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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 102317**

Prepared for Georges Inc

1810 S. St. Louis Street  
Batesville AR 72501

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Submersible Pump Repair Report - *Shop*

Submersible Pump Repair Report: *102317*

**1.0**

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Hi-Speed Industrial Service  
7030 Ryburn Dr  
Millington, Tn 38053  
901-873-5300

## Submersible Pump Repair Report

Georges Inc  
1810 S. St. Louis Street  
Batesville, AR 72501

FolderID: 102317  
FormID: 18973891

### Submersible Pump Repair Report

Location: Shop  
Serial Number: 102317  
Description: SUBMERSIBLE PUMP NO NP

HP: 7.5 (HP)  
Serial: C1962403  
V: 230460 (V)  
RPM: 1750 (RPM)  
Phase: 3

Priorities Found: ● 11 - High ● 37 - Good

### General

- Job Number **102317**
- Report Date



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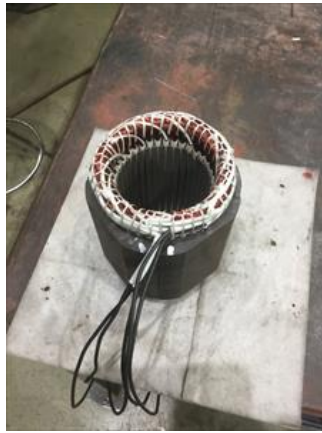
1.2



Machined new bushing.  
1.506  
Gary

3. Customer	Georges
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Initial Pump Inspection

4. Power Cord Wire Size	12 AWG
5. Power Cord # of Conductors	4
Power & Sensor cord combined.	



6. Power Cord Length	29 ft
----------------------	-------



7. Power Cord Condition

(F) Fail



8. Sensor Cord Wire Size 18 AWG

9. Sensor Cord # of Conductors 4

10. Sensor Cord Length ft

Combined with power cord.

11. Sensor Cord Condition (F) Fail

Sensor cord and power cord combination

12. Sensor Cord for Thermal Protection? (Y) Yes



13. Sensor Cord for Water Protection (Y) Yes

14. Bowl Condition (P) Pass

15. Impeller Condition (P) Pass

16. Number of Wear Rings 1

17. Wear Ring Condition (P) Pass

18. Wear Ring Size 0 in

19. Wear Ring Clearance to Impeller 0 in

20. Wear Ring Material brass

21. Seal Surfaces Condition (F) Fail

22. Seal Type Mechanical

23. Number of Seals 2

24. Seal Material on Rotary Face sic and carbon

25. Seal Material on Stationary Seat sic and ceramic

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26. Elastic Component Material	Buna
27. Seal OD	2.1265 mm
28. Seal ID	in
29. Seal Sleeve Material	



30. Seal Plate Condition	(P) Pass
31. Water Sensor in Seal Cavity?	(Y) Yes
32. Oil Filled Seal Cavity?	(Y) Yes
33. Oil Filled Stator?	(Y) Yes
<b>Initial Inspection</b>	
34. Number of Leads	3
35. Lead Length	Inches
36. Lead Size	
37. Lead Condition	(F) Fail
38. Lead Markings	na
39. Lead Size for Oil Filled Stator	0 AWG
40. Lug Size, Condition, and Type	16
41. Overload Required?	(Y) Yes
42. Winding RTD's	(N) No
43. Winding Rtd's Condition	(F) Fail
44. Shaft Run Out	0
45. Does Shaft Turn Freely	no
46. Does Shaft Have Visible Damage	no
47. Bearing Rtd's	(NA) Not Applicable
48. Bearing Rtd's Condition	(NA) Not Applicable
49. Contamination	Water contaminated
50. Frame Condition	(P) Pass
51. Fan Condition	(NA) Not Applicable

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52. Broken or missing components  
*Power cord connection, and power cord connectors.*



Initial Electric Test

53. Resistance to Ground	2000 Mohm
54. Winding Resistance 1-2	3.6 Ohm
55. Winding Resistance 2-3	3.6 Ohm's
56. Winding Resistance 1-3	3.6 Ohm's
57. Resistive Imbalance	0 %
58. Hi-Pot	0 Ua
59. Surge Test	(NA) Not Applicable
60. Stator Condition	rewind



# 61. Failure Location



## Initial Rotor Inspection

### 62. Rotor Type

squirrel cage aluminum



63. Air Gap <10% Variation	(P) Pass
64. Number of Rotor Bars	43
65. Number of Broken Rotor Bars	0
66. Growler Test	(P) Pass
67. Rotor Condition	(P) Pass

## Mechanical Inspection

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68. Bearing Manufacturer

FAG



69. Bearing DE Size

3308-BD-XL-TVH

70. Bearing DE Type

DBL wide, DBL row, ball bearing.

71. DE Bearing Qty.

1

72. Bearing ODE Size

6305



73. Bearing ODE Type

ball bearing



74. ODE Bearing Qty.

1

75. Insulated Bearing

No

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76.	Lubrication Type	oil
77.	Grease Condition	(NA) Not Applicable
78.	Bearing Retainers	(NA) Not Applicable
79.	Shaft Grounding Device	(NA) Not Applicable
80.	DE Seal	(Y) Yes
	Outer seal	
		
81.	DE Seal Type/Size	Seal OD 2.1265.
	Shaft seal surface is 1.5241. Carbon ceramic.	
82.	ODE Seal	(Y) Yes
	Inner seal.	
		
83.	ODE Seal Type/Size	SIC / SIC
	2.1265 OD. Of seal. Shaft seal surface is 1.5249	
<b>Root Cause of Failure</b>		
84.	Component Failure	seals

85. Cause of Failure

*Pump impeller was locked up with what appears to be an excessive amount of feathers. Additionally the power cord was forcibly yanked out of its receptacle, allowing moisture inside the stator causing the windings to short out. The drive end bearing was also locked up from contaminated lubrication.*



86. Comments

*None*

87. Service Technician

Terrence Holland

Machine Fit Inspection Report

● 88. Shaft Run Out	(P) Pass
89. Initial Shaft Run Out	0 "
90. Final Shaft Run Out	0 "



91. DE Bearing Shaft Fit

(F) Fail



92. DE Initial Shaft Bearing Fit Size

Measure 1	Measure 2	Measure 3
1.5745	1.5746	1.5745

93. DE Final Shaft Bearing Fit Size

Measure 1	Measure 2	Measure 3
1.5752	5.5753	5.5752



94. ODE Bearing Shaft Fit

(P) Pass

95. ODE Initial Shaft Bearing Fit Size

Measure 1	Measure 2	Measure 3
0.9845	0.9845	0.9844000000000001

96. ODE Final Shaft Bearing Fit Size

Measure 1	Measure 2	Measure 3
0	0	0

97. DE Air Seal Shaft Fit

(P) Pass

98. DE Air Seal Shaft Size

Initial	Final
0	0



99. ODE Air Seal Shaft Fit

(P) Pass

100. ODE Air Seal Shaft Size

Initial	Final
0	0

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101. DE Endbell Fit	(P) Pass		
102. DE Initial Endbell Fit Size			
Measure 1	Measure 2	Measure 3	
0	0	0	
103. DE Final Endbell Fit Size			
Measure 1	Measure 2	Measure 3	
0	0	0	
104. DE Endbell Fit Insulated	(N) No		
105. DE Endbell Air Seal Fit	(P) Pass		
106. DE Endbell Air Seal Fit Size			
Initial	Final		
0	0		
107. ODE Endbell Fit	(P) Pass		
108. ODE Initial Endbell Fit Size			
Measure 1	Measure 2	Measure 3	
0	0	0	
109. ODE Final Endbell Fit Size			
Measure 1	Measure 2	Measure 3	
0	0	0	
110. ODE Endbell Fit Insulated	(N) No		
111. ODE Endbell Air Seal Fit	(P) Pass		
112. ODE Endbell Air Seal Fit Size			
Initial	Final		
0	0		
113. Foot Flatness	(NA) Not Applicable		
114. Foot Condition	(NA) Not Applicable		
115. Flange Condition	(P) Pass		
116. Service Technician	Gary		
			
<b>Balancing Report</b>			
117. Balance Type	na		
118. Balance Operating Speed	0 RPM		
119. Start Left End	0 Mills		
120. Start Right End	0 Mills		
121. Balancing Specification	1.5		
122. Finish Left End	0 Mills		
123. Finish Right End	0 Mills		
124. Service Technician	Trevor Hall		
			
<b>Assembly and Final Test</b>			

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125. Rotor and Impeller Balanced	(N) No
Single flute impellor	
126. Stator Housing Refilled with Oil (if required)	(Y) Yes
127. Stator Pressure Test	



128. Seal Cavity Pressure Test	(P) Pass
129. Time Under Pressure	15 min
130. Overload Continuity	(P) Pass
131. Water Sensor Open?	(Y) Yes
132. Meggar Testing Reading	223988 Mohm
133. Surge Test	(P) Pass
RHR cowitness RW	



134. Hi-Pot	Ua	
 Na		
135. Winding Resistance		
1-2	2-3	3-1
3.299	3.29	3.293
 136. Test Run	(P) Pass	
 Witnessed by Chris Wiley		

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137. Test Run Voltage			
Phase A	Phase B	Phase C	
459	458	459	
138. Test Run Current			
Phase A	Phase B	Phase C	
7.9	7.9	7.3	
139. DE Vibration Reading			
Horizontal	Vertical	Axial	
0	0	0	
Single flute impeller			
140. ODE Vibration Reading			
Horizontal	Vertical	Axial	
0	0	0	
141. Ambient Temp at start of Test Run			74 Degrees F.
142. Temp at 5 minutes			0 Degrees F.
143. Temp at 10 minutes			0 Degrees F.
144. Temp at 15 minutes			0 Degrees F.
145. Temp at 20 minutes			0 Degrees F.
146. Temp at 25 minutes			0 Degrees F.
147. Temp at 30 minutes			0 Degrees F.
148. Temp at 35 minutes			0 Degrees F.
149. Temp at 40 minutes			0 Degrees F.
150. Temp at 45 minutes			0 Degrees F.
151. Temp at 50 minutes			0 Degrees F.
152. Temp at 55 minutes			0 Degrees F.
153. Temp at 60 minutes			0 Degrees F.
154. Motor Paint			(P) Pass
Checked by Chris Wiley			



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155. Service Technician

David Maclin

A handwritten signature in black ink, appearing to read 'David Maclin', is written across the signature line.





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13. **FORCE MAJEURE.** Neither party shall be responsible for any delay or failure in performance of any party of the quotation, purchase order or these Standard Terms and Conditions to the extent that such delays or failures are caused by fire, flood, earthquake, explosion, war, embargo, government requirement, civil or military authority, acts of God, or any other circumstances beyond its reasonable control and not involving any fault or negligence on the party affected ("Condition"). If any such Condition occurs, the party delayed or unable to perform shall promptly give written notice to the other party and, if such Condition remains at the end of thirty (30) days, the party affected by the other party's delay and inability to perform may elect to (i) terminate such order or part thereof, or (ii) suspend the order for the duration of the Condition, if the Buyer is the suspending party, buy elsewhere comparable material to be sold under the order and apply to any commitment the purchase price of such purchase, and resume performance of the order once the Condition ceases, with an option in the affected party to extend the period of this order up to the length of the time the Condition endures.
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