



QualiTest® Diagnostics

7030 Ryburn Dr. Millington, TN

Phone: (901) 873-5300

Fax: (901) 873-5301

www.gohispeed.com

August 18, 2021

Milwaukee Tools
Greenwood, MS

The following is a summary of findings from the August 2021 monthly vibration survey of the Heat Treat Quench Motors. 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.

Heat Treat Motors

Heat Treat Motor 1

. Vibration appeared to be within acceptable limits this survey. No actions necessary at this time

Heat Treat Motor 2

Vibration appeared to be within acceptable limits this survey. No actions necessary at this time.

Abbreviated Last Measurement Summary

Database: Milwaukee Tools.rbm
Area: HEAT TREAT SYSTEMS
Route No. 1: HEAT TREAT
Report Date: 18-Aug-21 13:43

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD
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MOTOR #1 - HEAT TREAT MOTOR #1	(12-Aug-21)	
OVERALL LEVEL	1K-20KHz	
MOH - MOTOR OUTBOARD HORIZONTAL	.040 In/Sec	.173 G-s
MOV - MOTOR OUTBOARD VERTICAL	.048 In/Sec	.127 G-s
MIH - MOTOR INBOARD HORIZONTAL	.016 In/Sec	.107 G-s
MIV - MOTOR INBOARD VERTICAL	.014 In/Sec	.122 G-s
MIA - MOTOR INBOARD AXIAL	.016 In/Sec	.197 G-s

MOTOR #2 - HEAT TREAT MOTOR #2	(12-Aug-21)	
OVERALL LEVEL	1K-20KHz	
MOH - MOTOR OUTBOARD HORIZONTAL	.130 In/Sec	.092 G-s
MOV - MOTOR OUTBOARD VERTICAL	.083 In/Sec	.098 G-s
MIH - MOTOR INBOARD HORIZONTAL	.015 In/Sec	.316 G-s
MIV - MOTOR INBOARD VERTICAL	.018 In/Sec	.382 G-s
MIA - MOTOR INBOARD AXIAL	.027 In/Sec	.140 G-s

Clarification Of Vibration Units:

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

As always, it has been a pleasure to serve Milwaukee Tools Greenwood, MS. If there are any comments or questions, do not hesitate to contact us.

Sincerely,

Chris Senter

ISO Certified Vibration Analyst, Category I



QualiTest® *Diagnostics*

Cell: 901-430-2620

Email: csenter@gohispeed.com