

**S & G****PRESS & MACHINERY SALES****PRESS INSPECTION REPORT****Customer**

<b>Press No.</b>	Stock # 2774	<b>Serial No.</b>	22967
<b>Model No.</b>	P2-150-54 Piece-Maker	<b>Mfg.</b>	Minster

**1. General Information**

<b>A. Stroke</b>	6"
<b>B. Stroke per minute</b>	45-90 VSPM
<b>C. Adjustment of ram</b>	4"
<b>D. Shut height to bed</b>	23"

**2. ELECTRICAL**

<b>A. Operational</b>	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
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**B. General condition** (based on a mechanics observation and not that of an electrician)**3. LUBRICATION**

<b>A. Type of System</b>	Oil	<input checked="" type="checkbox"/>	Grease	<input type="checkbox"/>
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**B. Manufacturer**

<b>C. All points receive lube</b>	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
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**D. General condition & assessment**

#### 4. PNEUMATICS

A. Clutch/brake pressure 80 PSI

B. Counter balance 45 PSI

C. Cushion N/A

D. Check for leaks & note None

E. General condition & assessment

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#### 5. CLUTCH

A. Air leak Yes ☐ No ☒

B. Travel .057

C. General condition & assessment

#### 6. BRAKE

A. Air leak Yes ☐ No ☒

B. Travel .057

C. General condition & assessment

#### 7. FLYWHEEL BRAKE

A. Lining thickness NA

B. General condition & assessment -

#### 8. GEAR TRAIN

A. General condition & assessment

Good Condition

## 9. GUARDS & COVERS

A. Damage	None
B. Leaking Oil	No
C. Missing Bolts	No
D. General Assessment	Good

## 10. Main Motor Assemble

A. Belts Assessment	Good
B. Shiv & Grooves Assessment	Smooth Belt No Groves
C. Motor Mount Assessment	Good

## 11. HYDRAULIC OVERLOAD SYSTEM

A. Operating Pressure	N/A
B. Leaks	
C. General Condition & Assessment	

## 12. RAM TO BED PARALLELISM

A. With counter balance pressure on

### Stroke down

LR	.000	RR	.000
LF		RF	

### Stroke at 90 degrees

LR	.0	RR	+.002
LF		RF	

### Stroke up

LR	.000	RR	+.002
LF		RF	

### Stroke at 270 degrees

LR	.00	RR	-.001
LF		RF	

B. Condition of slide face	Ok
C. Condition of bolster face	Ok
D. General condition & assessment	

### 13. GIB CLEARANCE

#### A. Points of gibbing

8 Point

#### B. Front to back

##### Bottom of gib

LR	<u>.005</u>	RR	<u>.005</u>
LF	<u>.006</u>	RF	<u>.006</u>

##### Top of gib

LR	<u>.004</u>	RR	<u>.005</u>
LF	<u>.007</u>	RF	<u>.005</u>

#### C. Left to right

##### Bottom of gib

LR	<u>.004</u>	RR	<u>.006</u>
LF	<u>.005</u>	RF	<u>.006</u>

##### Top of gib

LR	<u>.006</u>	RR	<u>.004</u>
LF	<u>.005</u>	RF	<u>.005</u>

#### D. General condition & assessment

### 14. RAM ADJUSTMENT

#### A. Limit switches working

Yes

☒

No

☐

#### B. General condition & assessment

Was checked and verified runs well – Ran up and down.

**15. RAM LIFT READINGS WITH JACK PRESSURE****A. Total lift**

LR	<u>.027</u>	RR	<u>.025</u>
LF	<u></u>	RF	<u></u>

**B. Crank shaft or main pin**

LR	<u>.006</u>	RR	<u>.009</u>
LF	<u></u>	RF	<u></u>

**C. Connection upper**

LR	<u>.008</u>	RR	<u>.007</u>
LF	<u></u>	RF	<u></u>

**D. Connection lower**

LR	<u>.005</u>	RR	<u>.003</u>
LF	<u></u>	RF	<u></u>

**E. Screw threads**

LR	<u></u>	RR	<u></u>
LF	<u></u>	RF	<u></u>

**F. Adjustment nut and housing**

LR	<u>.008</u>	RR	<u>.007</u>
LF	<u></u>	RF	<u></u>

**G. General condition & assessment****16. RUN PRESS**

A. Check for vibration	<u>None</u>
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B. Check for noise	<u>Noise coming from the clutch/brake</u>
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**C. Assessment**

Will need further evaluation and guards removed for inspection.

**17. Serviceman's general overall assessments & comments including repairs****18. INSPECTION**

Inspected by	<u>Derek</u>
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Date	<u>9/08/2023</u>
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