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

Submersible Pump Repair Report

FolderID: 99451
FormID: 12992037

Sage V Foods
5901 SLOAN DRIVE
LITTLE ROCK, AR 72206

Priorities Found: **17 - Good**

General

1.	Job Number	**99451**
2.	Report Date	**03/03/2022**
3.	Customer	**Sage V Foods**

Name Plate Information

4.	Manufacturer	**Zoeller**	P1

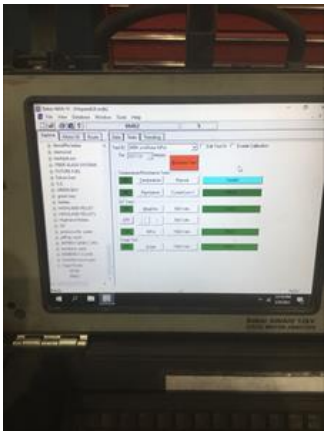
5.	Model	**G6221-A**
6.	Serial Number	**31785**
7.	Horsepower	**7.5**
8.	KW	
9.	Volts	**460**
10.	Amps	**11**
11.	RPM	**1750**
12.	Frame	
13.	Enclosure	
14.	Cycles	**60**
15.	Phase	**3**
16.	Service Factor	
17.	Motor Mount Position	
18.	Inlet Diameter	
19.	Outlet Diameter	
20.	Flow Rate	
21.	Pressure Head	

Initial Pump Inspection

22.	Power Cord Wire Size	
23.	Power Cord # of Conductors	
24.	Power Cord Length	**25 ft**
25.	Power Cord Condtion	
26.	Sensor Cord Wire Size	
27.	Sensor Cord # of Conductors	
28.	Sensor Cord Length	**25 ft**
29.	Sensor Cord Condition	
30.	Sensor Cord for Thermal Protection?	
31.	Sensor Cord for Water Protection	
32.	Bowl Condition	**(P) Pass**
33.	Impeller Condition	
34.	Number of Wear Rings	
35.	Wear Ring Condition	
36.	Wear Ring Size	
37.	Wear Ring Clearance to Impeller	
38.	Wear Ring Material	
39.	Seal Surfaces Condition	

	40.	Seal Type	
	41.	Number of Seals	**2**
	42.	Seal Material on Rotary Face	
	43.	Seal Material on Stationary Seat	
	44.	Elastic Component Material	
	45.	Seal OD	
	46.	Seal ID	
	47.	Seal Sleeve Material	
●	48.	Seal Plate Condition	**(P) Pass**
	49.	Water Sensor in Seal Cavity?	
●	50.	Oil Filled Seal Cavity?	**(Y) Yes**
●	51.	Oil Filled Stator?	**(Y) Yes**
Initial Inspection			
	52.	Number of Leads	**9**
	53.	Lead Length	
	54.	Lead Size	
●	55.	Lead Condition	**(P) Pass**
	56.	Lead Markings	
	57.	Lead Size for Oil Filled Stator	
	58.	Lug Size, Condition, and Type	
	59.	Overload Required?	
	60.	Winding RTD's	
	61.	Winding Rtd's Condition	
	62.	Shaft Run Out	
	63.	Does Shaft Turn Freely	
	64.	Does Shaft Have Visible Damage	
	65.	Bearing Rtd's	
	66.	Bearing Rtd's Condition	
	67.	Contamination ***Water***	
●	68.	Frame Condition	**(P) Pass**
●	69.	Fan Condition	**(NA) Not Applicable**
	70.	Broken or missing components	
Initial Electric Test			
	71.	Resistance to Ground	
	72.	Winding Resistance 1-2	
	73.	Winding Resistance 2-3	
	74.	Winding Resistance 1-3	
	75.	Resistive Imbalance	
	76.	Hi-Pot	

77.	Surge Test	**(P) Pass**	P63



78.	Stator Condition	**pass**	
79.	Failure Location		

Initial Rotor Inspection

80.	Rotor Type	**squirrel cage laminate**	
81.	Air Gap <10% Variation		
82.	Number of Rotor Bars		
83.	Number of Broken Rotor Bars		
84.	Growler Test	**(P) Pass**	
85.	Rotor Condition	**(P) Pass**	

Mechanical Inspection

86.	Bearing Manufacturer	**skf**	P10

87.	Bearing DE Size	**3309**	

	88.	Bearing DE Type	**double wide double row**

	89.	DE Bearing Qty.	**1**
	90.	Bearing ODE Size	**6205**
	91.	Bearing ODE Type	**open ball bearing**
	92.	ODE Bearing Qty.	**1**
	93.	Insulated Bearing	**no**
	94.	Lubrication Type	**oil**
●	95.	Grease Condition	**(NA) Not Applicable**
	96.	Bearing Retainers	**(NA) Not Applicable**
	97.	Shaft Grounding Device	**(NA) Not Applicable**
	98.	DE Seal	
	99.	DE Seal Type/Size	
	100.	ODE Seal	
	101.	ODE Seal Type/Size	

Root Cause of Failure

	102.	Component Failure	**seals**
	103.	Cause of Failure ***Wear***	
	104.	Comments	
	105.	Service Technician	**Terrence. Holland**

Machine Fit Inspection Report

	106.	Shaft Run Out	
	107.	Initial Shaft Run Out	
	108.	Final Shaft Run Out	
●	109.	DE Bearing Shaft Fit	**(P) Pass**
	110.	DE Initial Shaft Bearing Fit Size 1	**0.7723 "**
	111.	DE Initial Shaft Bearing Fit Size 2	**0.7723 "**
	112.	DE Initial Shaft Bearing Fit Size 3	**0.7724 "**
	113.	DE Finial Shaft Bearing Fit Size 1	
	114.	DE Finial Shaft Bearing Fit Size 2	

115.	DE Finial Shaft Bearing Fit Size 3	
116.	ODE Bearing Shaft Fit	**(P) Pass**
117.	ODE Initial Shaft Bearing Fit Size 1	**0.9847 "**
118.	ODE Initial Shaft Bearing Fit Size 2	**0.9845 "**
119.	ODE Initial Shaft Bearing Fit Size 3	**0.9846 "**
120.	ODE Finial Shaft Bearing Fit Size 1	
121.	ODE Finial Shaft Bearing Fit Size 2	
122.	ODE Finial Shaft Bearing Fit Size 3	
123.	DE Air Seal Shaft Fit	
124.	DE Initial Air Seal Shaft Size	
125.	DE Final Air Seal Shaft Size	
126.	ODE Air Seal Shaft Fit	
127.	ODE Initial Air Seal Shaft Size	
128.	ODE Final Air Seal Shaft Size	
129.	DE Endbell Fit	
130.	DE Initial Endbell Fit Size 1	
131.	DE Initial Endbell Fit Size 2	
132.	DE Initial Endbell Fit Size 3	
133.	DE Final Endbell Fit Size 1	
134.	DE Finial Endbell Fit Size 2	
135.	DE Final Endbell Fit Size 3	
136.	DE Endbell Fit Insulated	
137.	DE Endbell Air Seal Fit	
138.	Initial Endbell Air Seal Fit Size	
139.	Finial Endbell Air Seal Fit Size	
140.	ODE Endbell Fit	**(P) Pass**
141.	ODE Initial Endbell Fit Size 1	
142.	ODE Initial Endbell Fit Size 2	
143.	ODE Initial Endbell Fit Size 3	
144.	ODE Final Endbell Fit Size 1	
145.	ODE Final Endbell Fit Size 2	
146.	ODE Final Endbell Fit Size 3	
147.	ODE Endbell Fit Insulated	
148.	ODE Endbell Air Seal Fit	
149.	ODE Initial Endbell Seal Fit Size	
150.	ODE Finial Endbell Seal Fit Size	
151.	Foot Flatness	**(P) Pass**
152.	Foot Condition	**(P) Pass**
153.	Flange Condition	**(P) Pass**
154.	Service Technician	

Balancing Report

155.	Balance Type	
156.	Balance Operating Speed	
157.	Start Left End	
158.	Start Right End	
159.	Balancing Specification	
160.	Finish Left End	
161.	Finish Right End	

162.	Service Technician
Assembly and Final Test	
163.	Rotor and Impeller Balanced
164.	Stator Housing Refilled with Oil (if required)
165.	Stator Pressure Test
166.	Seal Cavity Pressure Test
167.	Time Under Pressure
168.	Overload Continuity
169.	Water Sensor Open?
170.	Meggar Testing Reading
171.	Surge Test
172.	Hi-Pot
173.	Winding Resistance 1-2
174.	Winding Resistance 2-3
175.	Winding Resistance 1-3
176.	Test Run
177.	Test Run Voltage Phase A
178.	Test Run Amps A
179.	Test Run Voltage Phase B
180.	Test Run Amps B
181.	Test Run Voltage Phase C
182.	Test Run Amps C
183.	DE Horizontal Vibration Reading
184.	DE Vertical Vibration Reading
185.	DE Axial Vibration Reading
186.	ODE Horizontal Vibration Reading
187.	ODE Vertical Vibration Reading
188.	ODE Axial Vibration Reading
189.	Ambient Temp at start of Test Run
190.	Temp at 5 minutes
191.	Temp at 10 minutes
192.	Temp at 15 minutes
193.	Temp at 20 minutes
194.	Temp at 25 minutes
195.	Temp at 30 minutes
196.	Temp at 35 minutes
197.	Temp at 40 minutes
198.	Temp at 45 minutes
199.	Temp at 50 minutes
200.	Temp at 55 minutes
201.	Temp at 60 minutes
202.	Motor Paint
203.	Service Technician