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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 103796**

Prepared for Arkansas Department of Correction (12097)

2540 Hwy 388  
Gould AR 71643

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Submersible Pump Repair Report - *LITTLE ROCK*  
*MOTOR SHOP*

Submersible Pump Repair Report: *53.095-0189*

**1.0**

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Hi-Speed Industrial Service  
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## Submersible Pump Repair Report

Arkansas Department of Correction (12097)  
2540 Hwy 388  
Gould, AR 71643

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FormID: 22351200

### Submersible Pump Repair Report

Location: LITTLE ROCK MOTOR SHOP

Serial Number: 53.095-0189

Description: 20HP FLYGT PUMP 1755RPM

Make: FLYGT

HP: 20 (HP)

Model: 153.095-1830032

Serial: 53.095-0189

V: 230 (V)

A: 26 (A)

RPM: 1755 (RPM)

Hz: 60 (Hz)

Phase: 3

Priorities Found: ● 6 - High ● 38 - Good

### General

1. Job Number

103796



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2. Report Date	12/03/2024
3. Customer	ADC
Initial Pump Inspection	

## 4. Power Cord Wire Size

12 AWG



## 5. Power Cord # of Conductors

4

## 6. Power Cord Length

32 ft

## 7. Power Cord Condition

(F) Fail

Cord needs to be replaced



## 8. Sensor Cord Wire Size

18 AWG

## 9. Sensor Cord # of Conductors

4

## 10. Sensor Cord Length

32 ft

## 11. Sensor Cord Condition

(F) Fail

## 12. Sensor Cord for Thermal Protection?

(NA) Not Applicable

## 13. Sensor Cord for Water Protection

(NA) Not Applicable

## 14. Bowl Condition

(P) Pass

## 15. Impeller Condition

(P) Pass

## 16. Number of Wear Rings

2

## 17. Wear Ring Condition

(P) Pass

## 18. Wear Ring Size

in

Na

## 19. Wear Ring Clearance to Impeller

in

Na

## 20. Wear Ring Material

















Na

## 21. Seal Surfaces Condition

(F) Fail

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22. Seal Type	<b>Mechanical</b>
23. Number of Seals	<b>2</b>
24. Seal Material on Rotary Face	<b>carbon</b>
25. Seal Material on Stationary Seat	<b>ceramic</b>
26. Elastic Component Material	<b>Buna</b>
27. Seal OD	<b>2.5 mm</b>
28. Seal ID	<b>1.75 in</b>
29. Seal Sleeve Material	
 <b>Na</b>	
 30. Seal Plate Condition	<b>(P) Pass</b>
 31. Water Sensor in Seal Cavity?	<b>(Y) Yes</b>
 32. Oil Filled Seal Cavity?	<b>(Y) Yes</b>
 33. Oil Filled Stator?	<b>(Y) Yes</b>
<b>Initial Inspection</b>	
34. Number of Leads	<b>12</b>
35. Lead Length	<b>24 Inches</b>
36. Lead Size	<b>12</b>
 37. Lead Condition	<b>(P) Pass</b>
38. Lead Markings	<b>1-12</b>
39. Lead Size for Oil Filled Stator	<b>AWG</b>
 <b>Na</b>	
40. Lug Size, Condition, and Type	
<b>Na</b>	
 41. Overload Required?	<b>(Y) Yes</b>
42. Winding RTD's	<b>(NA) Not Applicable</b>
 43. Winding Rtd's Condition	<b>(NA) Not Applicable</b>
44. Shaft Run Out	
 <b>Na</b>	
45. Does Shaft Turn Freely	<b>no</b>
46. Does Shaft Have Visible Damage	<b>no</b>
47. Bearing Rtd's	<b>(NA) Not Applicable</b>
 48. Bearing Rtd's Condition	<b>(NA) Not Applicable</b>
49. Contamination	
<b>Water and metal shavings</b>	
 50. Frame Condition	<b>(P) Pass</b>
 51. Fan Condition	<b>(NA) Not Applicable</b>
52. Broken or missing components	
<b>Na</b>	
<b>Initial Electric Test</b>	
53. Resistance to Ground	<b>7378 Mohm</b>
54. Winding Resistance 1-2	<b>Ohm</b>
 <b>Na</b>	
55. Winding Resistance 2-3	<b>Ohm's</b>
 <b>Na</b>	
56. Winding Resistance 1-3	<b>Ohm's</b>
 <b>Na</b>	

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57. Resistive Imbalance	%
Na	
58. Hi-Pot	0.0779 Ua
59. Surge Test	(P) Pass



60. Stator Condition	wash and dry
----------------------	--------------



61. Failure Location	Na
<b>Initial Rotor Inspection</b>	
62. Rotor Type	aluminum
63. Air Gap <10% Variation	(NA) Not Applicable
64. Number of Rotor Bars	30
65. Number of Broken Rotor Bars	0
66. Growler Test	(P) Pass

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**Mechanical Inspection**

68. Bearing Manufacturer	NTN
69. Bearing DE Size	63309 DWSR



Catastrophic failure


70. Bearing DE Type	BALL
71. DE Bearing Qty.	1
72. Bearing ODE Size	6306



Fatigue

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73. Bearing ODE Type	ball
74. ODE Bearing Qty.	1
75. Insulated Bearing	no
76. Lubrication Type	oil
77. Grease Condition	(NA) Not Applicable
78. Bearing Retainers	(N) No
79. Shaft Grounding Device	(NA) Not Applicable
80. DE Seal	(Y) Yes
81. DE Seal Type/Size	na
82. ODE Seal	(N) No
83. ODE Seal Type/Size	na
<b>Root Cause of Failure</b>	
84. Component Failure	bearing and seal
85. Cause of Failure	<i>Bearing housing egged shape cause the outer race to fail and breaking down the bearing taking out the lower seal locking the pump up. Had water in the lower housing</i>
86. Comments	<i>Shaft repair and bearing housing repair and new seals ,pump power cord</i>
87. Service Technician	RW
	
<b>Machine Fit Inspection Report</b>	
88. Shaft Run Out	(NA) Not Applicable
89. Initial Shaft Run Out	"
Na	
90. Final Shaft Run Out	"
Na	
91. DE Bearing Shaft Fit	(F) Fail
92. DE Initial Shaft Bearing Fit Size	
Measure 1	Measure 2
1.7733	1.7718
Needs repair	



93. DE Final Shaft Bearing Fit Size		
Measure 1	Measure 2	Measure 3
1.7722	1.7722	1.7722



Gary

94. ODE Bearing Shaft Fit (P) Pass		
95. ODE Initial Shaft Bearing Fit Size		
Measure 1	Measure 2	Measure 3
1.1813	1.1813	1.1813
96. ODE Final Shaft Bearing Fit Size		
Measure 1	Measure 2	Measure 3
97. DE Air Seal Shaft Fit (F) Fail		
Needs repair		










1.751  
1.751  
Repaired both seal fits.  
Gary



Replaced guide bushing.  
Gary

98.	DE Air Seal Shaft Size		
	Initial	Final	
	1.746	1.751	
99.	ODE Air Seal Shaft Fit		(NA) Not Applicable
100.	ODE Air Seal Shaft Size		
	Initial	Final	
101.	DE Endbell Fit		(F) Fail
102.	DE Initial Endbell Fit Size		
	Measure 1	Measure 2	Measure 3
	Needs replacing egg shaped		



103. DE Final Endbell Fit Size		
Measure 1	Measure 2	Measure 3
3.9378	3.9378	3.9378
<div>  Na </div>		
		
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	
<div>  Na </div>		
107. ODE Endbell Fit		(P) Pass
108. ODE Initial Endbell Fit Size		
Measure 1	Measure 2	Measure 3
2.8351	2.8351	2.8351
109. ODE Final Endbell Fit Size		
Measure 1	Measure 2	Measure 3
<div>  Na </div>		
110. ODE Endbell Fit Insulated		(NA) Not Applicable
111. ODE Endbell Air Seal Fit		(NA) Not Applicable
112. ODE Endbell Air Seal Fit Size		
Initial	Final	
<div>  Na </div>		
113. Foot Flatness		(NA) Not Applicable
114. Foot Condition		(NA) Not Applicable
115. Flange Condition		(P) Pass
116. Service Technician		RW
		
<div>  Co sign TRH </div>		

## Balancing Report

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117. Balance Type	Na	
118. Balance Operating Speed	Na	RPM
119. Start Left End	Na	Mills
120. Start Right End	Na	Mills
121. Balancing Specification	Na	
122. Finish Left End	Na	Mills
123. Finish Right End	Na	Mills
124. Service Technician	Na	
<b>Assembly and Final Test</b>		
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	10 min	
130. Overload Continuity	(P) Pass	
131. Water Sensor Open?	(Y) Yes	
132. Meggar Testing Reading	225.5 Mohm	



133. Surge Test	(P) Pass	
134. Hi-Pot	Ua	
135. Winding Resistance		
1-2	2-3	3-1
Na		
136. Test Run	(P) Pass	

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137. Test Run Voltage		
Phase A	Phase B	Phase C
457	454	459



Co sign SJ

138. Test Run Current		
Phase A	Phase B	Phase C
15.8	14.7	14.5



139. DE Vibration Reading		
Horizontal	Vertical	Axial
Na		
140. ODE Vibration Reading		
Horizontal	Vertical	Axial
Na		
141. Ambient Temp at start of Test Run		Degrees F.
Na		
142. Temp at 5 minutes		Degrees F.
Na		
143. Temp at 10 minutes		Degrees F.
Na		
144. Temp at 15 minutes		Degrees F.

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Na	
145. Temp at 20 minutes	Degrees F.
Na	
146. Temp at 25 minutes	Degrees F.
Na	
147. Temp at 30 minutes	Degrees F.
Na	
148. Temp at 35 minutes	Degrees F.
Na	
149. Temp at 40 minutes	Degrees F.
Na	
150. Temp at 45 minutes	Degrees F.
Na	
151. Temp at 50 minutes	Degrees F.
Na	
152. Temp at 55 minutes	Degrees F.
Na	
153. Temp at 60 minutes	Degrees F.
Na	
154. Motor Paint	(P) Pass



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155. Service Technician

RW

Co sign SJ



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2. **PRICE.** All quoted prices shall remain firm and binding for a period of thirty (30) days from the date of quotation or for the period specifically stated in the quotation. The price for any and all goods and/or services ordered or approved by Buyer after thirty (30) days from the date of any quotation are subject to any increase in price that may occur after the expiration of thirty (30) days from the issuance of the quotation and the date the Buyer releases any shipment.
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4. **BILLING AND PAYMENT TERMS.** Hi-Speed shall invoice Buyer for all goods and/or services as same are rendered at the address listed on the quotation. Payments for all goods and/or services shall be due thirty (30) days from the date of the current invoice or as otherwise set forth in the quotation. Late payments are subject to a late fee of 5% of the total invoice amount. Recurring late payments may lead to a deposit requirement on future services or sale of goods. Buyer shall be liable to Hi-Speed for any and all fees and expenses incurred by Hi-Speed to collect any invoices or to enforce these Standard Terms and Conditions, including but not limited to, attorney's fees.
5. **DELIVERY OF GOODS AND/OR SERVICES.** Unless otherwise identified in the quotation, all shipments are F.O.B. Hi-Speed's warehouse and the title to and all risk of loss with respect to any goods shipped shall pass to Buyer when such goods are delivered to the carrier at Hi-Speed's warehouse. Hi-Speed will use its best efforts to affect delivery by the date or dates specified in the quotation. However, Hi-Speed shall not be liable for delay in or failure to make shipment, or to perform services, by any identified date for any reason whatsoever, including but not limited to, causes beyond its reasonable control, such as strikes, fires, floods, epidemics, quarantines, restrictions, severe weather, embargos, acts of God, or public enemy, war, riot, delays in transportation or the inability to obtain necessary labor, materials or manufacturing facilities.
6. **DELIVERY SITE AND TIME FOR PERFORMANCE.** Hi-Speed and Buyer agree that time is of the essence for the purchase order and that Buyer shall fully cooperate with Hi-Speed in order to allow Hi-Speed full access to prosecute its work diligently and in an orderly manner. Buyer shall assist Hi-Speed in every way possible to avoid delaying, disrupting or interfering with the progress of Hi-Speed's work at the project site. In the event Hi-Speed's work is delayed, hindered, suspended, disrupted, re-sequenced or interfered with or rendered less efficient or more costly or adversely affected in any way as a result of acts or omissions of Buyer or other contractors or employees of Buyer or by any other reason beyond Hi-Speed's control and without the fault of Hi-Speed, then, in such event, Buyer shall be liable to Hi-Speed for any damages, additional costs, expenses, labor, materials, man hours, acceleration costs, overtime, additional jobsite overhead, extended home office overhead, and any and all other direct and indirect expenses of whatsoever nature or kind, caused in whole or in part, as a result of any of the above-referenced occurrences. Hi-Speed's project records will be the basis for computing the additional costs and damages of Hi-Speed's labor, materials, expenses and overhead related to such changes. BUYER WARRANTS THAT THE SITE FOR DELIVERY OR INSTALLATION OF ANY GOODS AND/OR FOR THE PERFORMANCE OF ANY SERVICES SHALL BE READY AND ADEQUATE FOR HI-SPEED'S DELIVERY OF GOODS AND/OR PERFORMANCE OF SERVICES AND THAT HI-SPEED SHALL HAVE FULL ACCESS THERETO, FREE OF ALL OBSTRUCTIONS. BUYER SHALL ASSUME ALL EXTRA COSTS ASSOCIATED WITH HI-SPEED'S INABILITY TO INSTALL ANY GOODS OR PERFORM ANY SERVICES AS A RESULT OF BUYER'S FAILURE TO COMPLY WITH THIS PROVISION. HI-SPEED MAY NOT INSPECT THE SITE PRIOR TO DELIVERY AND/OR INSTALLATION OF GOODS AND/OR PERFORMANCE OF SERVICES AND MAKES NO WARRANTY AS TO THE SUFFICIENCY OF THE SITE FOR THE DELIVERY AND/OR INSTALLATION OF GOODS AND/OR THE PERFORMANCE OF SERVICES AT SUCH SITE.
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8. **WARRANTIES.** Hi-Speed warrants that all goods shall conform in all material aspects to the goods identified in the quotation to Buyer and/or purchase order, and Hi-Speed makes to Buyer the manufacturer's express warranty for any goods sold to Buyer, which is offered by the manufacturer at the time of acceptance of any quotation by Buyer. This warranty is conditioned upon the installation, operation, and maintenance of the goods in accordance with the manufacturer's recommendations and/or standard industry practice and the goods at all times being operated or used under normal operating conditions for which they were designed. Hi-Speed, at its sole option, will repair or



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10. **SEVERABILITY.** The partial or complete invalidity of any provision of these Standard Terms and Conditions shall not affect the enforceability of the remainder of these Standard Terms and Conditions. If any provision is found to be invalid or unenforceable, that portion shall be modified to make it enforceable or shall be stricken and the remainder of these Standard Terms and Conditions shall enforced.
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.