



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

Submersible Pump Repair Report

FolderID: 99564
FormID: 13176569

Sage V Foods
5901 SLOAN DRIVE
LITTLE ROCK, AR 72206

Priorities Found: ● 3 - High ● 17 - Good

General

1. Job Number	99564
2. Report Date	03/25/2022
3. Customer	Sage V Foods

Name Plate Information



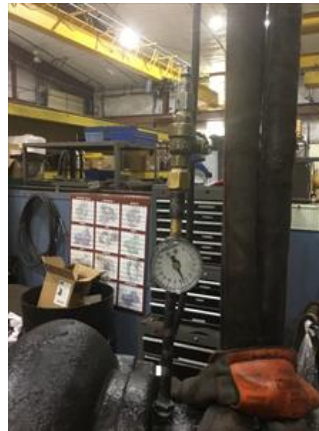
4. Manufacturer	Pentair	P1
Hydromatic		






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5.	Model	S4SD750M4-4
6.	Serial Number	10556507
7.	Horsepower	7.5
8.	KW	
9.	Volts	460
10.	Amps	12.6 Amps
11.	RPM	1750
12.	Frame	Sub Pump
13.	Enclosure	Sub Pump
14.	Cycles	60
15.	Phase	3
16.	Service Factor	1.2
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
23.	Power Cord # of Conductors	4
24.	Power Cord Length	42 ft
 25.	Power Cord Condition	(F) Fail
		P39
		
26.	Sensor Cord Wire Size	16 AWG

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27. Sensor Cord # of Conductors	4	
28. Sensor Cord Length	42 ft	
● 29. Sensor Cord Condition	(F) Fail	P70
		
30. Sensor Cord for Thermal Protection?		
31. Sensor Cord for Water Protection		
● 32. Bowl Condition	(P) Pass	P90
		
● 33. Impeller Condition	(P) Pass	P95
 		

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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	P135





42.	Seal Material on Rotary Face	carbon
43.	Seal Material on Stationary Seat	ceramic
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
53.	Lead Length
54.	Lead Size
55.	Lead Condition

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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	no	
64.	Does Shaft Have Visible Damage	yes: broken.	P115
			
65.	Bearing Rtd's		
66.	Bearing Rtd's Condition		
67.	Contamination <i>Water</i>		
68.	Frame Condition	(P) Pass	P136
			
69.	Fan Condition	(NA) Not Applicable	
70.	Broken or missing components <i>D.E shaft broken. Impeller mount bolt broken Machined new shaft.</i>		P144

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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	(NA) Not Applicable	
78.	Stator Condition	rewind	
79.	Failure Location	windings	P75






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	0	
84.	Growler Test		
85.	Rotor Condition	(F) Fail	

Mechanical Inspection



86.	Bearing Manufacturer	fag	
87.	Bearing DE Size	6307	

88. Bearing DE Type	open ball bearing	P22
		
89. DE Bearing Qty.	1	
90. Bearing ODE Size	6303	P48
		
91. Bearing ODE Type	open ball bearing	P55
		
92. ODE Bearing Qty.	1	
93. Insulated Bearing	no	
94. Lubrication Type	oil	
<input checked="" type="radio"/> 95. Grease Condition	(NA) Not Applicable	
96. Bearing Retainers	(NA) Not Applicable	
97. Shaft Grounding Device	(NA) Not Applicable	
<input checked="" type="radio"/> 98. DE Seal	(Y) Yes	P98

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99. DE Seal Type/Size

100. ODE Seal

101. ODE Seal Type/Size

Root Cause of Failure

102. Component Failure

**rewind, replace broken shaft,
and both cords.**

103. Cause of Failure

Impeller mount bolt sheared off

104. Comments

Swapped original rotor from this pump to another pump for rush job.

105. Service Technician

Terrence. Holland**Machine Fit Inspection Report**

● 106. Shaft Run Out

(NA) Not Applicable*Replace broken shaft*

107. Initial Shaft Run Out

108. Final Shaft Run Out

109. DE Bearing Shaft Fit

110. DE Initial Shaft Bearing Fit Size 1

111. DE Initial Shaft Bearing Fit Size 2

112. DE Initial Shaft Bearing Fit Size 3

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

117. ODE Initial Shaft Bearing Fit Size 1

118. ODE Initial Shaft Bearing Fit Size 2


119. ODE Initial Shaft Bearing Fit Size 3

120. ODE Finial Shaft Bearing Fit Size 1

121. ODE Finial Shaft Bearing Fit Size 2

122. ODE Finial Shaft Bearing Fit Size 3

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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	
131.	DE Initial Endbell Fit Size 2	
132.	DE Initial Endbell Fit Size 3	
133.	DE Final Endbell Fit Size 1	
134.	DE Final 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.	Final 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	(NA) Not Applicable
148.	ODE Endbell Air Seal Fit	
149.	ODE Initial Endbell Seal Fit Size	
150.	ODE Final Endbell Seal Fit Size	
● 151.	Foot Flatness	(P) Pass
● 152.	Foot Condition	(P) Pass
● 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

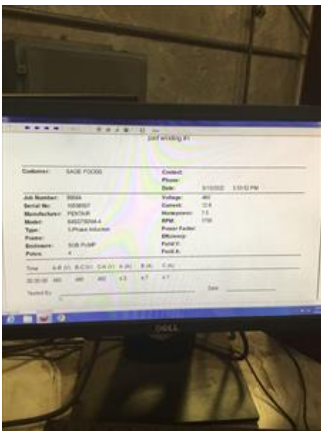


163.	Rotor and Impeller Balanced
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164.	Stator Housing Refilled with Oil (if required)		
165.	Stator Pressure Test		
166.	Seal Cavity Pressure Test		
167.	Time Under Pressure		
168.	Overload Continuity		
169.	Water Sensor Open?		
170.	Megger Testing 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	(P) Pass	P186

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203. Service Technician