



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

Motor Shop Repairs

Job Number 99785

Prepared for George's Inc

1810 S. St. Louis Street
Batesville AR 72501

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Submersible Pump Repair Report - *Shop*

Submersible Pump Repair Report: *6SE2004*

1.0

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

Submersible Pump Repair Report

George's Inc
1810 S. St. Louis Street
Batesville, AR 72501

FolderID: 99785
FormID: 13560557

Submersible Pump Repair Report

Location: Shop
Serial Number: 6SE2004
Description: 20HP Barnes Pump NO NP

Make: Barnes
HP: 20 (HP)
Model: 6SE2004
Serial: 6SE2004
Phase: 3

Priorities Found: ● 7 - High ● 24 - Good

General

1. Job Number	99785
2. Report Date	05/11/2022
3. Customer	George's



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1.1



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Initial Pump Inspection

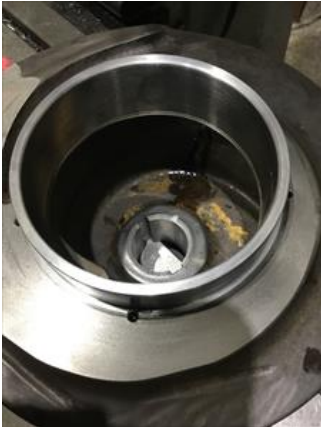
4. Power Cord Wire Size	2 AWG
5. Power Cord # of Conductors	4
6. Power Cord Length	32 ft
7. Power Cord Condition	(F) Fail
8. Sensor Cord Wire Size	16 AWG
9. Sensor Cord # of Conductors	5
10. Sensor Cord Length	32 ft
11. Sensor Cord Condition	(F) Fail
12. Sensor Cord for Thermal Protection?	(Y) Yes
13. Sensor Cord for Water Protection	(Y) Yes
14. Bowl Condition	

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15. Impeller Condition (F) Fail

Loose impeller to shaft fit. Wear ring surface on impeller broken.

Bored shaft fit to 1.750 and cut new key way. Sleeved wear ring surface.



16. Number of Wear Rings	1
17. Wear Ring Condition	(F) Fail
18. Wear Ring Size	
19. Wear Ring Clearance to Impeller	
20. Wear Ring Material	
21. Seal Surfaces Condition	
22. Seal Type	
23. Number of Seals	
24. Seal Material on Rotary Face	
25. Seal Material on Stationary Seat	
26. Elastic Component Material	
27. Seal OD	
28. Seal ID	
29. Seal Sleeve Material	
30. Seal Plate Condition	(P) Pass
31. Water Sensor in Seal Cavity?	(Y) Yes
32. Oil Filled Seal Cavity?	(Y) Yes
33. Oil Filled Stator?	(Y) Yes
Initial Inspection	
34. Number of Leads	3
35. Lead Length	Inches
36. Lead Size	
37. Lead Condition	(P) Pass
38. Lead Markings	
39. Lead Size for Oil Filled Stator	
40. Lug Size, Condition, and Type	
41. Overload Required?	
42. Winding RTD's	
43. Winding Rtd's Condition	
44. Shaft Run Out	
45. Does Shaft Turn Freely	no

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46. Does Shaft Have Visible Damage

yes

Shaft key way wallowed. Outer Seal surface worn



47. Bearing Rtd's

48. Bearing Rtd's Condition

49. Contamination

Water from seal failure.

50. Frame Condition

(P) Pass

51. Fan Condition

(NA) Not Applicable

52. Broken or missing components

Impeller worn. Replace.

Initial Electric Test

53. Resistance to Ground

54. Winding Resistance 1-2

55. Winding Resistance 2-3

56. Winding Resistance 1-3

57. Resistive Imbalance

58. Hi-Pot

59. Surge Test

(F) Fail



60. Stator Condition

61. Failure Location

Initial Rotor Inspection

62. Rotor Type

squirrel cage laminate 56 bars



63. Air Gap <10% Variation

64. Number of Rotor Bars

56




65. Number of Broken Rotor Bars

0

66. Growler Test

(P) Pass

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67. Rotor Condition	(P) Pass
Mechanical Inspection	
68. Bearing Manufacturer	koyo/MRC
69. Bearing DE Size	5310 dbl wide/dbl row
	
70. Bearing DE Type	
	
71. DE Bearing Qty.	1
72. Bearing ODE Size	207 M
	
73. Bearing ODE Type	

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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	
82. ODE Seal	
83. ODE Seal Type/Size	
Root Cause of Failure	
84. Component Failure	Windings/impeller
85. Cause of Failure	<i>Found impeller mount bolt loose enough to move impeller up and down on the shaft by hand which caused seals to fail and allow water to enter the stator housing. Electrical test after wash and bake shows coil to coil short between 1&2, and 1&3.</i>
86. Comments	<i>Shaft work needed on key way and seal surfaces.</i>

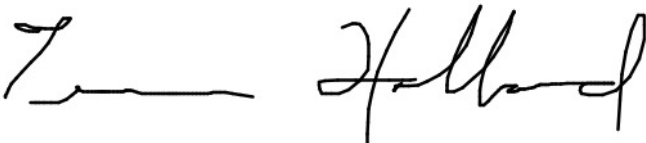



Machine Fit Inspection Report

88.	Shaft Run Out	(F) Fail	
89.	Initial Shaft Run Out	0.01 "	
90.	Final Shaft Run Out		
91.	DE Bearing Shaft Fit	(P) Pass	
92.	DE Initial Shaft Bearing Fit Size		
	Measure 1	Measure 2	Measure 3
	1.9689	1.9687	1.9688
93.	DE Final Shaft Bearing Fit Size		
	Measure 1	Measure 2	Measure 3
94.	ODE Bearing Shaft Fit	(P) Pass	
95.	ODE Initial Shaft Bearing Fit Size		
	Measure 1	Measure 2	Measure 3
	1.3781	1.3781	1.3782
96.	ODE Final Shaft Bearing Fit Size		
	Measure 1	Measure 2	Measure 3
97.	DE Air Seal Shaft Fit		
98.	DE Air Seal Shaft Size		
	Initial	Final	
99.	ODE Air Seal Shaft Fit		
100.	ODE Air Seal Shaft Size		
	Initial	Final	
101.	DE Endbell Fit	(P) Pass	
102.	DE Initial Endbell Fit Size		
	Measure 1	Measure 2	Measure 3
	4.3309	4.331	4.309
103.	DE Final Endbell Fit Size		
	Measure 1	Measure 2	Measure 3
104.	DE Endbell Fit Insulated	(NA) Not Applicable	
105.	DE Endbell Air Seal Fit		
106.	DE Endbell Air Seal Fit Size		
	Initial	Final	
107.	ODE Endbell Fit	(F) Fail	
108.	ODE Initial Endbell Fit Size		
	Measure 1	Measure 2	Measure 3
	2.8356	2.8356	2.8354

109. ODE Final Endbell Fit Size		
Measure 1	Measure 2	Measure 3
2.835	2.835	2.8351



110. ODE Endbell Fit Insulated	(NA) Not Applicable
111. ODE Endbell Air Seal Fit	
112. ODE Endbell Air Seal Fit Size	
Initial	Final
113. Foot Flatness	(P) Pass
114. Foot Condition	(P) Pass
115. Flange Condition	(P) Pass
116. Service Technician	Terrence Holland
	

Balancing Report

117. Balance Type



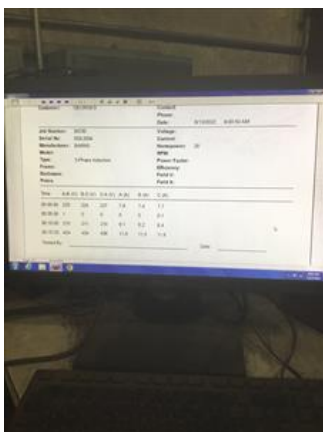
118. Balance Operating Speed
119. Start Left End
120. Start Right End
121. Balancing Specification

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122. Finish Left End	
123. Finish Right End	
124. Service Technician	
Assembly and Final Test	
125. Rotor and Impeller Balanced	
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	30 min
130. Overload Continuity	
131. Water Sensor Open?	
132. Meggar Testing Reading	4,500 Mohm



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



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137. Test Run Voltage		
Phase A	Phase B	Phase C
453	454	456
<div>   </div>		
138. Test Run Current		
Phase A	Phase B	Phase C
11.6	11.5	11.6
139. DE Vibration Reading		
Horizontal	Vertical	Axial
140. ODE Vibration Reading		
Horizontal	Vertical	Axial
141. Ambient Temp at start of Test Run		
142. Temp at 5 minutes		
143. Temp at 10 minutes		
144. Temp at 15 minutes		
145. Temp at 20 minutes		
146. Temp at 25 minutes		
147. Temp at 30 minutes		
148. Temp at 35 minutes		
149. Temp at 40 minutes		
150. Temp at 45 minutes		
151. Temp at 50 minutes		
152. Temp at 55 minutes		
153. Temp at 60 minutes		
● 154. Motor Paint	(P) Pass	

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155. Service Technician

RW

RW



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1. **APPLICABILITY.** The sale of any and all goods and/or services by Mock, Inc. d/b/a Hi-Speed Industrial Service ("Hi-Speed") shall be specifically conditioned upon and subject to the following terms and conditions which are incorporated by reference into any contracts and purchase orders with Hi-Speed, and which shall form and become a part of any agreement related thereto. Buyer's acceptance of any offer or quotation made by Hi-Speed for sale of any goods or services is expressly made subject to the terms and conditions set forth herein and to be so effective, Buyer need not sign or approve these Terms and Conditions to be bound hereunder provided a copy of same is provided to Buyer through any means. None of the terms and conditions contained herein may be added to, expanded, changed, modified, superseded or otherwise altered except as revised in writing and duly executed by Hi-Speed, and all orders received by Hi-Speed shall be governed only by the terms and conditions contained herein, notwithstanding any terms, conditions or provisions of any purchase order, release order, authorization or any other form issued by the Buyer. Hi-Speed hereby objects to any additional, modified, changed, deleted, altered or other terms and conditions not contained herein and notifies Buyer that any such terms or provisions are expressly rejected by Hi-Speed.
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.
3. **SCOPE OF GOODS AND/OR SERVICES.** The goods and/or services provided by Hi-Speed pursuant to any quotation shall be limited exclusively to those goods and/or services expressly identified therein. Hi-Speed does not assume any responsibility and/or liability for the failure to provide any other goods and/or services not identified in any quotation. Modifications, additions or deletions to or from the scope referenced in any quotation shall only be effective if evidenced in writing and signed by Hi-Speed. The sale of any of all goods and/or services affected by such modification, addition or deletion shall be subject to these same Standard Terms and Conditions whether or not referenced therein.
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

replace any defective or non-conforming goods in accordance with the applicable manufacturer's warranty. Warranty for any defective or incorrect parts is limited to the repair or replacement of those parts. Hi-Speed warrants that all services will conform in all material respects to the description of services identified in the quotation and will be performed in a good and workmanlike manner in accordance with industry practices and standards. Should the services be reasonably rejected or not conform with the foregoing warranties, Hi-Speed shall, at its sole cost, re-perform the defective or nonconforming services. Notwithstanding the foregoing, these warranties do not extend to goods or services to the extent that such goods have been subject to misuse, neglect or abuse not caused by Hi-Speed or have been used in violation of the approved written instructions furnished to Buyer. THE FOREGOING REPRESENTS THE SOLE AND EXCLUSIVE WARRANTY GIVEN BY HI-SPEED WITH RESPECT TO ALL GOODS SOLD AND IS IN LIEU OF ALL OTHER WARRANTIES EITHER EXPRESS OR IMPLIED. HI-SPEED EXPRESSLY DISCLAIMS ALL OTHER WARRANTIES INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR USE OR PURPOSE. BUYER WAIVES ANY CLAIM THAT THESE EXCLUSIONS OR LIMITATIONS DEPRIVE IT OF AN ADEQUATE REMEDY AT EQUITY OR LAW OR CAUSE THIS AGREEMENT TO FAIL IN ITS ESSENTIAL PURPOSE. BUYER SHALL BE ENTITLED TO NO OTHER REMEDY OTHER THAN AS SET FORTH HEREIN, REGARDLESS OF THE CLAIM OR CAUSE OF ACTION, WHETHER BASED IN CONTRACT, TORT, NEGLIGENCE, GOODS LIABILITY, STRICT LIABILITY OR OTHERWISE.

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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.