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: 99958
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AC Recondition - Rev. 2

Location:	Motor Shop
Serial Number:	32-12-200A 5C
Description:	3HP ILG INDUSTRIES 900RPM 30 FRAME

Hi-Speed Job Number:	99958
Manufacturer:	Other
Product Number:	99958
Serial Number:	32-12-200A 5C
HP/kW:	3 (HP)
RPM:	855 (RPM)
Frame:	30
Voltage:	220-240
Current:	18
Phase:	Three
Hz:	60 (Hz)
Enclosure:	TENV
J-box Included:	None
Coupling/Sheave:	None
Date Received:	06/22/2022
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Teardown Inspection
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: **3 - High** **1 - Good**

Overall Condition

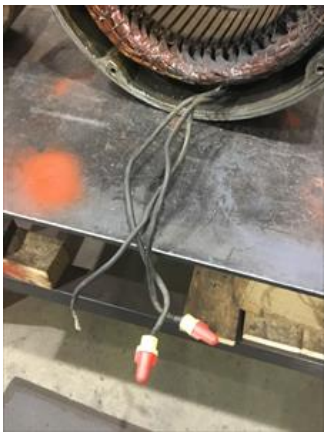
1. Report Date
2. Nameplate Picture P34

3.	Describe the Overall Condition of the Equipment as Received		
4.	Distance from the end of the shaft to the Coupling/Sheave		

Initial Mechanical/Electrical

5.	Does Shaft Turn Freely?	**(Yes) Yes**	
6.	Does Shaft Have Visible Damage?	**(No) No**	P20

7.	Assembled Shaft Runout		
8.	Assembled Shaft End Play		
9.	Air Gap Variation <10%		
10.	Lead Condition		P55



11.	Lead Length	**13 Inches**	

12.	Stator Temperature Detector Rating and Function			
	Quantity	Rating	Quantity Passed	
13.	Bearing Temperature Detector Rating and Function			
	Quantity	Rating	Quantity Passed	
14.	Frame Condition			
15.	Fan Condition		**(N) NA**	
16.	Heater Quantity, Ratings			
	Quantity	Volts/Watts	Pass/Fail	
17.	Broken or Missing Components			

Initial Electrical Inspection

18.	Insulation Resistance/Megger			
19.	Winding Resistance			
	1-2	1-3	2-3	
20.	Perform Surge Test		**(F) Fail**	
	Shorted in slot			
21.	Stator Condition			P69

Mechanical Inspection

22.	Drive End Bearing Number-	**6208**	P16

23.	Drive End Bearing Qty.	**1**

24.	Drive End Bearing Type	**(Ball) Ball Bearing**	
25.	Drive End Lubrication Type	**(Grease) Grease Lubricated**	
26.	Drive End Bearing Insulation or Grounding Device?	**none**	
27.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**	
28.	Drive End Bearing Condition	**dirty**	
29.	Opposite Drive End Bearing Number-	**6206**	P87

30.	Opposite Drive End Bearing Qty.	**1**	
31.	Opposite Drive End Bearing Type	**(Ball) Ball Bearing**	
32.	Opposite Drive End Lubrication Type	**(Grease) Grease Lubricated**	
33.	Opposite Drive End Bearing Insulation or Grounding Device?	**none**	
34.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**broken**	P106

35.	Opposite Drive End Bearing Condition	**dirty**	
36.	Drive End Seal	**none**	
37.	Opposite Drive End Seal	**none**	

38. DE Sleeve Bearing Inside Diameter

0 degrees	120 degrees	240 degrees

39. DE Sleeve Bearing Outside Diameter

0 degrees	120 degrees	240 degrees

40. DE Sleeve Bearing Housing Inside Diameter

0 degrees	120 degrees	240 degrees

41.	DE Sleeve Bearing to Housing Clearance		
	0 degrees	120 degrees	240 degrees
42.	ODE Sleeve Bearing Inside Diameter		
	0 degrees	120 degrees	240 degrees
43.	ODE Sleeve Bearing Outside Diameter		
	0 degrees	120 degrees	240 degrees
44.	ODE Sleeve Bearing Housing Inside Diameter		
	0 degrees	120 degrees	240 degrees
45.	ODE Sleeve Bearing to Housing Clearance		
	0 degrees	120 degrees	240 degrees

Rotor Inspection

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

47.	Growler Test	**(Pass) Pass**
48.	Number of Rotor Bars	
49.	Rotor Condition	**pass**
50.	List the Parts needed for the Repair Below	
51.	Signature of Technician that Disassembled Motor	**Terrence. Holland**

Mechanical Fits- Rotor

52.	Shaft Runout		
53.	Rotor Runout		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

54. Coupling Fit Closest to Bearing Housing

0 Degrees	90 Degrees	120 Degrees

55. Coupling Fit Closest to the end of the Shaft

0 Degrees	60 Degrees	120 Degrees

56. Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees

57. Drive End Bearing Shaft Fit Condition

58. Opposite Drive End Bearing Shaft Fit

0 Degrees	60 Degrees	120 Degrees

59. Opposite Drive End Bearing Shaft Fit Condition

60. Shaft Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

Mechanical Fits- Bearing Housings

61. Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees

Excessive bearing play in housing.

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

63. Opposite Drive End - Endbell Bearing Fit

0 Degrees	60 Degrees	120 Degrees

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

Lip worn in fit

65. Bearing Cap Condition

Drive End Bearing Cap	Opposite Drive End Bearing Cap

66. End Bell Air Seal Fits

Drive End Air Seal	Opposite Drive End Air Seal

67. List Machine Work Needed Below

D.e & O.d.e housing fits bad. Ode shaft bearing journal measures too small.

68. Technician **Terrence. Holland**

Dynamic Balance Report

69. Rotor Weight and Balance Grade

Rotor Weight	Balance Grade

70.	Initial Balance Readings		
	Drive End	Opposite Drive End	
71.	Final Balance Readings		
	Drive End	Opposite Drive End	
72.	Technician		

Rewind

73.	Core Test Results - Watts loss per Pound		
	Pre-Burnout	Post Burnout	
74.	Core Hot Spot Test		
	Pre-Burnout	Post-Burnout	
75.	Post Rewind Electrical Test- Insulation Resistance		
76.	Post Rewind Polarization Index		
77.	Post Rewind Winding Resistance		
	1-2	1-3	2-3
78.	Post Rewind Surge Test		
79.	Post Rewind Hi-Pot		
80.	Technician		

Root Cause of Failure

81.	Failure locations		
82.	Root cause of failure		

Mechanical Fits- Rotor - Post Repair

83.	Shaft Runout Post Repair		
84.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
85.	Coupling Fit Closest to Bearing Housing Post Repair		
	0 Degrees	90 Degrees	120 Degrees
86.	Coupling Fit Closest to the end of the Shaft Post Repair		
	0 Degrees	60 Degrees	120 Degrees
87.	Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
88.	Opposite Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
89.	Shaft Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
90.	Shaft Repair Sign-off		

Mechanical Fits- Bearing Housings - Post Repair

91.	Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
92.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
93.	Bearing Cap Condition Post Repair		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	
94.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
95.	DE Sleeve Bearing Inside ID Post Repair		
	Measure 1	Measure 2	Measure 3
96.	DE Sleeve Bearing Outside ID Post Repair		
	Measure 1	Measure 2	Measure 3
97.	DE Sleeve Bearing Inside OD Post Repair		
	Measure 1	Measure 2	Measure 3
98.	DE Sleeve Bearing Outside OD Post Repair		
	Measure 1	Measure 2	Measure 3
99.	End Bell Repair Sign-off		
100.	ODE Sleeve Bearing Inside ID Post Repair		
	Measure 1	Measure 2	Measure 3
101.	ODE Sleeve Bearing Outside ID Post Repair		
	Measure 1	Measure 2	Measure 3
102.	ODE Sleeve Bearing Inside OD Post Repair		
	Measure 1	Measure 2	Measure 3
103.	ODE Sleeve Bearing Outside OD Post Repair		
	Measure 1	Measure 2	Measure 3

Assembly

104.	Photograph All Major Components prior to assembly		
105.	Final Insulation Resistance Test		
106.	Assembled Shaft Endplay		
107.	Assembled Shaft Runout		
108.	Test Run Voltage		
	Volts	Volts	Volts

109.	Test Run Amperage		
	Amps	Amps	Amps
110.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
111.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
112.	Ambient Temperature - Fahrenheit		
113.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
114.	Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
	20 Minutes	25 Minutes	30 Minutes
115.	Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
	35 Minutes	40 Minutes	45 Minutes
116.	Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
	50 Minutes	55 Minutes	60 Minutes
117.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
118.	Opposite Drive End Bearing Temps - Fahrenheit 20-30 Minutes		
	20 Minutes	25 Minutes	30 Minutes
119.	Opposite Drive End Bearing Temps - Fahrenheit 35-45 Minutes		
	35 Minutes	40 Minutes	45 Minutes
120.	Opposite Drive End Bearing Temps - Fahrenheit 50-60 Minutes		
	50 Minutes	55 Minutes	60 Minutes
121.	Stator Temperatures- Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
122.	Stator Temperatures- Fahrenheit 20-30 Minutes		
	20 Minutes	25 Minutes	30 Minutes
123.	Stator Temperatures- Fahrenheit 35-45 Minutes		
	35 Minutes	40 Minutes	45 Minutes
124.	Stator Temperatures- Fahrenheit 50-60 Minutes		
	50 Minutes	55 Minutes	60 Minutes
125.	Final Test Run Sign-off		

126.	Document Final Condition with Pictures after paint
127.	Final Pics and QC Review