip worn in.

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

Groove worn in

52. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees

Bad

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

Pitted

54. Bearing Cap Condition

Drive End Bearing Cap	Opposite Drive End Bearing Cap

55. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

56. List Machine Work Needed Below

Sleeve both end bell housing fits

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

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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 P6

Windings overloaded.

71. Root cause of failure

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

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80. Drive End - Endbell Bearing Fit Post Repair P0

0 Degrees	60 Degrees	120 Degrees
3.15	**3.1501**	**3.1501**

81. Opposite Drive End - Endbell Bearing Fit Post Repair P100

0 Degrees	60 Degrees	120 Degrees
2.4412	**2.4412**	**2.4411**

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

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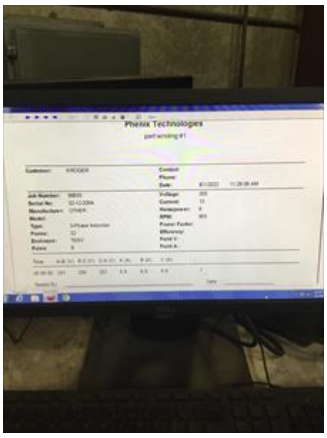

86.	Final Insulation Resistance Test		
87.	Assembled Shaft Endplay		
88.	Assembled Shaft Runout		
89.	Test Run Voltage		
	Volts	Volts	Volts
90.	Test Run Amperage		
	Amps	Amps	Amps
91.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
92.	Opposite Drive End Vibration Readings - 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		

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97.	Document Final Condition with Pictures after paint	
98.	Final Pics and QC Review	**Terrence. Holland**

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