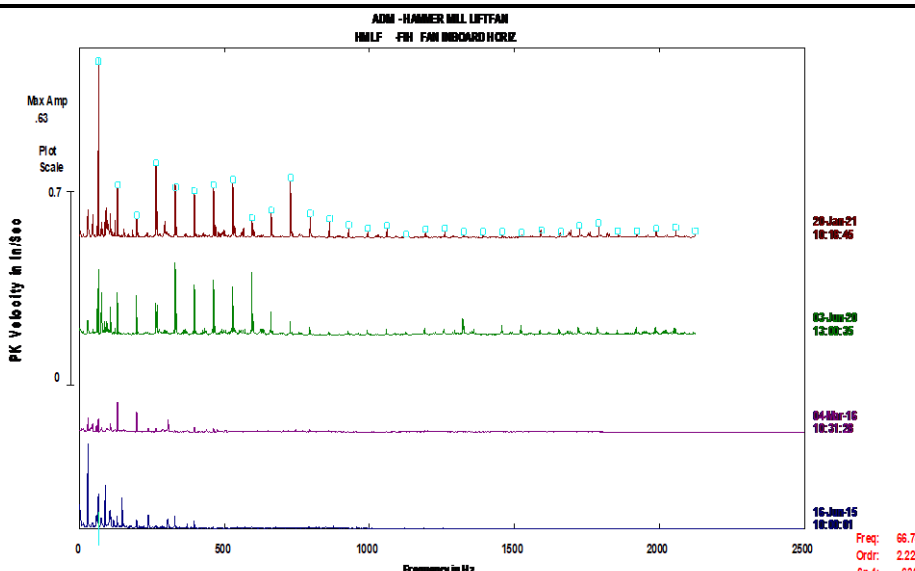
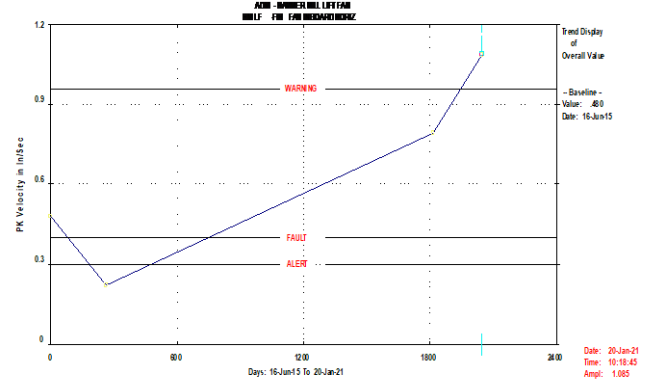




Client	ADM Flour Milling	Survey Date	1-20-21
Location	Jackson, TN	Report Date	1-21-21
Machine	Hammer Mill Lift Fan	QMS No.	144290
Component	Fan Bearings	Analyst	DWS

Defect Rating for this machine	CLASS III
Defect Rating System	
Class I: Defect is present, but effect on reliability is not clear; no immediate action is required. Continue normal monitoring.	Class III: Defect (s) present that may cause failure in short term (less than 2 mos.). Should be addressed as soon as practical, with a high maintenance priority. Increase monitoring frequency.
Class II: Defect (s) present that may cause problem in long term (2-6 mos.). Repair during normal maintenance scheduling. Continue to monitor.	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.

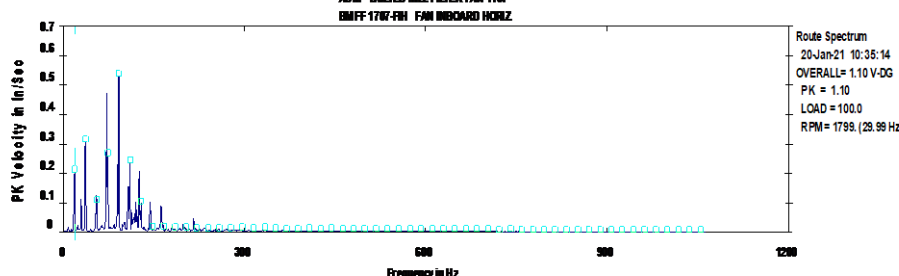
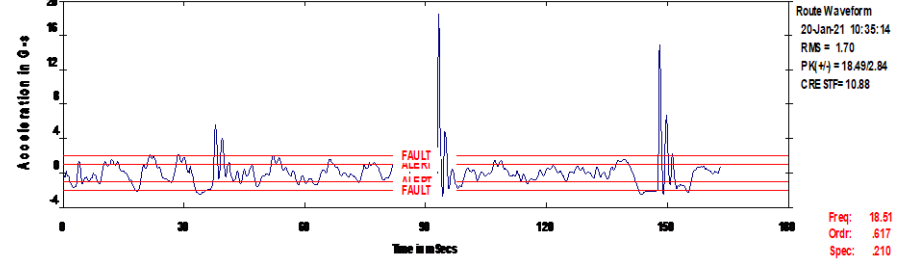
Vibration Data	Analysis
<p>ADM - HAMMER MILL LIFT FAN HMLF - FM FAN INBOARD HORIZ</p>  <p>Max Amp .63 Plot Scale 0.7</p> <p>20-Jan-21 10:16:45 03-Jan-20 12:00:25 04-Mar-16 10:31:28 16-Jan-15 10:00:00</p> <p>Freq: 66.74 Ord: 2.225 Sp 4: .630</p>	<p>Large peak at 66.3 Hz this survey with large number of harmonics in the fan inboard bearing.</p>

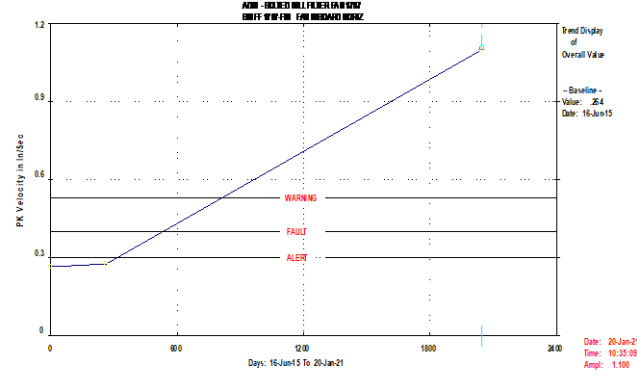
Discussion / Repair recommendations	Trend Data
<p>This unit was reported the last survey. The fan bearings are in distress. Overall vibrations are over 1"/sec velocity peak and near 4.5G's RMS. Replace the fan bearings. Inspect the shafts, sheaves and belts for wear and alignment. Rated a Class III Defect.</p>	 <p>Trend Display of Overall Value</p> <p>Baseline Value: .630 Date: 16-Jan-15</p> <p>Alert Fault Warning</p> <p>Date: 20-Jan-21 Time: 10:16:45 Amp: 1.003</p>



Client	ADM Flour Milling	Survey Date	1-20-21
Location	Jackson, TN	Report Date	1-21-21
Machine	1707 Bolted Mill Fan	QMS No.	144290
Component	Fan Bearings	Analyst	DWS

Defect Rating for this machine	CLASS IV
Defect Rating System	
Class I: Defect is present, but effect on reliability is not clear; no immediate action is required. Continue normal monitoring.	Class III: Defect (s) present that may cause failure in short term (less than 2 mos.). Should be addressed as soon as practical, with a high maintenance priority. Increase monitoring frequency.
Class II: Defect (s) present that may cause problem in long term (2-6 mos.). Repair during normal maintenance scheduling. Continue to monitor.	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.

Vibration Data	Analysis
<p>ADM - BOLTED MILL FILTER FAN 1707 EMFF 1707-FBI FAN IMBOARD HORIZ</p>  <p>Route Spectrum 20-Jan-21 10:35:14 OVERALL= 1.10 V-DG PK = 1.10 LOAD = 100.0 RPM = 1799. (29.99 Hz)</p>  <p>Route Waveform 20-Jan-21 10:35:14 RMS = 1.70 PK(4x) = 18.49/2.64 CRE STR= 10.88</p> <p>Freq: 18.51 Ord: .617 Spec: .210</p>	<p>Data shows shaft speed harmonics associated with looseness. Large asymmetrical impacts in the time domain.</p>

Discussion / Repair recommendations	Trend Data
<p>Data indicates the drive bearing is in very poor shape. The bearings should be replaced soon. Inspect all drive train components during repairs, replace worn components. Rated a Class IV Defect.</p>	 <p>Trend Display of Overall Value Baseline Value: .84 Date: 16-Jun-15</p> <p>WARNING FAULT ALERT</p> <p>Date: 20-Jan-21 Time: 10:35:09 Ampl: 1.100</p>