



QualiTest® Diagnostics

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July 12, 2021

Hank Bass
Coca-Cola
West Memphis, AR

The following is a summary of findings from the July 2021 vibration survey at your facility. Please let us know if there are any questions or comments.

QualiTest® uses a four step rating system for defects.

Class I: Defect is present, but effect on reliability is not clear; no immediate action is required. Continue to normally monitor.

Class II: Defect (s) present that may cause problem in long term (2-6 months). Repair during normal maintenance scheduling. Continue to monitor.

Class III: Defect (s) present that may cause failure in short term (less than 2 months). This should be addressed as soon as practical, with a high maintenance priority. Increase monitoring frequency.

Class IV: Defect (s) present that makes continued reliability unpredictable, and possibility of secondary damage is high. Repairs should be made ASAP. An unscheduled shutdown should be considered for repairs

Hi-Speed Industrial Service tests and inspects industrial machinery and equipment and makes recommendations concerning maintenance and repairs based on its experience in the field of industrial repair and maintenance. The information contained herein is provided as an opinion only, not as a guaranty or warranty of the matters discussed herein.

Defects

Filler Motor

Motor spectral data is starting to show an indication of defects in the motor bearings. We will monitor this issue closely. Rated as a **CLASS II** defect.

Filler 2 Motor

Motor data is showing bearing defects present. Motor may need attention soon. Rated as a **CLASS III** defect for now.

C-1 Ammonia Compressor

Vibration data continues to indicate defects within the drive end MOTOR bearing. Considerations should be made to replace motor soon. Rated as a **CLASS III** defect.

C-2 Ammonia Compressor

Vibration data indicates base looseness, during visual inspection I noticed the belts were loose. Considerations should be made to check all base bolts and inspect belts for wear and check sheaves for wear and alignment. Rated as a **CLASS III** defect.

C-3 Ammonia Compressor

Motor vibration is still suggesting possible belt and or sheave issue. Data shows a dominant peak of vibration at what appears to be 2 x belt frequency. Inspect belts and sheaves for wear and misalignment as maintenance scheduling allows. Ensure all base and feet fasteners are tight. Rated as a **CLASS II** defect.

C-5 Ammonia Compressor

Motor vibration is still suggesting possible belt and or sheave issue. Inspect belts and sheaves for wear and misalignment as maintenance scheduling allows. Ensure all base and feet fasteners are tight. Rated as a **CLASS II** defect.

C-6 Ammonia Compressor

The motor appears to have an electrical vibration that may be caused by signs of electrical faults in the motor. We will monitor this issue closely. Rated as a **CLASS I** defect for now.

Abbreviated Last Measurement Summary

Database: Coca-Cola.rbm
Area: W.MEMPHIS PLANT
Route No. 1: WEST MEMPHIS
Report Date: 12-Jul-21 14:45

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD
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FILL 1 - FILLER 1 MOTOR	(12-Jul-21)	
	OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL	.186 In/Sec	1.027 G-s
MIH - MOTOR INBOARD HORIZONTAL	.245 In/Sec	1.153 G-s
MIA - MOTOR INBOARD AXIAL	.130 In/Sec	.678 G-s
 FILL 2 - FILLER 2 MOTOR	 (12-Jul-21)	
	OVERALL LEVEL	1K-20KHz

MOH - MOTOR OUTBOARD HORIZONTAL	.194 In/Sec	2.019 G-s
MIH - MOTOR INBOARD HORIZONTAL	.163 In/Sec	1.822 G-s
MIA - MOTOR INBOARD AXIAL	.095 In/Sec	1.165 G-s
C-1 - AMMONIA COMPRESSOR C-1	(12-Jul-21)	
	OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL	.651 In/Sec	4.414 G-s
MIH - MOTOR INBOARD HORIZONTAL	.331 In/Sec	3.738 G-s
MIA - MOTOR INBOARD AXIAL	.286 In/Sec	2.316 G-s
PIA - PUMP INBOARD AXIAL	.207 In/Sec	1.011 G-s
PIH - PUMP INBOARD HORIZONTAL	.306 In/Sec	.872 G-s
POH - PUMP OUTBOARD HORIZONTAL	.231 In/Sec	.491 G-s
C-2 - AMMONIA COMPRESSOR C-2	(12-Jul-21)	
	OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL	.964 In/Sec	.299 G-s
MIH - MOTOR INBOARD HORIZONTAL	.729 In/Sec	.360 G-s
MIA - MOTOR INBOARD AXIAL	.698 In/Sec	.138 G-s
PIA - PUMP INBOARD AXIAL	.183 In/Sec	.651 G-s
PIH - PUMP INBOARD HORIZONTAL	.523 In/Sec	.516 G-s
POH - PUMP OUTBOARD HORIZONTAL	.411 In/Sec	.526 G-s
C-4 - AMMONIA COMPRESSOR C-4	(12-Jul-21)	
	OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL	.094 In/Sec	.119 G-s
MIH - MOTOR INBOARD HORIZONTAL	.092 In/Sec	.180 G-s
MIA - MOTOR INBOARD AXIAL	.143 In/Sec	.134 G-s
PIA - PUMP INBOARD AXIAL	.155 In/Sec	.518 G-s
PIH - PUMP INBOARD HORIZONTAL	.085 In/Sec	.531 G-s
POH - PUMP OUTBOARD HORIZONTAL	.245 In/Sec	1.467 G-s
C-5 - AMMONIA COMPRESSOR C-5	(12-Jul-21)	
	OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL	.527 In/Sec	.471 G-s
MIH - MOTOR INBOARD HORIZONTAL	.560 In/Sec	.729 G-s
MIA - MOTOR INBOARD AXIAL	.191 In/Sec	.152 G-s
PIA - PUMP INBOARD AXIAL	.135 In/Sec	.191 G-s
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POH - PUMP OUTBOARD HORIZONTAL	.114 In/Sec	.153 G-s
C-7 - AMMONIA COMPRESSOR C-7	(12-Jul-21)	
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MIH - MOTOR INBOARD HORIZONTAL	.216 In/Sec	.639 G-s
MIA - MOTOR INBOARD AXIAL	.429 In/Sec	.254 G-s
PIA - PUMP INBOARD AXIAL	.154 In/Sec	2.094 G-s
PIH - PUMP INBOARD HORIZONTAL	.361 In/Sec	.879 G-s
POH - PUMP OUTBOARD HORIZONTAL	.159 In/Sec	2.280 G-s
CWP1 - CITY WATER PUMP 1	(12-Jul-21)	
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MIH - MOTOR INBOARD HORIZONTAL	.062 In/Sec	.204 G-s
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PWP2 - PROCESS WATER PUMP 2	(12-Jul-21)	
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34-P-201-2 - RO #2 PUMP (12-Jul-21)		
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MIV - MOTOR INBOARD VERTICAL	.041 In/Sec	.185 G-s
MIA - MOTOR INBOARD AXIAL	.118 In/Sec	.101 G-s
38-P-101-1 - RO PERMEATE PUMP #1 (12-Jul-21)		
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MOH - MOTOR OUTBOARD HORIZONTAL	.176 In/Sec	.700 G-s
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26-P-201 - UF BACKWASH PUMP (12-Jul-21)		
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MIV - MOTOR INBOARD VERTICAL	.069 In/Sec	.655 G-s
MIA - MOTOR INBOARD AXIAL	.067 In/Sec	.229 G-s

SC-1 - SCREW COMPRESSOR 1	(12-Jul-21)	
	OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL	.054 In/Sec	.540 G-s
MOV - MOTOR OUTBOARD VERTICAL	.060 In/Sec	.313 G-s
MIH - MOTOR INBOARD HORIZONTAL	.041 In/Sec	.511 G-s
MIV - MOTOR INBOARD VERTICAL	.061 In/Sec	.317 G-s
MIA - MOTOR INBOARD AXIAL	.059 In/Sec	.483 G-s
1IA - COMPRESSOR INPUT INBOARD AXIAL	.119 In/Sec	1.184 G-s
1IH - COMPRESSOR INPUT IB HORIZONTAL	.066 In/Sec	.651 G-s
1IV - COMPRESSOR INPUT IB VERTICAL	.151 In/Sec	.741 G-s
1OH - COMPRESSOR INPUT OB HORIZONTAL	.057 In/Sec	.849 G-s
1OV - COMPRESSOR INPUT OB VERTICAL	.152 In/Sec	1.808 G-s
2IA - COMPRESSOR OUTPUT INBOARD AXIAL	.164 In/Sec	1.387 G-s

Clarification Of Vibration Units:

Acc	-->	G-s	RMS
Vel	-->	In/Sec	PK

Abbreviated Last Measurement Summary

Database: Coca-Cola.rbm
Area: W.MEMPHIS PLANT
Route No. 1: WEST MEMPHIS
Report Date: 12-Jul-21 14:45

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD
-----	-----	-----
FILL 1 - FILLER 1 MOTOR	(12-Jul-21)	
	OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL	.186 In/Sec	1.027 G-s
MIH - MOTOR INBOARD HORIZONTAL	.245 In/Sec	1.153 G-s
MIA - MOTOR INBOARD AXIAL	.130 In/Sec	.678 G-s
FILL 2 - FILLER 2 MOTOR	(12-Jul-21)	
	OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL	.194 In/Sec	2.019 G-s
MIH - MOTOR INBOARD HORIZONTAL	.163 In/Sec	1.822 G-s
MIA - MOTOR INBOARD AXIAL	.095 In/Sec	1.165 G-s
C-1 - AMMONIA COMPRESSOR C-1	(12-Jul-21)	
	OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL	.651 In/Sec	4.414 G-s
MIH - MOTOR INBOARD HORIZONTAL	.331 In/Sec	3.738 G-s
MIA - MOTOR INBOARD AXIAL	.286 In/Sec	2.316 G-s
PIA - PUMP INBOARD AXIAL	.207 In/Sec	1.011 G-s
PIH - PUMP INBOARD HORIZONTAL	.306 In/Sec	.872 G-s
POH - PUMP OUTBOARD HORIZONTAL	.231 In/Sec	.491 G-s
C-2 - AMMONIA COMPRESSOR C-2	(12-Jul-21)	
	OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL	.964 In/Sec	.299 G-s
MIH - MOTOR INBOARD HORIZONTAL	.729 In/Sec	.360 G-s
MIA - MOTOR INBOARD AXIAL	.698 In/Sec	.138 G-s
PIA - PUMP INBOARD AXIAL	.183 In/Sec	.651 G-s
PIH - PUMP INBOARD HORIZONTAL	.523 In/Sec	.516 G-s
POH - PUMP OUTBOARD HORIZONTAL	.411 In/Sec	.526 G-s

C-4	- AMMONIA COMPRESSOR C-4	(12-Jul-21)	
		OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL		.094 In/Sec	.119 G-s
MIH - MOTOR INBOARD HORIZONTAL		.092 In/Sec	.180 G-s
MIA - MOTOR INBOARD AXIAL		.143 In/Sec	.134 G-s
PIA - PUMP INBOARD AXIAL		.155 In/Sec	.518 G-s
PIH - PUMP INBOARD HORIZONTAL		.085 In/Sec	.531 G-s
POH - PUMP OUTBOARD HORIZONTAL		.245 In/Sec	1.467 G-s
C-5	- AMMONIA COMPRESSOR C-5	(12-Jul-21)	
		OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL		.527 In/Sec	.471 G-s
MIH - MOTOR INBOARD HORIZONTAL		.560 In/Sec	.729 G-s
MIA - MOTOR INBOARD AXIAL		.191 In/Sec	.152 G-s
PIA - PUMP INBOARD AXIAL		.135 In/Sec	.191 G-s
PIH - PUMP INBOARD HORIZONTAL		.162 In/Sec	.405 G-s
POH - PUMP OUTBOARD HORIZONTAL		.114 In/Sec	.153 G-s
C-7	- AMMONIA COMPRESSOR C-7	(12-Jul-21)	
		OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL		.304 In/Sec	.618 G-s
MIH - MOTOR INBOARD HORIZONTAL		.216 In/Sec	.639 G-s
MIA - MOTOR INBOARD AXIAL		.429 In/Sec	.254 G-s
PIA - PUMP INBOARD AXIAL		.154 In/Sec	2.094 G-s
PIH - PUMP INBOARD HORIZONTAL		.361 In/Sec	.879 G-s
POH - PUMP OUTBOARD HORIZONTAL		.159 In/Sec	2.280 G-s
CWP1	- CITY WATER PUMP 1	(12-Jul-21)	
		OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL		.086 In/Sec	.970 G-s
MIH - MOTOR INBOARD HORIZONTAL		.062 In/Sec	.204 G-s
MIA - MOTOR INBOARD AXIAL		.055 In/Sec	.293 G-s
PWP1	- PROCESS WATER PUMP 1	(12-Jul-21)	
		OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL		.310 In/Sec	.121 G-s
MIH - MOTOR INBOARD HORIZONTAL		.188 In/Sec	.631 G-s
MIA - MOTOR INBOARD AXIAL		.085 In/Sec	1.180 G-s
PWP2	- PROCESS WATER PUMP 2	(12-Jul-21)	
		OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL		.161 In/Sec	.330 G-s
MIH - MOTOR INBOARD HORIZONTAL		.091 In/Sec	.190 G-s
MIA - MOTOR INBOARD AXIAL		.055 In/Sec	.194 G-s
PWP5	- PROCESS WATER PUMP 5	(12-Jul-21)	
		OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL		.073 In/Sec	.056 G-s
MIH - MOTOR INBOARD HORIZONTAL		.052 In/Sec	.054 G-s
MIA - MOTOR INBOARD AXIAL		.044 In/Sec	.045 G-s
34-P-201-2	- RO #2 PUMP	(12-Jul-21)	
		OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL		.117 In/Sec	.276 G-s
MOV - MOTOR OUTBOARD VERTICAL		.054 In/Sec	.480 G-s
MIH - MOTOR INBOARD HORIZONTAL		.100 In/Sec	.114 G-s
MIV - MOTOR INBOARD VERTICAL		.041 In/Sec	.185 G-s
MIA - MOTOR INBOARD AXIAL		.118 In/Sec	.101 G-s
38-P-101-1	- RO PERMEATE PUMP #1	(12-Jul-21)	
		OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL		.176 In/Sec	.700 G-s
MOV - MOTOR OUTBOARD VERTICAL		.140 In/Sec	.459 G-s
MIH - MOTOR INBOARD HORIZONTAL		.068 In/Sec	.369 G-s
MIV - MOTOR INBOARD VERTICAL		.109 In/Sec	.596 G-s
MIA - MOTOR INBOARD AXIAL		.140 In/Sec	.800 G-s
26-P-201	- UF BACKWASH PUMP	(12-Jul-21)	
		OVERALL LEVEL	1K-20KHz

MOH - MOTOR OUTBOARD HORIZONTAL	.109 In/Sec	.608 G-s
MOV - MOTOR OUTBOARD VERTICAL	.126 In/Sec	.650 G-s
MIH - MOTOR INBOARD HORIZONTAL	.061 In/Sec	.660 G-s
MIV - MOTOR INBOARD VERTICAL	.069 In/Sec	.655 G-s
MIA - MOTOR INBOARD AXIAL	.067 In/Sec	.229 G-s

SC-1 - SCREW COMPRESSOR 1	(12-Jul-21)	
	OVERALL LEVEL	1K-20KHz
MOH - MOTOR OUTBOARD HORIZONTAL	.054 In/Sec	.540 G-s
MOV - MOTOR OUTBOARD VERTICAL	.060 In/Sec	.313 G-s
MIH - MOTOR INBOARD HORIZONTAL	.041 In/Sec	.511 G-s
MIV - MOTOR INBOARD VERTICAL	.061 In/Sec	.317 G-s
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1IA - COMPRESSOR INPUT INBOARD AXIAL	.119 In/Sec	1.184 G-s
1IH - COMPRESSOR INPUT IB HORIZONTAL	.066 In/Sec	.651 G-s
1IV - COMPRESSOR INPUT IB VERTICAL	.151 In/Sec	.741 G-s
1OH - COMPRESSOR INPUT OB HORIZONTAL	.057 In/Sec	.849 G-s
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Clarification Of Vibration Units:

Acc	-->	G-s	RMS	
Vel	-->	In/Sec	PK	Abbreviated Last Measurement Summary

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Route No. 1: WEST MEMPHIS
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	OVERALL LEVEL	1K-20KHz
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Clarification Of Vibration Units:

Acc	-->	G-s	RMS
Vel	-->	In/Sec	PK

As always, it has been a pleasure to serve Coca-Cola West Memphis. If there are any comments or questions, do not hesitate to contact us.

Sincerely,

Chris Senter

ISO Certified Vibration Analyst, Category II



QualiTest® Diagnostics

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