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LR Motor Shop Repairs

**Job Number 99994**

Prepared for Sage V Foods

5901 SLOAN DRIVE  
LITTLE ROCK AR 72206

# Table of Contents



Hi-Speed Industrial Service  
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Millington, Tn 38053  
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## AC Recondition As Found

Sage V Foods  
5901 SLOAN DRIVE  
LITTLE ROCK, AR 72206

FolderID: 99994  
FormID: 13973876

### AC Recondition - Rev. 2

Location: MOTOR SHOP LR  
Serial Number: 12H041Y292G2  
Description: 40HP BALDOR 3600RPM 324TSC

|                      |                 |
|----------------------|-----------------|
| Hi-Speed Job Number: | 99994           |
| Manufacturer:        | Baldor          |
| Product Number:      | CEM4109T        |
| Spec/ID #:           | 12H041Y292G2    |
| HP/kW:               | 40 (HP)         |
| RPM:                 | 3530 (RPM)      |
| Frame:               | 324TSC          |
| Voltage:             | 230 / 460       |
| Current:             | 92/46           |
| Phase:               | Three           |
| Hz:                  | 60 (Hz)         |
| Service Factor:      | 1.15            |
| Enclosure:           | TEFC            |
| J-box Included:      | Complete        |
| Coupling/Sheave:     | None            |
| Date Received:       | 07/01/2022      |
| Bearing RTDs:        | No              |
| Stator RTDs:         | No              |
| Repair Stage:        | Final           |
| Heaters:             | No              |
| Winding Type :       | Random Wound    |
| Bearing Type:        | Rolling Element |

Priorities Found: ● 2 - High ● 6 - Good

### Overall Condition

1. Report Date
2. Nameplate Picture



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1.1





3. Describe the Overall Condition of the Equipment as Received


*Dirty*


4. Photos of all six sides of the machine.

#### Initial Mechanical/Electrical

|                                  |                                    |           |
|----------------------------------|------------------------------------|-----------|
| <input checked="" type="radio"/> | 5. Does Shaft Turn Freely?         | (Yes) Yes |
| <input type="radio"/>            | 6. Does Shaft Have Visible Damage? | (No) No   |
| <input type="radio"/>            | 7. Assembled Shaft Runout          | Inches    |
| <input type="radio"/>            | 8. Assembled Shaft End Play        |           |
| <input type="radio"/>            | 9. Air Gap Variation <10%          |           |

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|   |  |  |
|---|--|--|
| 10.   | Lead Condition   | (P) Pass   |
| 11.   | Lead Length  | 12 Inches  |
| 12.   | Frame Condition  | good   |
| 13.   | Fan Condition  | (P) Pass   |
| 14.   | Broken or Missing Components                                     | none   |
| <b>Initial Electrical Inspection</b>  |  |  |
| 15.   | Insulation Resistance/Megger                                     |  |
| 16.   | Winding Resistance   |  |
|   | 1-2  | 1-3 2-3  |
| 17.   | Perform Surge Test   | (F) Fail   |
| 18.   | Stator Condition   | rewind   |
| <b>Mechanical Inspection</b>  |  |  |
| 19.   | Drive End Bearing Number-  | 6312 2RS   |
| 20.   | Drive End Bearing Qty.   | 1  |
| 21.   | Drive End Bearing Type   | (Ball) Ball Bearing                                    |
| 22.   | Drive End Lubrication Type                                       | (Grease) Grease Lubricated                             |
| 23.   | Drive End Bearing Insulation or Grounding Device?                |  |
| 24.   | Drive End Wavy Washer/Snap-Ring Other Retention Device?          |  |
| 25.   | Drive End Bearing Condition                                      | contaminated   |
| 26.   | Opposite Drive End Bearing Number-                               | 6311 2RS   |
| 27.   | Opposite Drive End Bearing Qty.                                  | 1  |
| 28.   | Opposite Drive End Bearing Type                                  | (Ball) Ball Bearing                                    |
| 29.   | Opposite Drive End Lubrication Type                              | (Grease) Grease Lubricated                             |
| 30.   | Opposite Drive End Bearing Insulation or Grounding Device?       |  |
| 31.   | Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device? |  |
| 32.   | Opposite Drive End Bearing Condition                             | bad  |
| 33.   | Drive End Seal   |  |
| 34.   | Opposite Drive End Seal  |  |
| <b>Rotor Inspection</b>   |  |  |
| 35.   | Rotor Type/Material  | (Squirrel Aluminum) Squirrel<br>Cage Aluminum Die Cast |
| 36.   | Growler Test   | (Pass) Pass  |
| 37.   | Number of Rotor Bars   | 26   |
| 38.   | Rotor Condition  | good   |
| 39.   | List the Parts needed for the Repair Below                       |  |
|   | <i>Rewind, 6312 2RS, 6311 2RS, sleeve ODE end bell</i>           |  |
| 40.   | Signature of Technician that Disassembled Motor                  | David Maclin   |
|  |  |  |
| <b>Mechanical Fits- Rotor</b>   |  |  |
| 41.   | Shaft Runout   |  |
| 42.   | Rotor Runout   |  |
|   | Drive End Bearing Fit  | Rotor Body Opposite Drive End Bearing                  |

|  |  |                                |              |
|--|--|--------------------------------|--------------|
| 43.  | Coupling Fit Closest to Bearing Housing                      |                                |              |
|  | 0 Degrees  | 90 Degrees                     | 120 Degrees  |
| 44.  | Coupling Fit Closest to the end of the Shaft                 |                                |              |
|  | 0 Degrees  | 60 Degrees                     | 120 Degrees  |
| 45.  | Drive End Bearing Shaft Fit                                  |                                |              |
|  | 0 Degrees  | 60 Degrees                     | 120 Degrees  |
|  | 2.3628   | 2.3628                         | 2.3628       |
| 46.  | Drive End Bearing Shaft Fit Condition                        |                                | (P) Pass     |
| 47.  | Opposite Drive End Bearing Shaft Fit                         |                                |              |
|  | 0 Degrees  | 60 Degrees                     | 120 Degrees  |
|  | 2.1659   | 2.1659                         | 2.1659       |
| 48.  | Opposite Drive End Bearing Shaft Fit Condition               |                                | (P) Pass     |
| 49.  | Shaft Air Seal Fits  |                                |              |
|  | Drive End Air Seal   | Opposite Drive End Air Seal    |              |
| <b>Mechanical Fits- Bearing Housings</b>   |  |                                |              |
| 50.  | Drive End - Endbell Bearing Fit                              |                                |              |
|  | 0 Degrees  | 60 Degrees                     | 120 Degrees  |
|  | 5.1185   | 5.1185                         | 5.1185       |
| 51.  | Drive End - Endbell Bearing Fit Condition                    |                                | (P) Pass     |
| 52.  | Opposite Drive End - Endbell Bearing Fit                     |                                |              |
|  | 0 Degrees  | 60 Degrees                     | 120 Degrees  |
| 53.  | Opposite Drive End - Endbell Bearing Fit Condition           |                                | (F) Fail     |
| 54.  | Bearing Cap Condition  |                                |              |
|  | Drive End Bearing Cap  | Opposite Drive End Bearing Cap |              |
| 55.  | End Bell Air Seal Fits                                       |                                |              |
|  | Drive End Air Seal   | Opposite Drive End Air Seal    |              |
| 56.  | List Machine Work Needed Below<br><i>Sleeve ODE end bell</i> |                                |              |
| 57.  | Technician   |                                | David Maclin |
|  |  |                                |              |
| <b>Dynamic Balance Report</b>  |  |                                |              |
| 58.  | Rotor Weight and Balance Grade                               |                                |              |
|  | Rotor Weight   | Balance Grade                  |              |
| 59.  | Initial Balance Readings                                     |                                |              |
|  | Drive End  | Opposite Drive End             |              |

|  |                             |                            |
|--|-----------------------------|----------------------------|
| 60. Final Balance Readings                                   |                             |                            |
| Drive End  | Opposite Drive End          |                            |
| 61. Technician   |                             |                            |
| <b>Rewind</b>  |                             |                            |
| 62. Core Test Results - Watts loss per Pound                 |                             |                            |
| Pre-Burnout  | Post Burnout                |                            |
| 63. Core Hot Spot Test                                       |                             |                            |
| Pre-Burnout  | Post-Burnout                |                            |
| 64. Post Rewind Electrical Test- Insulation Resistance       |                             |                            |
| 65. Post Rewind Polarization Index                           |                             |                            |
| 66. Post Rewind Winding Resistance                           |                             |                            |
| 1-2  | 1-3                         | 2-3                        |
| 67. Post Rewind Surge Test                                   |                             |                            |
| 68. Post Rewind Hi-Pot                                       |                             |                            |
| 69. Technician   |                             |                            |
| <b>Root Cause of Failure</b>                                 |                             |                            |
| 70. Failure locations  |                             |                            |
| 71. Root cause of failure                                    |                             |                            |
| <b>Mechanical Fits- Rotor - Post Repair</b>                  |                             |                            |
| 72. Shaft Runout Post Repair                                 |                             |                            |
| 73. Rotor Runout Post Repair                                 |                             |                            |
| Drive End Bearing Fit  | Rotor Body                  | Opposite Drive End Bearing |
| 74. Coupling Fit Closest to Bearing Housing Post Repair      |                             |                            |
| 0 Degrees  | 90 Degrees                  | 120 Degrees                |
| 75. Coupling Fit Closest to the end of the Shaft Post Repair |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 76. Drive End Bearing Shaft Fit Post Repair                  |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 77. Opposite Drive End Bearing Shaft Fit Post Repair         |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |
| 78. Shaft Air Seal Fits Post Repair                          |                             |                            |
| Drive End Air Seal   | Opposite Drive End Air Seal |                            |
| 79. Shaft Repair Sign-off                                    |                             |                            |
| <b>Mechanical Fits- Bearing Housings - Post Repair</b>       |                             |                            |
| 80. Drive End - Endbell Bearing Fit Post Repair              |                             |                            |
| 0 Degrees  | 60 Degrees                  | 120 Degrees                |



|  |            |             |
|--|------------|-------------|
| 81. Opposite Drive End - Endbell Bearing Fit Post Repair |            |             |
| 0 Degrees  | 60 Degrees | 120 Degrees |
| 4.7247   | 4.7247     | 4.7247      |



|   |                                |            |
|---|--------------------------------|------------|
| 82. Bearing Cap Condition Post Repair                         |                                |            |
| Drive End Bearing Cap   | Opposite Drive End Bearing Cap |            |
| 83. End Bell Air Seal Fits Post Repair                        |                                |            |
| Drive End Air Seal  | Opposite Drive End Air Seal    |            |
| 84. End Bell Repair Sign-off                                  |                                |            |
| <b>Assembly</b>   |                                |            |
| 85. Photograph All Major Components prior to assembly         |                                |            |
| 86. Final Insulation Resistance Test                          |                                |            |
| 87. Assembled Shaft Endplay                                   |                                |            |
| 88. Assembled Shaft Runout                                    |                                |            |
| 89. Test Run Voltage  |                                |            |
| Volts   | Volts                          | Volts      |
| 90. Test Run Amperage   |                                |            |
| Amps  | Amps                           | Amps       |
| 91. Drive End Vibration Readings - Inches Per Second          |                                |            |
| Horizontal  | Vertical                       | Axial      |
| 92. Opposite Drive End Vibration Readings - Inches Per Second |                                |            |
| Horizontal  | Vertical                       | Axial      |
| 93. Ambient Temperature - Fahrenheit                          |                                |            |
| 94. Drive End Bearing Temps - Fahrenheit                      |                                |            |
| 5 Minutes   | 10 Minutes                     | 15 Minutes |
| 95. Opposite Drive End Bearing Temps - Fahrenheit             |                                |            |
| 5 Minutes   | 10 Minutes                     | 15 Minutes |
| 96. Final Test Run Sign-off                                   |                                |            |
| 97. Document Final Condition with Pictures after paint        |                                |            |

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#### 98. Final Pics and QC Review

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