



**PRESS INSPECTION REPORT**

Customer \_\_\_\_\_

Press No. Stock # 2699 Serial No. 17344

Model No. P2-150-54 Piece-Maker Mfg. Minster

**1. General Information**

A. Stroke 6"

B. Stroke per minute 45-90 VSPM

C. Adjustment of ram 4"

D. Shut height to bed 23"

**2. ELECTRICAL**

A. Operational Yes  No

B. General condition (based on a mechanics observation and not that of an electrician)

**3. LUBRICATION**

A. Type of System Oil  Grease

B. Manufacturer \_\_\_\_\_

C. All points receive lube Yes  No

D. General condition & assessment:  
Lube System not pumping oil will need repair and upgrades.

#### 4. PNEUMATICS

- A. Clutch/brake pressure                      60 PSI  
\_\_\_\_\_
- B. Counter balance                              Rear Counterbalance Leaks  
\_\_\_\_\_
- C. Cushion    N/A  
\_\_\_\_\_
- D. Check for leaks & note                      Not holding pressure  
\_\_\_\_\_
- E. General condition & assessment  
\_\_\_\_\_

#### 5. CLUTCH

- A. Air leak    Yes                          No      
\_\_\_\_\_
- B. Travel    .068  
\_\_\_\_\_
- C. General condition & assessment

#### 6. BRAKE

- A. Air leak    Yes                          No      
\_\_\_\_\_
- B. Travel    .068  
\_\_\_\_\_
- 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 - Motor appears New/er

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	_____	RR	_____	LR	_____	RR	_____
LF	_____	RF	_____	LF	_____	RF	_____

#### Stroke up

#### Stroke at 90 degrees

LR	.0	RR	+.002	LR	.00	RR	-.001
LF	_____	RF	_____	LF	_____	RF	_____

#### Stroke at 270 degrees

B. Condition of slide face	Ok
C. Condition of bolster face	Ok

### D. General condition & assessment

Did not run press because lube system not functioning so we did not check for parallelism.

### 13. GIB CLEARANCE

#### A. Points of gibbing

8 Point

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#### B. Front to back

##### Bottom of gib

LR \_\_\_\_\_ RR \_\_\_\_\_  
LF \_\_\_\_\_ RF \_\_\_\_\_

##### Top of gib

LR \_\_\_\_\_ RR \_\_\_\_\_  
LF \_\_\_\_\_ RF \_\_\_\_\_

#### C. Left to right

##### Bottom of gib

LR \_\_\_\_\_ RR \_\_\_\_\_  
LF \_\_\_\_\_ RF \_\_\_\_\_

##### Top of gib

LR \_\_\_\_\_ RR \_\_\_\_\_  
LF \_\_\_\_\_ RF \_\_\_\_\_

#### D. General condition & assessment

Gibs backed off for inspection – Will need to set when press lube is running for proper assessment.

### 14. RAM ADJUSTMENT

#### A. Limit switches working

Yes  No

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#### B. General condition & assessment

Was not checked.

### 15. RAM LIFT READINGS WITH JACK PRESSURE

#### A. Total lift

LR .031 RR .033  
LF \_\_\_\_\_ RF \_\_\_\_\_

#### B. Crank shaft or main pin

LR .009 RR .006  
LF \_\_\_\_\_ RF \_\_\_\_\_

#### C. Connection upper

LR .011 RR .010  
LF \_\_\_\_\_ RF \_\_\_\_\_

#### D. Connection lower

LR .006 wrist pin RR .006  
LF \_\_\_\_\_ RF \_\_\_\_\_

#### E. Screw threads

LR .005 RR .005  
LF \_\_\_\_\_ RF \_\_\_\_\_

#### F. Adjustment nut and housing

LR \_\_\_\_\_ RR \_\_\_\_\_  
LF \_\_\_\_\_ RF \_\_\_\_\_

#### G. General condition & assessment

Press appeared to have work performed recently. Excellent condition.

### 16. RUN PRESS

A. Check for vibration Not Checked  
B. Check for noise \_\_\_\_\_  
C. Assessment \_\_\_\_\_

### 17. Serviceman's general overall assessments & comments including repairs

Will need to take more time to assess the lube system and make operational prior to running. As well as address air counterbalance leaks. Preliminary Inspection

### 18. INSPECTION

Inspected by Derek / Dave Ruthenberg  
Date 11/01/2023