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

AC Recondition As Found

Hormel (11974)
8201 Fraizer Pike
Little Rock, AR 72206

FolderID: 100842
FormID: 15836915

AC Recondition - Rev. 2

Location:	MOTOR SHOP LR
Serial Number:	NO NP
Description:	200HP BALDOR 3600RPM 447TY

Hi-Speed Job Number:	100842
Manufacturer:	Baldor
Product Number:	Z44G8505
Spec/ID #:	Z44G8505
Serial Number:	NO NP
HP/kW:	200 (HP)
RPM:	3575 (RPM)
Frame:	447TY
Voltage:	460
Current:	222
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	TEFC
J-box Included:	Complete
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

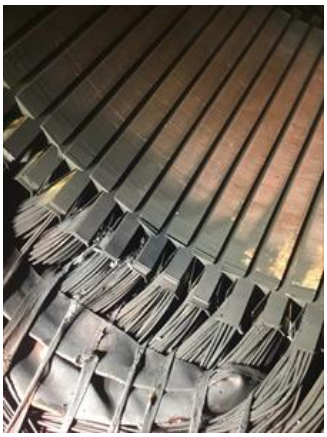
Priorities Found: **6 - Good**

Overall Condition

1. Report Date

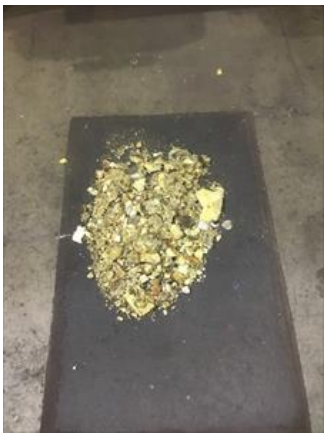
2. Nameplate Picture P37

3. Photos of all six sides of the machine. P45



4. Describe the Overall Condition of the Equipment as Received P54

Coated with sticky peanut butter



Initial Mechanical/Electrical

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

	7.	Assembled Shaft Runout	**0.003 Inches**	
	8.	Assembled Shaft End Play		
	9.	Air Gap Variation <10%		

10.	Lead Condition	**(P) Pass**	P53

11.	Lead Length	**17 Inches**	P78

6 leads #1,2,3

12.	Frame Condition	**pass**	
13.	Fan Condition	**(P) Pass**	P89

14. Broken or Missing Components

Initial Electrical Inspection

15. Insulation Resistance/Megger

16. Winding Resistance

1-2	1-3	2-3

17. Perform Surge Test **(NA) Not Applicable** P55

18. Number of Stator Slots

19. Stator Condition **pass**

Mechanical Inspection

20. Drive End Bearing Number- **NU 313-E-XL-M1-C3** P12

21.	Drive End Bearing Qty.	**1**	
22.	Drive End Bearing Type	**(Roller) Roller Bearing**	P36

23.	Drive End Lubrication Type	**(Oil) Oil Lubricated**	
24.	Drive End Bearing Insulation or Grounding Device?	**yes (aegis)**	P59

25.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	**spacer**	P63

26.	Drive End Bearing Condition	**replace**	
27.	Opposite Drive End Bearing Number-	**6313 2Z/C3**	P81

28.	Opposite Drive End Bearing Qty.	**1**	
29.	Opposite Drive End Bearing Type	**(Ball) Ball Bearing**	P85

30.	Opposite Drive End Lubrication Type	**(Grease) Grease Lubricated**	
31.	Opposite Drive End Bearing Insulation or Grounding Device?	**none**	
32.	Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	**none**	
33.	Opposite Drive End Bearing Condition	**worn**	
34.	Drive End Seal	**TC 65*85*8**	P95

Also has lip seal

35.	Opposite Drive End Seal	**CR-25956**	P96

Rotor Inspection

36.	Rotor Type/Material	P3

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

Mechanical Fits- Rotor

42.	Shaft Runout	**0.003 inches**
43.	Rotor Runout	

Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing

44.	Coupling Fit Closest to Bearing Housing

0 Degrees	90 Degrees	120 Degrees

45.	Coupling Fit Closest to the end of the Shaft			
	0 Degrees	60 Degrees	120 Degrees	
46.	Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	2.5603	**2.56**	**2.5602**	
47.	Drive End Bearing Shaft Fit Condition			
48.	Opposite Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	2.5598	**2.5599**	**2.5599**	
49.	Opposite Drive End Bearing Shaft Fit Condition			**(P) Pass**
50.	Shaft Air Seal Fits			
	Drive End Air Seal	Opposite Drive End Air Seal		

Mechanical Fits- Bearing Housings

51.	Drive End - Endbell Bearing Fit			
	0 Degrees	60 Degrees	120 Degrees	
52.	Drive End - Endbell Bearing Fit Condition			
53.	Opposite Drive End - Endbell Bearing Fit			
	0 Degrees	60 Degrees	120 Degrees	
54.	Opposite Drive End - Endbell Bearing Fit Condition			
55.	Bearing Cap Condition			
	Drive End Bearing Cap	Opposite Drive End Bearing Cap		
56.	End Bell Air Seal Fits			
	Drive End Air Seal	Opposite Drive End Air Seal		
57.	List Machine Work Needed Below			
58.	Technician			

Dynamic Balance Report

59.	Rotor Weight and Balance Grade			
	Rotor Weight	Balance Grade		
60.	Initial Balance Readings			
	Drive End	Opposite Drive End		
61.	Final Balance Readings			
	Drive End	Opposite Drive End		
62.	Technician			

Rewind

63.	Core Test Results - Watts loss per Pound			
	Pre-Burnout	Post Burnout		

64.	Core Hot Spot Test		
	Pre-Burnout	Post-Burnout	
65.	Post Rewind Electrical Test- Insulation Resistance		
66.	Post Rewind Polarization Index		
67.	Post Rewind Winding Resistance		
	1-2	1-3	2-3
68.	Post Rewind Surge Test		
69.	Post Rewind Hi-Pot		
70.	Technician		

Root Cause of Failure

71.	Failure locations		
72.	Root cause of failure		

Mechanical Fits- Rotor - Post Repair

73.	Shaft Runout Post Repair		
74.	Rotor Runout Post Repair		
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
75.	Coupling Fit Closest to Bearing Housing Post Repair		
	0 Degrees	90 Degrees	120 Degrees
76.	Coupling Fit Closest to the end of the Shaft Post Repair		
	0 Degrees	60 Degrees	120 Degrees
77.	Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
78.	Opposite Drive End Bearing Shaft Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
79.	Shaft Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
80.	Shaft Repair Sign-off		

Mechanical Fits- Bearing Housings - Post Repair

81.	Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
82.	Opposite Drive End - Endbell Bearing Fit Post Repair		
	0 Degrees	60 Degrees	120 Degrees
83.	Bearing Cap Condition Post Repair		
	Drive End Bearing Cap	Opposite Drive End Bearing Cap	

84.	End Bell Air Seal Fits Post Repair		
	Drive End Air Seal	Opposite Drive End Air Seal	
85.	End Bell Repair Sign-off		
Assembly			
86.	Photograph All Major Components prior to assembly		
87.	Final Insulation Resistance Test		
88.	Assembled Shaft Endplay		
89.	Assembled Shaft Runout		
90.	Test Run Voltage		
	Volts	Volts	Volts
91.	Test Run Amperage		
	Amps	Amps	Amps
92.	Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
93.	Opposite Drive End Vibration Readings - Inches Per Second		
	Horizontal	Vertical	Axial
94.	Ambient Temperature - Fahrenheit		
95.	Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
96.	Opposite Drive End Bearing Temps - Fahrenheit		
	5 Minutes	10 Minutes	15 Minutes
97.	Final Test Run Sign-off		
98.	Document Final Condition with Pictures after paint		
99.	Final Pics and QC Review		