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Scope of Work

No. 7D-SS Minster O.B.I. Serial #7d-21203

S&G Press Stock #2753

- I. Counterbalance cylinders.
 - A. Disassemble, clean, and inspect.
 - B. New Cylinders provided and installed.
 - C. New Pistons provided and installed.
 - D. Rod Guide Bushings (2) New Installed
 - E. Replacement of (2) Assembly Pins, Installed
 - F. Furnish new packings, seals, and "O" rings.
 - G. Reassemble complete and pressure test.

- II. Clutch/Brake, Bull Gear Assembly.
 - A. Disassemble, clean, and inspect all components for wear and dimensional integrity. Inspect and advise on bull gear bearings. Bull gear is in very good condition. Pinion gear is in very good condition.
 - B. Set up all friction plates and skim cut to minimum cleanup.
 - C. New Lining installed on Brake Plate
 - D. Replace Brake pins (2) and fit to brake plate.
 - E. Set up cylinder and piston and polish to remove any light scoring.
 - F. Furnish new clutch/brake linings, bolts, and springs.
 - G. Furnish new packings and seals.
 - H. Reassemble complete pressure test and verify stroke.
Bolts and springs: Linings: Packings, seals, O-rings.
 - I. Replace (2) Bearings in ID of Bull Gear.
 - J. Bull gear set up on VTL and bored to oversize to accept steer sleeve. Furnish material, turn, and shrink and fit into bull gear. Finish bore to fit with new bearings.
 - K. Crankshaft has worn bearing diameters, set up and weld diameters. Set up into lathe and turn to fit with new bearings. Includes all labor and material.

- III. Slide assembly:
 - A. Disassemble, clean, and inspect all adjustment assembly components for wear and dimensional integrity.
 - B. Machine lower ball seat retaining cap to close up clearance within recommended tolerance.
 - C. Ball and seat to be set up into lathe, skim cut and wet polished to remove any light scoring.
 - D. The upper connection bushing was found to have excessive clearance. Furnish bronze material, machine/split and install into link and cap.
 - E. Set up slide onto mill and skim cut face parallel to adjustment housing mounting surface and parallel to gib surfaces.



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- F. Reassemble adjustment assembly into slide, verify clearances and test run.
- G. Adjustment worm shaft bearings found to be worn due to sludge/debris found in housing. Furnish New Bearings.
- IV. Lubrication System
 - A. Replace multiple hoses and lines found damaged. Check out all other lube components and make sure they are in good working order.
- VII. Assembly:
 - A. Assemble all components back into press and secure.
 - B. Verify clutch/brake operation and complete adjustments.
 - C. Level slide, adjust gibs and test run press.