PdM Solutions of San Antonio, Inc

Vibration Analysis Summary

Plant Name	Sanderson Farm
Location	Palestine, TX
Date	July 15, 2025

Refrigeration compressors

Unit ID#	Equipment		Note
C-1	Vilter VMC440-8cylinders Motor: Baldor 125HP/1175 RPM		
C-2	Vilter VMC440-8cylinders Motor: Baldor 125HP/1175 RPM		
C-3	Vilter VMC440-16 cylinders Motor: Baldor 250HP/1175 RPM		
C-4	Vilter VMC440-8 cylinders Motor: Baldor 125HP/1175 RPM		
C-5	Vilter VMC440-16 cylinders Motor: Baldor 250HP/1175 RPM		
C-6	FES/GEA VRV2240S-28 Motor: WEG 500HP		Higher motor bearings noise observed. Grease them up.
C-7	FES/GEA VRV2240S-28 Motor: WEG 500HP		High compressor bearing noise observed (discharge side). Data showed signs of small defect(s) on bearings/bearing raceway.
C-8	FES/GEA VRV2240S-28 Motor: WEG 500HP		
C-9	FES/GEA VRV2240S-28 Motor: WEG 500HP		
C-10	FES/GEA VRV2240S-28 Motor: WEG 500HP		
C-11	Vilter VMC440-16 cylinders Motor: Baldor 250HP/1175 RPM		
C-12	Vilter VMC440-16 cylinders Motor: Baldor 250HP/1175 RPM		
C-13	FES/GEA VRV2240S-28 Motor: WEG 500HP		
B-1	Vilter VMC440-16 cylinders Motor: Baldor 1000HP/1175 RPM		
B-2	FES/GEA VRV309-28 Motor: WEG 150HP		
B-3	FES/GEA XAR-XA30S-28 Motor: WEG 300HP		

Warning Flag Notation

Flag Type	Reliability Assessments
Normal	Reliable
Showed sign of problem(s)	Reliable, but concern(s) existed.
Progresses problem(s)	Not reliable for continuous operation.
Critical	Unsafe to operate

Next Inspection: In 6 months. January 2026

PdM Solutions of San Antonio, Inc
Vibration analysis, Thermal imaging, oil analysis ,laser alignment
Phone:(210)492-8363 Fax:(509)275-7676

Vibration Analysis Cover Sheet

1. Machinery Information.

Plant	Sanderson Farms	Location.	Palestine, TX
Contract No.		Date	January 7, 2025
Unit ID#	C-6 FES/GEA	Refrigerant	NH3
Compressor Model	FES/GEA VRV2240S-28	S/N:V1996	
Suction Press/temp.	23.4 psig / 17.4 F	Discharge Press/temp	163 psig/ 150.5 F
Type of Oil Cooling	NH3 direct expansion	Oil Press/temp.	200 psig/ 120 F
Oil Injection	N/A	Compressor Load	77 %/ (525 amps)
Type of Oil	FES #1	Compressor Vi	3.2(3.37)
Compressor Run Hour	15741 (run 3220 hrs)	Compressor speed	3550 RPM
Driven by	Motor	Driver Gear	N/A
Pinion Gear	N/A	Motor manufacturer	WEG
Motor BHP	500 HP	Motor S/N	
Motor Bearing-Drive	6314C3	Motor Bearing-Open	6314C3
Data Taken by	SB/PdM Solutions	Data Analyses by	Hank/PdM Solutions
Service History July 2021:Repare compressor(thrust bearings)			

2. Result

		Comment
Compressor		
Motor		Motor bearings noise trending higher. Data showed lubrication issue. Grease up the bearings.
Alignment		

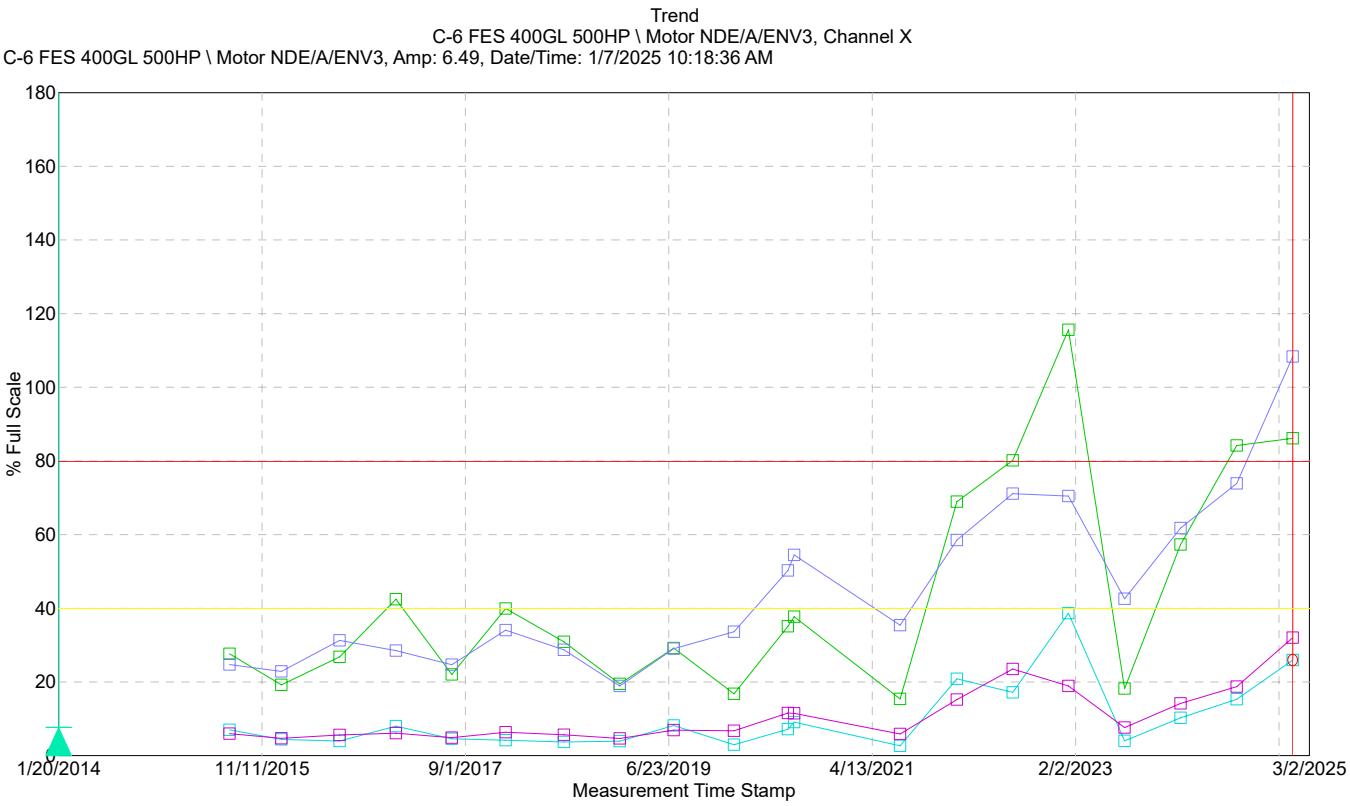
Warning Flag Notation

Flag Type	Reliability Assessments
Normal	Reliable
Showed a sign of problem(s)	Reliable, but concern(s) existed.
Progresses problem(s)	Not reliable for continuous operation.
Critical	Unsafe to operate

Inspection Note

3. Recommendation
   - Grease up the motor bearings.
   - Check vibration in 6 months
4. Attachments

5. Next Inspection. In (6) months, **July 2025**


Trend
C-6 FES 400GL 500HP \ Motor NDE/A/ENV3, Channel X
C-6 FES 400GL 500HP \ Motor NDE/A/ENV3, Amp: 6.49, Date/Time: 1/7/2025 10:18:36 AM
% Full Scale
180
160
140
120
100
80
60
40
20
0
1/20/2014
11/11/2015
9/1/2017
6/23/2019
4/13/2021
2/2/2023
3/2/2025
Measurement Time Stamp

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Vibration Analysis Cover Sheet

1. Machinery Information.

Plant	Sanderson Farms	Location.	Palestine, TX
Contract No.		Date	July 15, 2025
Unit ID#	C-7 FES/GEA	Refrigerant	NH3
Compressor Model	FES/GEA VRV2240S-28	S/N:V1994	
Suction Press/temp.	29.7 psig / 18 F	Discharge Press/temp	185 psig/ 129 F
Type of Oil Cooling	NH3 direct expansion	Oil Press/temp.	216 psig/ 128 F
Oil Injection	N/A	Compressor Load	74 %/ (406 amps)
Type of Oil	FES #1	Compressor Vi	3.0/3.38
Compressor Run Hour	7598 hrs	Compressor speed	3550 RPM
Driven by	Motor	Driver Gear	N/A
Pinion Gear	N/A	Motor manufacturer	WEG
Motor BHP	500 HP	Motor S/N	
Motor Bearing-Drive	6314C3	Motor Bearing-Open	6314C3
Data Taken by	SB/PdM Solutions	Data Analyses by	Hank/PdM Solutions
Service History Jan 2021:Repair compressor			

2. Result

		Comment
Compressor		High compressor bearing noise observed (discharge side). Data showed signs of small defect(s) on bearings/bearing raceway.
Motor		
Alignment		

Warning Flag Notation

Flag Type	Reliability Assessments
Normal	Reliable
Showed a sign of problem(s)	Reliable, but concern(s) existed.
Progresses problem(s)	Not reliable for continuous operation.
Critical	Unsafe to operate

Inspection Note

3. Recommendation
   - Monitor compressor for sudden noise levels changes and frequent shaft seal changes.
   - Check vibration in 6 months.

4. Attachments

5. Next Inspection. In (6) months, **January 2026**