Compressor Assembly Log (After Bearing Inspection)

Instructions*: Use the below log to check the items for bearing inspection. Insert values wherever applicable.*

Compressor Model: _____

Serial Number: _____

Check	Items to be Checked
	Suction Bearing and Disch Bearing inspected, moly-coated, and re-installed
	Thrust Bearing moly-coated and re-installed
	Thrust Collar inspected, moly-coated, and re-installed
	New Pump Bolt installed
	Torque value _____ (lbs)
	Pump runout: Volute 0.0. _____.000 in
	Pump runout: Probe 0.0. _____.000_in
	Pump runout: Face _____.000 in
	(*A dial indicator reading in .0001" must be used for the above)*
	Volute blued, checked, and re-installed
	Reverse Thrust checked, moly-coated, and re-installed
	Pump HSQ face free from high spots, clean, and installed
	Thrust end play (with HSQ torque)
	Gasket thickness _____
	Horizontal: Series 190 Gap Voltage: _____ -VDC *mv deviation/revolution _____ mv
	Vertical: Series 190 Gap Voltage: _____ -VDC *mv deviation/revolution _____ mv
	Arial: Series 300 Gap Voltage (with Thrust Collar on its forward thrust): _____ -VDC ** use a digital voltmeter or scope for deviation in mv while slow rolling drive shaft—axial monitor should read "zero" with rotor in its forward thrust*
	Probes connected and properly clamped inside Sump
	Jet Pump re-installed, clean, and tight
	Sump and seal reservoir clean
	Sump cover installed
	Drive Shaft Runout _____.00 inches

	Thread compound used
	Seal collar inspected and re-used
	“New” seal collar used
	New “O” ring installed (using Dow “O” ring grease)
	Seal collar properly seated on shaft
	Seal height (gasket surface to seal collar face with compressor on forward thrust) (A) _____ in
	Drawing specified seal height (B) _____ in
	A-B = _____ in Gaskets used _____ in
	Carbon seal assembly disassembled and cleaned
	Old carbon inspected and re-used
	New carbon installed
	New springs installed
	New “O” ring installed and lubricated (per above A-B)
	Gasket surfaces free from high spots, new gaskets sprayed with graphite, and seal surfaces generously lubricated with clean oil
	Seal housing torqued
	Torque value
	Compressor can be turned by hand and is free from tight spots