



S & G

PRESS & MACHINERY SALES

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400-ton Minster E2-400-60-48 Hevi-Stamper Straight Side Press

Mechanical Rebuild Scope of Work Performed:

Onsite Disassembly at S&G Press Livonia Warehouse:

Remove both counterbalance cylinders from the press.

Remove both front gibs, (2) upper connection caps and slide assembly from press.

Unfasten and remove the flywheel brake.

Remove covers and remove clutch/brake from press.

Load out all components and transport parts to Superb Machine Repair.

Known repairs found during inspection:

Counterbalance Cylinders:

Disassemble, clean, and inspect.

Superb to hone cylinder, polish rod and piston, furnish new packings and seals.

Reassemble complete and pressure test.

Slide Assembly/Links:

Remove links and adjustment screws from slide.

L.H and R.H. upper connection, furnish bushing material, machine, and split. Install and fasten into link and cap. Assemble and finish bore.

Both lower connections bushings found to have .010 to .012 over recommended clearance between wrist pin and bushings. Furnish New bushing material, machine, install and fit bushings to (2) new wrist pins.

Reassemble adjustment screws into nuts/housings.

Install links into screws and assemble wrist pin into bores.

Clutch/Brake Assembly:

Disassemble, clean, and inspect all components for wear and dimensional integrity.

Superb to machine all friction plate surfaces to minimum cleanup.

Install all new linings on the clutch and brake.

Set up piston/cylinders and polish diameters.

Furnish all new packings and seals.

Reassemble complete and verify stroke.



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Flywheel Brake:

Disassemble, clean, and inspect.
Lightly hone cylinder and polish piston rod.
Install new lining.
Reassemble complete, pressure test, and verify operation.

Load out and deliver to S & G Press Warehouse.

Onsite Assembly:

Furnish servicemen to install counterbalance cylinders, slide assembly, gibs, flywheel brake and guarding.
Startup press, level slide and adjust gibs.

Complete Update of Lubrication and Air system; includes a new lube pump and motor, go through metering blocks, and make sure all-in good operating order, replace any lines that require replacement. Update Air Filters and Regulators for counterbalances, clutch/brake, etc. Test run to make sure everything is functioning properly.

Please feel free to contact me directly with any questions you may have about the press.

Best Regards,

Sergio Gasperoni
Managing Partner