



MILLINGTON, TN

September 3, 2021

Blues City Brewery

Subject: August vibration service

Most of the machines surveyed were found to be in good condition with the exception of the following:

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.

This completes our assessment of your equipment for this survey. Thank you for your business and don't hesitate to call if you have any comments or questions.

Sincerely,

David W Shook

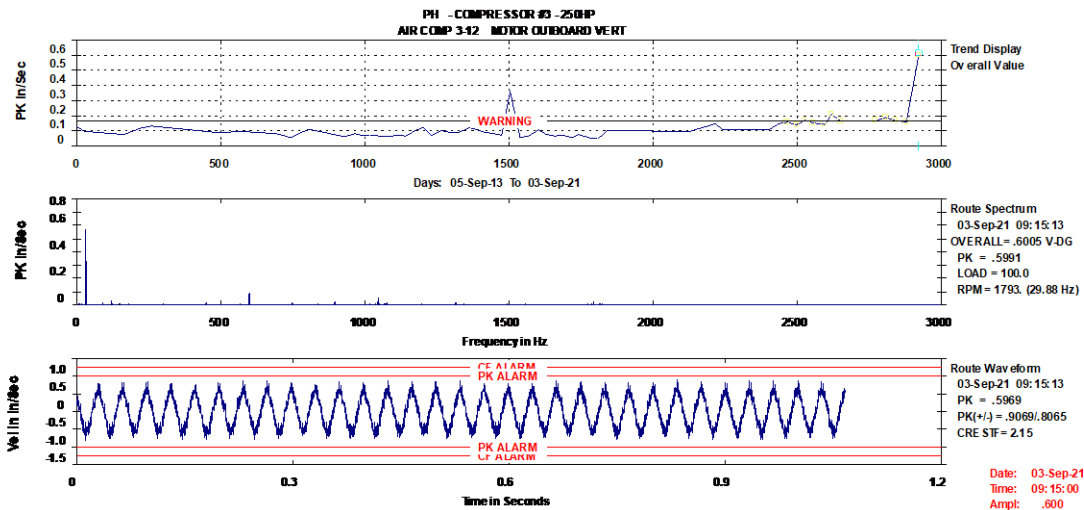
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Reportable equipment

Powerhouse #3 Air Compressor

Large jump in unit vibration at motor speed indicated a possible coupling issue. Inspection revealed a damaged coupling inspection cover. We suggested an immediate inspection of the unit to ascertain the root cause of the large vibration increase. Maintenance personnel shut it down and found one half of the coupling flexible element had delaminated from the steel shell and was lying below. Supporting data follows:



Boiler Fan 2

Motor vibrations are still high for the motor. Velocity overall is still over 1"/second peak for both radial and axial measurements. Ensure all foot bolts on the motor and all fan bearing bolts are torqued and there is no soft foot. This is more than likely a fan imbalance that is transferring through the motor. Still recommend having fan pulled and shop balanced on a balance stand. **Rated as a Class III Defect.**

Yellow Box Filtered Water Pump

Shaft speed vibration is still evident in the inboard pump horizontal. Inspect the coupling first for signs of wear that could cause imbalance. Check the alignment if the coupling looks good. The pump could be in distress if the coupling and alignment are good. **Rated a Class II Defect.**

Service Water Pump 8

The shaft speed vibrations in the motor radial and axial are still reportable. There are still signs of loose fasteners, structural looseness, possible misalignment, bent shaft, or coupling defects. **Rated a Class II Defect.**

RO Water Pump 2

This unit still has a vibration at what appears to be vane pass, (5x RPM, 122 HZ). The vibrations are still almost 0.5"/sec velocity peak in the time waveform now. There could be wear in the pump, or there could be a flow issue. We recommend further inspection and adjustments of flow related controls, filters, screens, or piping. **Rated a Class II Defect.**

Sugar Tank Viking Pump #3

The pump data still shows non-synchronous harmonic peaks in the data. This could indicate distress in the unit bearings. We will watch for changes. **Rated a Class I Defect.**

Filter Cellar Chill Water Circulator Pump 1

Vibrations are still at 2x line frequency. Unbalanced electrical phases or poor connections can cause the vibration since it changes in amplitude over time. Perform a motor phase and voltage analysis up to and including PDMA if necessary. **Rated a Class II Defect.**

Gov Cellar Packaging Cold Glycol Pump #2

Motor vibration data indicates possible early distress in the bearings. Ensure the bearings are lubricated properly. No other action is suggested. **Rated a Class I Defect.**

Administration HVAC Hot Water Pump

Motor and pump vibration is near 1/2"/second velocity peak overall. There could still be an alignment or coupling issue. Inspect the coupling and check the shaft alignment. **Rated a Class II Defect.**

Units previously reported but not running this survey

Boiler 3 Fan, Motor Bearings

Bearing defect frequencies are present in the motor vibration data. The acceleration trend has increased this survey. The overalls are above 3 g's RMS. Expect to change out the bearings in the future. **Rated a Class II Defect.**

Boiler 3 Fan, Fan Bearings

The inboard fan bearing shows strong peaks in the acceleration spectrum up around 2500 Hz with peaks around 114 Hz apart. Vibrations are over 4 g's RMS. Expect to change out the bearings in the future. **Rated a Class II Defect.**

Service Water Pump 5

The unit still has signs of possible misalignment or coupling defects. Check in the near future. The pump also has multiple non-synchronous vibration peaks in the upper frequencies, which we believe to be bearing defects. **Rated a Class II Defect.**

G Cellar Cold Glycol Pump #2

Motor has a dominant shaft speed vibration. Check the motor cooling fan as well as the coupling and alignment. Ensure all fasteners are tight. **Rated a Class II Defect.**

G Cellar Cold Glycol Pump #5

Motor still has a dominant vibration at 4X shaft speed with sidebands or shaft speed harmonics. Inspect for loose fasteners, coupling, and alignment issues. Could be a pump issue too if it has 4 flutes in the impeller. **Rated a Class II Defect.**

G Cellar 128 NANO Pump

Vibrations at shaft speed are still excessive. Ensure all fasteners are tight and support structure is sound. Check for pipe strain. Make sure coupling is in good shape and shaft alignment is precise. **Rated a Class II Defect.**

G Cellar 129 NANO Pump

Motor bearings have signs of early defects. No action required at this time other than ensuring the bearings have lubrication. **Rated a Class I Defect.**

2nd Floor South Hot Water Pump

Shaft speed vibration still dominates the motor vibration data at near 0.4" per second velocity peak. A 2x RPM vibration is also present. Inspect the unit base, structure, coupling and fasteners for issues. Have the shaft alignment checked too. **Rated a Class I Defect.**

Gallery DA Vacuum Pump Skid 1

We see a large shaft speed vibration at near 1/2"/second velocity peak in the pump. Inspect the unit fasteners and structure for issues. Check the coupling for defects and have the alignment checked. The unit rotor could also be out of balance due to wear. **Rated a Class II Defect.**

Abbreviated Last Measurement Summary *****

Database: Blues_city.rbm
Station: POWER HOUSE
Report Date: 03-Sep-21 13:59

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD	MACHINE SPEED
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AIR COMP 3 - COMPRESSOR #3 - 250HP		(03-Sep-21)	
	OVERALL LEVEL	1-20 KHZ	
11	.565 In/Sec	1.275 G-s	1792.0 RPM
12	.600 In/Sec	1.486 G-s	
13	.110 In/Sec	.859 G-s	
21	.504 In/Sec	2.824 G-s	

22	.457 In/Sec	1.581 G-s	
23	.365 In/Sec	4.282 G-s	
71	.547 In/Sec	1.266 G-s	3655.7 RPM
72	.579 In/Sec	2.351 G-s	
73	.171 In/Sec	2.398 G-s	
81	.660 In/Sec	1.535 G-s	
82	.593 In/Sec	1.305 G-s	
83	.175 In/Sec	2.098 G-s	

AIR COMP 5 - COMPRESSOR #5 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.192 In/Sec	.776 G-s	1788.0 RPM
12	.089 In/Sec	.561 G-s	
13	.111 In/Sec	.388 G-s	
21	.170 In/Sec	.552 G-s	
22	.090 In/Sec	.663 G-s	
23	.115 In/Sec	.490 G-s	
71	.150 In/Sec	.602 G-s	1785.0 RPM
72	.124 In/Sec	.468 G-s	
73	.169 In/Sec	.687 G-s	
81	.131 In/Sec	.655 G-s	
82	.042 In/Sec	.762 G-s	
83	.091 In/Sec	.247 G-s	

AIR COMP 6 - COMPRESSOR #6 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.162 In/Sec	.820 G-s	1788.0 RPM
12	.083 In/Sec	.756 G-s	
13	.122 In/Sec	.064 G-s	
21	.162 In/Sec	.347 G-s	
22	.082 In/Sec	.784 G-s	
23	.080 In/Sec	.441 G-s	
71	.098 In/Sec	.869 G-s	1785.0 RPM
72	.107 In/Sec	.403 G-s	
73	.152 In/Sec	.799 G-s	
81	.101 In/Sec	.732 G-s	
82	.058 In/Sec	.767 G-s	
83	.120 In/Sec	.490 G-s	

BFWPMIDLE2 - BOILER FEED WATER PUMP MID 2 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.127 In/Sec	.514 G-s	3540.0 RPM
12	.133 In/Sec	.354 G-s	
21	.191 In/Sec	.474 G-s	
22	.066 In/Sec	.466 G-s	
23	.098 In/Sec	.290 G-s	
71	.333 In/Sec	1.232 G-s	
72	.179 In/Sec	1.318 G-s	
73	.075 In/Sec	.909 G-s	
81	.144 In/Sec	.913 G-s	
82	.124 In/Sec	.490 G-s	

BFWPSOUTH1 - BOILER FEED WATER PUMP S 1 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.184 In/Sec	.244 G-s	3540.0 RPM
12	.098 In/Sec	.621 G-s	
21	.135 In/Sec	.527 G-s	

22	.073 In/Sec	.326 G-s	
23	.107 In/Sec	.058 G-s	
71	.122 In/Sec	1.130 G-s	
72	.139 In/Sec	1.136 G-s	
73	.083 In/Sec	.974 G-s	
81	.319 In/Sec	1.221 G-s	
82	.122 In/Sec	.541 G-s	
BOILERFAN1 - BOILER FAN #1		(03-Sep-21)	
	OVERALL LEVEL	1-20 KHZ	
11	.104 In/Sec	.125 G-s	1750.0 RPM
12	.211 In/Sec	.047 G-s	
21	.088 In/Sec	.549 G-s	
22	.091 In/Sec	.338 G-s	
23	.161 In/Sec	.103 G-s	
71	.141 In/Sec	.084 G-s	
BOILERFAN2 - BOILER FAN #2		(03-Sep-21)	
	OVERALL LEVEL	1-20 KHZ	
11	.432 In/Sec	.241 G-s	1780.0 RPM
12	.543 In/Sec	.316 G-s	
21	1.185 In/Sec	.243 G-s	
22	1.554 In/Sec	.230 G-s	
23	1.306 In/Sec	.169 G-s	
CR PUMP 1 - CARBON RECIRC PUMP		(03-Sep-21)	
	OVERALL LEVEL	1-20 KHZ	
11	.042 In/Sec	.136 G-s	3545.0 RPM
12	.059 In/Sec	.144 G-s	
21	.045 In/Sec	.162 G-s	
22	.061 In/Sec	.156 G-s	
23	.036 In/Sec	.089 G-s	
71	.029 In/Sec	.228 G-s	
72	.038 In/Sec	.178 G-s	
73	.029 In/Sec	.016 G-s	
81	.024 In/Sec	.070 G-s	
82	.026 In/Sec	.058 G-s	
YB PUMP 1 - YELLOW BOX FILTERED WATER		(03-Sep-21)	
	OVERALL LEVEL	1-20 KHZ	
11	.157 In/Sec	.202 G-s	3545.0 RPM
12	.155 In/Sec	.998 G-s	
21	.234 In/Sec	.897 G-s	
22	.179 In/Sec	.395 G-s	
23	.227 In/Sec	.395 G-s	
71	.747 In/Sec	.394 G-s	
72	.257 In/Sec	.523 G-s	
73	.132 In/Sec	.427 G-s	
81	.331 In/Sec	.356 G-s	
82	.195 In/Sec	.209 G-s	
SW PUMP 8 - SERVICE WATER PUMP 8		(03-Sep-21)	
	OVERALL LEVEL	1-20 KHZ	
11	.170 In/Sec	.284 G-s	3545.0 RPM
12	.508 In/Sec	.402 G-s	
21	.158 In/Sec	.726 G-s	
22	.406 In/Sec	.440 G-s	

23	.487 In/Sec	.376 G-s
71	.302 In/Sec	.700 G-s
72	.272 In/Sec	.776 G-s
73	.156 In/Sec	.562 G-s
81	.174 In/Sec	1.120 G-s
82	.179 In/Sec	.979 G-s

RO 2	- RO WATER PUMP 2	(03-Sep-21)	
	OVERALL LEVEL	1-20 KHZ	
11	.076 In/Sec	.409 G-s	3545.0 RPM
12	.062 In/Sec	.512 G-s	
21	.073 In/Sec	1.034 G-s	
22	.074 In/Sec	.431 G-s	
23	.058 In/Sec	.483 G-s	
71	.396 In/Sec	.235 G-s	
72	.089 In/Sec	.291 G-s	
73	.154 In/Sec	.281 G-s	
81	.191 In/Sec	.471 G-s	
82	.087 In/Sec	.523 G-s	

AMMCOMP 2	- AMMONIA COMP - #2	(03-Sep-21)	
	OVERALL LEVEL	1-20 KHZ	
11	.051 In/Sec	.207 G-s	3592.0 RPM
12	.070 In/Sec	.031 G-s	
13	.041 In/Sec	.175 G-s	
21	.069 In/Sec	.102 G-s	
22	.076 In/Sec	.055 G-s	
23	.084 In/Sec	.046 G-s	
71	.110 In/Sec	.606 G-s	
72	.097 In/Sec	.441 G-s	
73	.087 In/Sec	.189 G-s	
81	.063 In/Sec	.778 G-s	
82	.144 In/Sec	.297 G-s	
83	.098 In/Sec	.196 G-s	
71F	.114 In/Sec	.555 G-s	
72F	.088 In/Sec	.404 G-s	
73F	.080 In/Sec	.738 G-s	
81F	.057 In/Sec	.481 G-s	
82F	.064 In/Sec	.435 G-s	
83F	.077 In/Sec	.719 G-s	

Clarification Of Vibration Units:

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

Abbreviated Last Measurement

Summary

Database: Blues_city.rbm
 Station: UPPER FLOORS
 Report Date: 03-Sep-21 13:59

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD	MACHINE SPEED
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2NHWP	- 2ND FLOOR N. HOT WATER PUMP	(03-Sep-21)	
	OVERALL LEVEL	1-20 KHZ	

11	.160 In/Sec	.346 G-s	3545.0 RPM
12	.131 In/Sec	.224 G-s	
21	.108 In/Sec	.624 G-s	
22	.174 In/Sec	1.009 G-s	
23	.181 In/Sec	.197 G-s	
71	.141 In/Sec	1.477 G-s	
72	.194 In/Sec	1.336 G-s	
73	.270 In/Sec	1.185 G-s	
81	.111 In/Sec	1.657 G-s	
82	.107 In/Sec	.440 G-s	

Clarification Of Vibration Units:

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

Abbreviated Last Measurement

Summary

Database: Blues_city.rbm
Station: BREWING 1ST FLOOR
Report Date: 03-Sep-21 13:59

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD	MACHINE SPEED
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*** NO DATA Was Found That Meets the Report Specification ***
Abbreviated Last Measurement Summary

Database: Blues_city.rbm
Station: BREWING BASEMENT
Report Date: 03-Sep-21 13:59

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD	MACHINE SPEED
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*** NO DATA Was Found That Meets the Report Specification ***
Abbreviated Last Measurement Summary

Database: Blues_city.rbm
Station: GRAIN TRANSFER
Report Date: 03-Sep-21 13:59

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD	MACHINE SPEED
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*** NO DATA Was Found That Meets the Report Specification ***
Abbreviated Last Measurement Summary

Database: Blues_city.rbm
Station: SUGAR PUMPS
Report Date: 03-Sep-21 13:59

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD	MACHINE SPEED
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V3 - SUGAR TANK VIKING PUMP #3 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.086 In/Sec	.371 G-s	1750.0 RPM
12	.130 In/Sec	.173 G-s	
21	.119 In/Sec	.753 G-s	
22	.100 In/Sec	.292 G-s	
23	.051 In/Sec	.347 G-s	
31	.105 In/Sec	1.465 G-s	
32	.105 In/Sec	.906 G-s	
33	.080 In/Sec	1.190 G-s	
61	.087 In/Sec	1.686 G-s	
62	.083 In/Sec	.869 G-s	
63	.072 In/Sec	.524 G-s	
71	.076 In/Sec	.109 G-s	
72	.061 In/Sec	.218 G-s	

V4 - SUGAR TANK VIKING PUMP #4 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.080 In/Sec	.161 G-s	1750.0 RPM
12	.086 In/Sec	.233 G-s	
21	.062 In/Sec	1.519 G-s	
22	.057 In/Sec	.878 G-s	
23	.083 In/Sec	.645 G-s	
31	.142 In/Sec	.207 G-s	
32	.076 In/Sec	.185 G-s	
33	.068 In/Sec	.307 G-s	
61	.046 In/Sec	.440 G-s	
62	.093 In/Sec	.227 G-s	
63	.063 In/Sec	.295 G-s	
71	.073 In/Sec	.191 G-s	
72	.163 In/Sec	.505 G-s	
73	.294 In/Sec	.969 G-s	
81	.093 In/Sec	.205 G-s	

V5 - SUGAR TANK VIKING PUMP #5 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.136 In/Sec	.384 G-s	1175.0 RPM
12	.026 In/Sec	.293 G-s	
21	.117 In/Sec	.322 G-s	
22	.033 In/Sec	.224 G-s	
23	.026 In/Sec	.217 G-s	
71	.078 In/Sec	.448 G-s	
72	.076 In/Sec	.659 G-s	
73	.052 In/Sec	.076 G-s	
81	.065 In/Sec	.203 G-s	
82	.066 In/Sec	.336 G-s	

Clarification Of Vibration Units:

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

Summary

Database: Blues_city.rbm
Station: ALCOHOL PUMP ROOM

Report Date: 03-Sep-21 13:59

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD	MACHINE SPEED
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*** NO DATA Was Found That Meets the Report Specification ***
Abbreviated Last Measurement Summary

Database: Blues_city.rbm
Station: ADMINISTRATIVE AREA
Report Date: 03-Sep-21 13:59

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD	MACHINE SPEED
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HVAC COLD - HVAC COLD GLYCOL CIRC PUMP		(03-Sep-21)	
	OVERALL LEVEL	1-20 KHZ	
11	.069 In/Sec	.390 G-s	3600.0 RPM
12	.071 In/Sec	.260 G-s	
21	.122 In/Sec	.414 G-s	
22	.040 In/Sec	.367 G-s	
23	.088 In/Sec	.188 G-s	
71	.197 In/Sec	.176 G-s	
72	.139 In/Sec	.223 G-s	
73	.063 In/Sec	.160 G-s	
81	.255 In/Sec	.355 G-s	
82	.137 In/Sec	.214 G-s	

HVAC HOT - HVAC HOT WATER CIRC PUMP		(03-Sep-21)	
	OVERALL LEVEL	1-20 KHZ	
11	.232 In/Sec	.310 G-s	3600.0 RPM
12	.200 In/Sec	.314 G-s	
21	.185 In/Sec	.756 G-s	
22	.292 In/Sec	.444 G-s	
23	.279 In/Sec	.301 G-s	
71	.299 In/Sec	.506 G-s	
72	.471 In/Sec	.556 G-s	
73	.149 In/Sec	.208 G-s	
81	.195 In/Sec	.308 G-s	
82	.199 In/Sec	.225 G-s	

Clarification Of Vibration Units:

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

Abbreviated Last Measurement

Summary

Database: Blues_city.rbm
Station: FILTER CELLAR
Report Date: 03-Sep-21 13:59

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD	MACHINE SPEED
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CHILL 1 - CHILL WATER CIRC PUMP #1		(03-Sep-21)	
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	OVERALL LEVEL	1-20 KHZ	
11	.271 In/Sec	.576 G-s	3600.0 RPM
12	.153 In/Sec	.373 G-s	
21	.273 In/Sec	.709 G-s	
22	.173 In/Sec	.536 G-s	
23	.237 In/Sec	.990 G-s	
71	.121 In/Sec	.727 G-s	
72	.155 In/Sec	.531 G-s	
73	.197 In/Sec	1.132 G-s	
81	.082 In/Sec	.585 G-s	
82	.059 In/Sec	.477 G-s	

WARM GLY 1 - WARM GLYCOL PUMP #1 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.029 In/Sec	.125 G-s	3600.0 RPM
12	.027 In/Sec	.204 G-s	
21	.072 In/Sec	.379 G-s	
22	.093 In/Sec	.264 G-s	
23	.118 In/Sec	.082 G-s	
71	.300 In/Sec	.293 G-s	
72	.162 In/Sec	.114 G-s	
73	.114 In/Sec	.120 G-s	
81	.133 In/Sec	.324 G-s	
82	.100 In/Sec	.312 G-s	

WARM GLY 2 - WARM GLYCOL PUMP #2 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.020 In/Sec	.188 G-s	3600.0 RPM
12	.020 In/Sec	.189 G-s	
21	.038 In/Sec	.255 G-s	
22	.022 In/Sec	.243 G-s	
23	.025 In/Sec	.176 G-s	
71	.028 In/Sec	.082 G-s	
72	.048 In/Sec	.058 G-s	
73	.028 In/Sec	.035 G-s	
81	.035 In/Sec	.086 G-s	
82	.038 In/Sec	.046 G-s	

Clarification Of Vibration Units:

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

Summary

Database: Blues_city.rbm
Station: GOVERNMENT CELLAR
Report Date: 03-Sep-21 13:59

MEASUREMENT POINT	OVERALL LEVEL	HFD / VHFD	MACHINE SPEED
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COLD GLY 3 - COLD GLYCOL PUMP #3 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.048 In/Sec	.160 G-s	3600.0 RPM
12	.032 In/Sec	.193 G-s	
21	.057 In/Sec	.380 G-s	

22	.068 In/Sec	.264 G-s
23	.082 In/Sec	.089 G-s
71	.091 In/Sec	.153 G-s
72	.042 In/Sec	.170 G-s
73	.066 In/Sec	.042 G-s
81	.123 In/Sec	.187 G-s
82	.034 In/Sec	.213 G-s

COLD GLY 4 - COLD GLYCOL PUMP #4 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.106 In/Sec	.372 G-s	3600.0 RPM
12	.036 In/Sec	.460 G-s	
21	.131 In/Sec	.682 G-s	
22	.078 In/Sec	.746 G-s	
23	.093 In/Sec	.100 G-s	
71	.055 In/Sec	.819 G-s	
72	.037 In/Sec	.696 G-s	
73	.029 In/Sec	.308 G-s	
81	.031 In/Sec	.403 G-s	

PACK GLY 2 - PACKAGING COLD GLYCOL PUMP 2 (03-Sep-21)

	OVERALL LEVEL	1-20 KHZ	
11	.034 In/Sec	1.432 G-s	3600.0 RPM
12	.019 In/Sec	1.568 G-s	
21	.040 In/Sec	1.125 G-s	
22	.038 In/Sec	2.113 G-s	
23	.034 In/Sec	.928 G-s	
71	.041 In/Sec	.317 G-s	
72	.017 In/Sec	.264 G-s	
73	.038 In/Sec	.299 G-s	
81	.023 In/Sec	.472 G-s	
82	.016 In/Sec	.225 G-s	

Clarification Of Vibration Units:

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