



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

LR Motor Shop Repairs

**Job Number 103357**

Prepared for Tyson Foods (10914)

1238 Market Street  
Clarksville AR 72830

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Submersible Pump Repair Report - *MOTOR SHOP*  
*LR*

Submersible Pump Repair Report: *WS5012D4*

**1.0**

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

## Submersible Pump Repair Report

Tyson Foods (10914)

1238 Market Street  
Clarksville, AR 72830

FolderID: 103357  
FormID: 21341904

### Submersible Pump Repair Report

Location: MOTOR SHOP LR

Serial Number: WS5012D4

Description: 5HP GOULD PUMP

HP: 5 (HP)

Model: M2344254

Serial: WS5012D4

V: 230 (V)

RPM: 1725 (RPM)

Hz: 60 (Hz)

Phase: 1

Priorities Found: ● 2 - High ● 37 - Good

### General

1. Job Number	103357
2. Report Date	08/20/2024
3. Customer	



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## Initial Pump Inspection

### 4. Power Cord Wire Size

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6. Power Cord Length

20 ft

☒ 7. Power Cord Condition

(P) Pass



8. Sensor Cord Wire Size

AWG

9. Sensor Cord # of Conductors

10. Sensor Cord Length

ft

11. Sensor Cord Condition

☒ 12. Sensor Cord for Thermal Protection?

(N) No

13. Sensor Cord for Water Protection

(NA) Not Applicable

☒ 14. Bowl Condition

(P) Pass





16. Number of Wear Rings	1
17. Wear Ring Condition	
18. Wear Ring Size	in
19. Wear Ring Clearance to Impeller	in
20. Wear Ring Material	
21. Seal Surfaces Condition	(F) Fail



Resurfaced  
Gary

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22. Seal Type	<b>Mechanical</b>
23. Number of Seals	<b>2</b>
24. Seal Material on Rotary Face	<b>tungsten carbon</b>
25. Seal Material on Stationary Seat	<b>tungsten ceramic</b>
26. Elastic Component Material	<b>Viton</b>
27. Seal OD	<b>1.7525 in</b>
28. Seal ID	<b>1.1498 in</b>
29. Seal Sleeve Material	
30. Seal Plate Condition	<b>(P) Pass</b>



31. Water Sensor in Seal Cavity?	<b>(N) No</b>
32. Oil Filled Seal Cavity?	<b>(Y) Yes</b>
33. Oil Filled Stator?	<b>(Y) Yes</b>

#### Initial Inspection

34. Number of Leads	<b>4</b>
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35. Lead Length	<b>8 Inches</b>
36. Lead Size	
37. Lead Condition	<b>(P) Pass</b>
38. Lead Markings	<b>none</b>
39. Lead Size for Oil Filled Stator	<b>AWG</b>
40. Lug Size, Condition, and Type	
41. Overload Required?	<b>(N) No</b>

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42. Winding RTD's	(N) No
43. Winding Rtd's Condition	
44. Shaft Run Out	0.002
45. Does Shaft Turn Freely	yes
46. Does Shaft Have Visible Damage	yes, seal surface worn
47. Bearing Rtd's	(N) No
48. Bearing Rtd's Condition	
49. Contamination	None
50. Frame Condition	(P) Pass
51. Fan Condition	
52. Broken or missing components	None
<b>Initial Electric Test</b>	
53. Resistance to Ground	2,000 Mohm
54. Winding Resistance 1-2	Ohm
55. Winding Resistance 2-3	Ohm's
56. Winding Resistance 1-3	Ohm's
57. Resistive Imbalance	%
58. Hi-Pot	Ua
59. Surge Test	
60. Stator Condition	pass
61. Failure Location	
Impeller was entangled with rag like materials.	
<b>Initial Rotor Inspection</b>	
62. Rotor Type	squirrel cage
63. Air Gap <10% Variation	(P) Pass
64. Number of Rotor Bars	48
65. Number of Broken Rotor Bars	0
66. Growler Test	(P) Pass
67. Rotor Condition	(P) Pass
<b>Mechanical Inspection</b>	
68. Bearing Manufacturer	koyo
69. Bearing DE Size	6206



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70. Bearing DE Type	ball bearing.
71. DE Bearing Qty.	1
72. Bearing ODE Size	6204
73. Bearing ODE Type	ball bearing



74. ODE Bearing Qty.	1
75. Insulated Bearing	no
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
81. DE Seal Type/Size	viton tungsten/ tungsten
82. ODE Seal	(Y) Yes
83. ODE Seal Type/Size	carbon ceramic

#### Root Cause of Failure

84. Component Failure	impeller
85. Cause of Failure	<i>Excessive amounts of rag like material entangled around the impeller</i>
86. Comments	<i>Motor test ran good.</i>
87. Service Technician	Terrence Holland

#### Machine Fit Inspection Report

88. Shaft Run Out	(P) Pass	
89. Initial Shaft Run Out	0.002 "	
90. Final Shaft Run Out	0 "	
91. DE Bearing Shaft Fit	(P) Pass	
92. DE Initial Shaft Bearing Fit Size		
Measure 1	Measure 2	Measure 3
1.1813	1.1812	1.1813

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93. DE Final Shaft Bearing Fit Size			
Measure 1	Measure 2	Measure 3	
0	0	0	
94. ODE Bearing Shaft Fit			(P) Pass
95. ODE Initial Shaft Bearing Fit Size			
Measure 1	Measure 2	Measure 3	
0.7877	0.7875	0.7875	
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		
101. DE Endbell Fit			(P) Pass
102. DE Initial Endbell Fit Size			
Measure 1	Measure 2	Measure 3	
2.4412	2.441	2.4412	
103. DE Final Endbell Fit Size			
Measure 1	Measure 2	Measure 3	
0	0	0	
104. DE Endbell Fit Insulated			(NA) Not Applicable
105. DE Endbell Air Seal Fit			(NA) Not Applicable
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	
1.8508	1.8507	1.8507	
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			(P) Pass
114. Foot Condition			(P) Pass
115. Flange Condition			(P) Pass
116. Service Technician			Terrence Holland

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*[Handwritten Signature]*

Witness: DWM

### Balancing Report

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	0
122. Finish Left End	0 Mills
123. Finish Right End	0 Mills
124. Service Technician	David Maclin

*[Handwritten Signature]*

### Assembly and Final Test

125. Rotor and Impeller Balanced

(NA) Not Applicable





126. Stator Housing Refilled with Oil (if required)	(Y) Yes	
127. Stator Pressure Test	(P) Pass	
128. Seal Cavity Pressure Test	(P) Pass	
129. Time Under Pressure	15 min	
130. Overload Continuity	(N) NA	
131. Water Sensor Open?	(NA) Not Applicable	
132. Meggar Testing Reading	2000 Mohm	
133. Surge Test	(NA) Not Applicable	
134. Hi-Pot	0 Ua	
135. Winding Resistance		
1-2	2-3	3-1
0	0	0
136. Test Run	(P) Pass	
137. Test Run Voltage		
Phase A	Phase B	Phase C
228	228	

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#### 138. Test Run Current

Phase A	Phase B	Phase C
7.8	7.7	



#### 139. DE Vibration Reading

Horizontal	Vertical	Axial
0.0545	0.0387	0.0456

#### 140. ODE Vibration Reading

Horizontal	Vertical	Axial
0.0143	0.0074	0.0362

#### 141. Ambient Temp at start of Test Run

70 Degrees F.

#### 142. Temp at 5 minutes

70 Degrees F.

#### 143. Temp at 10 minutes

70 Degrees F.

#### 144. Temp at 15 minutes

70 Degrees F.

#### 145. Temp at 20 minutes

70 Degrees F.

#### 146. Temp at 25 minutes

70 Degrees F.

#### 147. Temp at 30 minutes

70 Degrees F.

#### 148. Temp at 35 minutes

70 Degrees F.

#### 149. Temp at 40 minutes

70 Degrees F.

#### 150. Temp at 45 minutes

70 Degrees F.

#### 151. Temp at 50 minutes

70 Degrees F.

#### 152. Temp at 55 minutes

70 Degrees F.

#### 153. Temp at 60 minutes

70 Degrees F.

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154. Motor Paint  
Witnessed by Robert wiley

(P) Pass



155. Service Technician

David Maclin

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





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11. **GOVERNING LAW AND JURISDICTION.** Any controversy arising out of any quotation, the purchase order, the goods sold or delivered, repair or replacement thereof, or any services provided pursuant to any quotation or any purchase order, or these Standard Terms and Conditions shall be governed by the laws of the state of Tennessee without regard to any choice of law provisions and any cause of action related in any manner thereto shall be brought only in the state or federal courts of Shelby County, Tennessee.
12. **ABANDONED EQUIPMENT.** Hi-Speed requires that Buyer promptly pick up or provide shipment instructions for Buyer equipment or other Buyer property in Hi-Speed's possession. If equipment or other Buyer property is left with Hi-Speed and not picked up within six (6) months after Hi-Speed's final action related to the applicable property (e.g. evaluation, teardown, estimate, completion of services), Hi-Speed will consider such property abandoned and may dispose of it in accordance with applicable law. Buyer agrees to hold Hi-Speed harmless for any damage or claim for such abandoned property and acknowledges that Hi-Speed may discard or recycle it at Hi-Speed's sole and absolute discretion. Specifically, Hi-Speed may sell Buyer's abandoned property at a private or public sale and retain the proceeds to offset Hi-Speed's storage, inspection and servicing costs. For the avoidance of doubt, Hi-Speed reserves its statutory and other lawful liens for unpaid charges related to abandoned property.
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.
14. **NONWAIVER.** No course of dealing or failure of either party to strictly enforce any term, right, or condition of these Standard Terms and Conditions will be construed as a waiver of such term, right or condition. Any waiver by Hi-Speed will only be in writing and will waive no succeeding breach of a term, right or condition.
15. **ASSIGNMENT.** The rights and obligations of the parties shall neither be assigned nor delegated without the prior written consent of the other party. However, any party may assign or delegate its respective rights and obligations, in whole or in part, (i) to any subsidiary, (ii) pursuant to other financing, merger or reorganization or (iii) pursuant to any sale or transfer of substantially all of the assets of the assigning party. These Standard Terms and Conditions shall bind the heirs, successors and assigns of the parties hereto.
16. **NO INDIVIDUAL LIABILITY.** Notwithstanding any other agreement to the contrary, the Buyer agrees that in no event will the Buyer hold and Hi-Speed owner, director, officer or employee personally liable for unintentional tortious conduct or conduct that constitutes the breach of any contract between Hi-Speed and the Buyer, even if the Hi-Speed owner, director, officer or employee is or could be construed to be a party to such contract.