

**S & G****PRESS & MACHINERY SALES****PRESS INSPECTION REPORT****Customer****Press No.** Stock # 2784**Serial No.** SDG-400-269-89**Model No.** SC2-400-84-48**Mfg.** Blow**1. General Information**

A. Stroke 10"
B. Stroke per minute 25-50 VSPM
C. Adjustment of ram 10"
D. Shut height to bed 28" Bolster - 34" on Bed

2. ELECTRICAL

A. Operational Yes ☒ No ☐

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

Press was run direct to motor. All electrical and prints are available but due to time constraints and additional cost decision to run press direct was made.

3. LUBRICATION

A. Type of System Oil ☒ Grease ☐

B. Manufacturer

C. All points receive lube Yes ☒ No ☐

D. General condition & assessment:
All Points getting lube and verified.

4. PNEUMATICS

A. Clutch/brake pressure 50 PSI

B. Counterbalance 50 PSI

C. Cushion N/A

D. Check for leaks & note None

E. General condition & assessment

- Rebuilt Air Counterbalances, replaced air hoses, and new guide bushing.

5. CLUTCH

A. Air leak Yes ☐ No ☒

B. Travel .100

C. General condition & assessment

Newly Relined – Ortlinghaus Double Sided Clutch Plate.

6. BRAKE

A. Air leak Yes ☐ No ☒

B. Travel .100

C. General condition & assessment

Newly Relined – Ortlinghaus Brake Plates

7. FLYWHEEL BRAKE

A. Lining thickness 3/8"

B. General condition & assessment - OK

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	Good
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 counterbalance pressure on

Stroke down

LR	.0	RR	-.004	LR	.0	RR	-.013
LF		RF		LF		RF	

Stroke up

Stroke at 90 degrees

LR	.0	RR	-.007	LR	.0	RR	-.011
LF		RF		LF		RF	

Stroke at 270 degrees

B. Condition of slide face	Great – Machined to minimum Clean-Up
C. Condition of bolster face	Great – Machined to minimum Clean-Up

D. General condition & assessment

Also machined the Gibs

13. GIB CLEARANCE

A. Points of gibbing

8 Point

B. Front to back

Bottom of gib

LR	<u>.006</u>	RR	<u>.013</u>
LF	<u>.007</u>	RF	<u>.016</u>

Top of gib

LR	<u>.007</u>	RR	<u>.007</u>
LF	<u>.009</u>	RF	<u>.010</u>

C. Left to right

Bottom of gib

LR	<u>.005</u>	RR	<u>.013</u>
LF	<u>.007</u>	RF	<u>.007</u>

Top of gib

LR	<u>.006</u>	RR	<u>.013</u>
LF	<u>.006</u>	RF	<u>.010</u>

D. General condition & assessment

14. RAM ADJUSTMENT

A. Limit switches working

Yes

☒

No

☐

B. General condition & assessment

15. RAM LIFT READINGS WITH JACK PRESSURE

A. Total lift

LR	<u>.052</u>	RR	<u>.057</u>
LF	<u></u>	RF	<u></u>

B. Crank shaft or main pin

LR	<u>.012</u>	RR	<u>.014</u>
LF	<u></u>	RF	<u></u>

C. Connection upper

LR	<u>.010</u>	RR	<u>.019 11- 12" Bushing</u>
LF	<u></u>	RF	<u></u>

D. Connection lower

LR	<u>.005</u>	RR	<u>.004 5" Bushing</u>
LF	<u></u>	RF	<u></u>

E. Screw threads

LR	<u>.025</u>	RR	<u>.019</u>
LF	<u></u>	RF	<u></u>

F. Adjustment nut and housing

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

G. General condition & assessment

Excellent condition.

16. RUN PRESS

A. Check for vibration	<u>None</u>
B. Check for noise	<u>Normal Gear Noise</u>
C. Assessment	<u></u>

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

18. INSPECTION

Inspected by	<u>Derek Ruthenberg</u>
Date	<u>02/28/2024</u>