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

Submersible Pump Repair Report

FolderID: 99453
FormID: 12992401

Sage V Foods
5901 SLOAN DRIVE
LITTLE ROCK, AR 72206

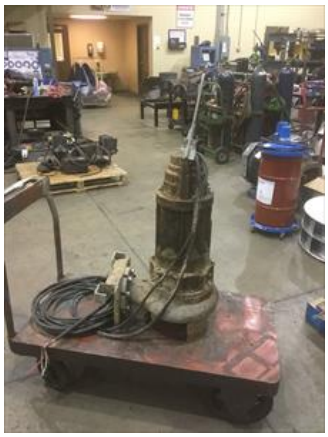
Priorities Found: **23 - Good**

General

1.	Job Number	**99453**
2.	Report Date	**03/14/2022**
3.	Customer	**Sage V Foods**

Name Plate Information

4.	Manufacturer	**Zoeller**	P1

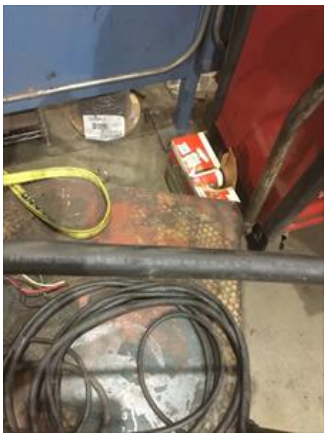


5.	Model	**G6221-A**
6.	Serial Number	**16279**
7.	Horsepower	**7.5**
8.	KW	
9.	Volts	**460**
10.	Amps	**11**
11.	RPM	**1750**
12.	Frame	
13.	Enclosure	
14.	Cycles	**60**
15.	Phase	**3**

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	**12 AWG**	P8



23.	Power Cord # of Conductors	**4**	
24.	Power Cord Length	**28 ft**	
25.	Power Cord Condtion	**(P) Pass**	
26.	Sensor Cord Wire Size	**18 AWG**	P43

27.	Sensor Cord # of Conductors	**5**	
28.	Sensor Cord Length	**28 ft**	
29.	Sensor Cord Condition	**(P) Pass**	
30.	Sensor Cord for Thermal Protection?		
31.	Sensor Cord for Water Protection	**(Y) Yes**	

32.	Bowl Condition	**(P) Pass**	P90

33.	Impeller Condition	**(P) Pass**	
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	**carbon**	
43.	Seal Material on Stationary Seat	**ceramic**	
44.	Elastic Component Material		
45.	Seal OD	**2.125 mm**	
46.	Seal ID	**0.5014999999999999 in**	
47.	Seal Sleeve Material		
48.	Seal Plate Condition	**(P) Pass**	P159

49.	Water Sensor in Seal Cavity?	**(Y) Yes**	
50.	Oil Filled Seal Cavity?	**(Y) Yes**	
51.	Oil Filled Stator?	**(Y) Yes**	

Initial Inspection

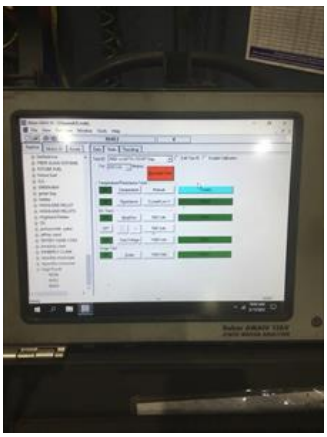
52.	Number of Leads	**3**	
53.	Lead Length	**11 Inches**	

	54.	Lead Size		
●	55.	Lead Condition	**(P) Pass**	P47

	56.	Lead Markings	**1-3**	
	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	**0.001**	
	63.	Does Shaft Turn Freely	**yes**	
	64.	Does Shaft Have Visible Damage	**no**	P115

	65.	Bearing Rtd's		
	66.	Bearing Rtd's Condition		
	67.	Contamination		
		Water		
●	68.	Frame Condition	**(P) Pass**	P136

	69.	Fan Condition	**(NA) Not Applicable**	
	70.	Broken or missing components ***Cord cap seal plate has broken piece. Needs welded back in place***		
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**	P3

81.	Air Gap <10% Variation		
82.	Number of Rotor Bars		
83.	Number of Broken Rotor Bars	**0**	
84.	Growler Test		
85.	Rotor Condition	**(P) Pass**	P51

Mechanical Inspection

86.	Bearing Manufacturer	**skf**	
87.	Bearing DE Size	**3309 A-2Z/C3**	P19

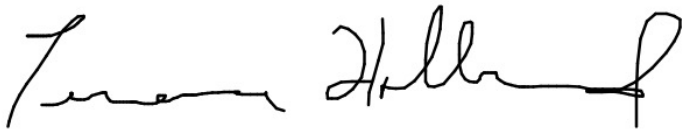
88.	Bearing DE Type	**double row/double wide**	
89.	DE Bearing Qty.	**1**	

90.	Bearing ODE Size	**6205**	
91.	Bearing ODE Type	**open ball bearing**	P55

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	**seal failure**	
103.	Cause of Failure ***Normal wear.***		
104.	Comments		
105.	Service Technician	**Terrence. Holland**	



Machine Fit Inspection Report

106.	Shaft Run Out	**(P) Pass**	
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	**1.7724 "**	
111.	DE Initial Shaft Bearing Fit Size 2	**1.7723 "**	
112.	DE Initial Shaft Bearing Fit Size 3	**1.7724 "**	
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	**0.9844000000000001 "**
	118.	ODE Initial Shaft Bearing Fit Size 2	**0.9844000000000001 "**
	119.	ODE Initial Shaft Bearing Fit Size 3	**0.9844000000000001 "**
	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	**(P) Pass**
	130.	DE Initial Endbell Fit Size 1	**3.9379 "**
	131.	DE Initial Endbell Fit Size 2	**3.9379 "**
	132.	DE Initial Endbell Fit Size 3	**3.9379 "**
	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	**(NA) Not Applicable**
	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	**2.0475 "**
	142.	ODE Initial Endbell Fit Size 2	**2.0474 "**
	143.	ODE Initial Endbell Fit Size 3	**2.0475 "**
	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	**(NA) Not Applicable**
●	152.	Foot Condition	**(NA) Not Applicable**
●	153.	Flange Condition	**(P) Pass**
	154.	Service Technician	**Terrence. Holland**

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