



**KEEPING YOUR FACILITY UP TO SPEED**  
— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 102389**

Prepared for Sage V Foods

5901 SLOAN DRIVE  
LITTLE ROCK AR 72206

# Table of Contents



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

## AC Inspection as Found

**Sage V Foods**  
5901 SLOAN DRIVE  
LITTLE ROCK, AR 72206

FolderID: 102389  
FormID: 19148715

### AC Inspection - Rev. 2

**Location:** MOTOR SHOP LR

**Serial Number:** 16282

**Description:** 7.5HP ZOELLER SUBMERSIBLE  
PUMP 1800RPM

**Hi-Speed Job Number:** 102389

**Manufacturer:** Other

**Product Number:** G6221-A

**Serial Number:** 16282

**HP/kW:** 7.5 (HP)

**RPM:** 1750 (RPM)

**Frame:** SUB PUMP

**Voltage:** 460

**Current:** 11

**Phase:** Three

**Hz:** 60 (Hz)

**Enclosure:** Submersible

**# of Leads:** 9

**J-box Included:** Complete

**Coupling/Sheave:** None

**Bearing RTDs:** No

**Stator RTDs:** No

**Repair Stage:** Final

**Rewind:** No


**Shaft Machined Fit Repairs  
Required:** Yes

**Bearing Housing Machined  
Fit Repairs Required:** No

**Heaters:** No

**Winding Type :** Random Wound

**Bearing Type:** Rolling Element

Priorities Found:  **8 - Good**

### Overall Condition

1. Report Date

 Na

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1.0

## 2. Nameplate Picture

Na



## 3. Photos of all six sides of the machine.

Na





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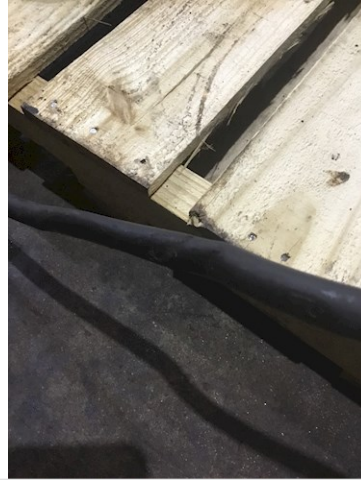
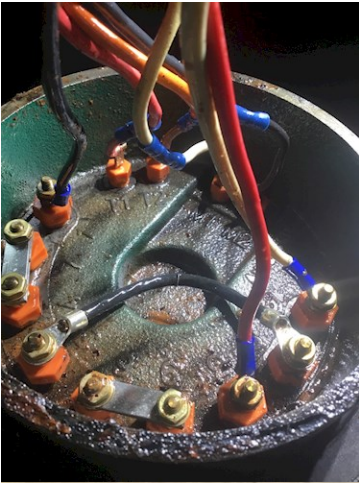
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1.2





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4. Describe the Overall Condition of the Equipment as Received

Na

#### Initial Mechanical/Electrical

☒ 5. Does Shaft Turn Freely? (Yes) Yes

6. Does Shaft Have Visible Damage? (Yes) Yes



7. Assembled Shaft Runout Inches

☐ Na

8. Assembled Shaft End Play inches

☐ Na

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9. Air Gap Variation <10%	
Na	
10. Lead Condition	
Replace power & sensor cords. 26'	
11. Lead Length	Inches
Cord length is 26' for sensor and power cord. Power cord 4C/12 awg. Sensor is 5C/18awg	
12. Lead Numbers	1-9
13. Frame Condition	pass
14. Fan Condition	(N) NA
15. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
16. Broken or Missing Components	pump handle bracket bent
17. Does it have Lugs?, If so what is the Stud Size?	(No) No

### Initial Electrical Inspection

18. Insulation Resistance/Megger	Megohms
Na	

Time	Test ID	Te...	Res...	Mo...	PI	DC
2/6/2024 2:07:55 PM	480V w/R...		PASS	PASS		
12/14/2023 2:5...	480V w/o...		PASS	PASS		PASS
12/14/2023 2:4...	480V w/o...					

Test Date	2/6/2024	12/14/2023	12/14/2023
Test Time	2:07:55 PM	2:57:44 PM	2:45:38 PM
Megohm Stat	PASS	PASS	No Test
Volts (V)	501	501	No Test
I (uA)	0.0312	0.0033	
Resist	16047	151351	
Alt 40°C	4883	40867	
PI Status	No Test	No Test	No Test
Volts (V)			
DA Ratio			
PI Ratio			
DC Status	No Test	PASS	No Test
Test Type		Step-Voltage	
Volts (V)		2000	
I (uA)		0.0294	

19. Winding Resistance			
1-2	1-3	2-3	

Na	
----	--

Time	Test ID	Te...	Res...	Mo...	PI	DC
2/6/2024 2:07:55 PM	480V w/R...		PASS	PASS		
12/14/2023 2:5...	480V w/o...		PASS	PASS		PASS
12/14/2023 2:4...	480V w/o...					

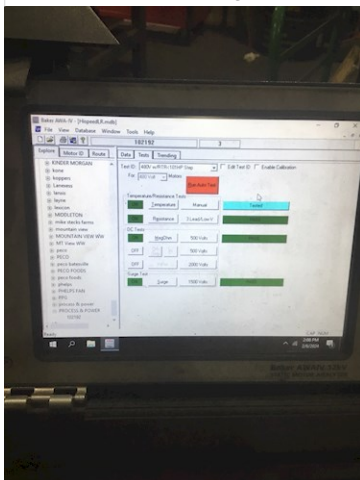
Test Date	2/6/2024	12/14/2023	12/14/2023
Test Time	2:07:55 PM	2:57:44 PM	2:45:38 PM
Temp Status	Tested	Tested	No Test
Temp (C)	22.8	21.1	
IR Temp Cor...	Thermoplastic	Thermoplastic	None
Resist Status	PASS	PASS	No Test
Bal L1 (Ohms)			
Bal L2 (Ohms)			
Bal L3 (Ohms)			
L1-L2 (Ohms)	3.713 Com 3.7...	0.0422 Com 0...	
L2-L3 (Ohms)	3.710 Com 3.7...	0.0425 Com 0...	
L3-L1 (Ohms)	3.719 Com 3.7...	0.0425 Com 0...	
Max Delta R %	0.239	0.846	
Coil 1 (Ohms)	5.565 Com 5.6...	0.0629 Com 0...	
Coil 2 (Ohms)	5.556 Com 5.6...	0.0618 Com 0...	

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20. Perform Surge Test

(P) Pass



Surge Status	No Test	PASS	No Test
Test Type		Step-Voltage	
Volts (V)		2000	
I(μA)		0.0259	
Resist		77361	
At 40°C		20888	
Surge Status	PASS	PASS	No Test
Peak Volt(V) L1	1510	1510	
Peak Volt(V) L2	1510	1510	
Peak Volt(V) L3	1510	1520	
Max P-P EAR(	0.3/0.2/0.2	0.3/0.3/0.2	
EAR 1-2/2-3/...	No Test	1/3/3	

21. Number of Stator Slots

36

22. Stator Condition

pass

23. Stator Thermistors/Ohms

no

24. Stator Overloads/Ohms

yes

### Mechanical Inspection

25. Drive End Bearing Brand

skf

26. Drive End Bearing Number-

3309 A/C3



27. Drive End Bearing Qty.

1

28. Drive End Bearing Type

(Ball) Ball Bearing

29. Drive End Lubrication Type

(Oil) Oil Lubricated

30. Drive End Bearing Insulation or Grounding Device?

Na

31. Drive End Wavy Washer/Snap-Ring Other Retention Device?

no

32. Drive End Bearing Condition

replace

33. Opposite Drive End Bearing Brand

koyo

34. Opposite Drive End Bearing Number-

6205



35. Opposite Drive End Bearing Qty.

1

36. Opposite Drive End Bearing Type

(Ball) Ball Bearing

37. Opposite Drive End Lubrication Type

(Oil) Oil Lubricated

38. Opposite Drive End Bearing Insulation or Grounding Device?

Na

39. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?

Na

40. Opposite Drive End Bearing Condition

replace

41. Drive End Seal

Na

42. Opposite Drive End Seal

Na

### Rotor Inspection

43. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast



44. Growler Test

(Pass) Pass

45. Number of Rotor Bars

44

46. Rotor Condition

Shaft seal surface worn.

47. List the Parts needed for the Repair Below

Na

48. Signature of Technician that Disassembled Motor

Terrence Holland


**Mechanical Fits- Rotor**

49. Shaft Runout inches

Na

50. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

Na

51. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

Na

52. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

Na

53. Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

1.7719

1.7718

1.7718

54. Drive End Bearing Shaft Fit Condition (P) Pass

55. Opposite Drive End Bearing Shaft Fit

0 Degrees

60 Degrees

120 Degrees

0.9848

0.9849

0.9847

56. Opposite Drive End Bearing Shaft Fit Condition (P) Pass

57. Shaft Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

Na

**Mechanical Fits- Bearing Housings**

58. Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

3.9377

3.9378

3.9378

59. Drive End - Endbell Bearing Fit Condition (P) Pass

60. Opposite Drive End - Endbell Bearing Fit

0 Degrees

60 Degrees

120 Degrees

2.0477

2.0476

2.0476


61. Opposite Drive End - Endbell Bearing Fit Condition (P) Pass

62. Bearing Cap Condition

Drive End Bearing Cap

Opposite Drive End Bearing Cap


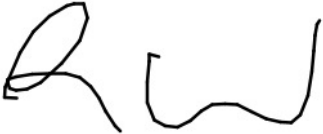
Na

63. End Bell Air Seal Fits			
Drive End Air Seal		Opposite Drive End Air Seal	
<div> <div></div> <div>Na</div> </div>			
64. List Machine Work Needed Below <i>Shaft seal surface.</i>			
65. Technician			Terrence Holland
			
<b>Root Cause of Failure</b>			
66. Failure locations <i>Seals failed. Power and sensor cords kinked</i>			
67. Root cause of failure <i>Seal failure from wear.</i>			
<b>Dynamic Balance Report</b>			
68. Rotor Weight and Balance Grade			
Rotor Weight		Balance Grade	
<div> <div></div> <div>Na</div> </div>			
69. Initial Balance Readings			
Drive End		Opposite Drive End	
<div> <div></div> <div>Na</div> </div>			
70. Final Balance Readings			
Drive End		Opposite Drive End	
<div> <div></div> <div>Na</div> </div>			
71. Technician			
<div> <div></div> <div>Na</div> </div>			
<b>Mechanical Fits- Rotor - Post Repair</b>			
72. Shaft Runout Post Repair			inches
<div> <div></div> <div>Na</div> </div>			
73. Rotor Runout Post Repair			
Drive End Bearing Fit		Rotor Body	Opposite Drive End Bearing
<div> <div></div> <div>Na</div> </div>			
74. Coupling Fit Closest to Bearing Housing Post Repair			
0 Degrees		90 Degrees	120 Degrees
<div> <div></div> <div>Na</div> </div>			
75. Coupling Fit Closest to the end of the Shaft Post Repair			
0 Degrees		60 Degrees	120 Degrees
<div> <div></div> <div>Na</div> </div>			



76. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
Na		
77. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
Na		
78. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
1.501		
Pump seal fit.		



79. Shaft Repair Sign-off	Gary
	
Assembly	
80. QC Check All Parts for Cleanliness Prior to Assembly	RW
	

81. Photograph All Major Components prior to assembly

(Complete) Complete





82. Final Insulation Resistance Test

9,030 Megohms

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83. Assembled Shaft Endplay	inches		
 Na			
84. Assembled Shaft Runout	inches		
 Na			
85. Test Run Voltage			
Volts	Volts	Volts	
460	459	458	
 Co witness DM			



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86. Test Run Amperage		
Amps	Amps	Amps
3.1	3	3.1



87. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
Na		
88. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
Na		
89. Ambient Temperature - Fahrenheit		
Na		
90. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
91. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
Na		
92. Document Final Condition with Pictures after paint		



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93. Final Pics and QC Review

RW

A handwritten signature consisting of the letters 'R' and 'W' in a stylized, cursive font, drawn in black ink.

Co witness DM



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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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