

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

Press No.	Stock # 2865	Serial No.	28451
Model No.	E2-200-72-42	Mfg.	Minster

1. General Information

A. Stroke	10"
B. Stroke per minute	0-90 VSPM
C. Adjustment of ram	6"
D. Shut height to bed	26"

2. ELECTRICAL

A. Operational	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)

Press is running through controls. Electrical is fully functional.

3. LUBRICATION

A. Type of System	Oil	<input checked="" type="checkbox"/>	Grease	<input type="checkbox"/>
B. Manufacturer	Minster Monitor Flow			
C. All points receive lube	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>	

D. General condition & assessment

4. PNEUMATICS

A. Clutch/brake pressure 60 PSI

B. Counter balance 0 PSI – Missing a Pipe

C. Cushion N/A

D. Check for leaks & note None

E. General condition & assessment

Recommend getting the proper Air Pipe and Fitting to complete for future customer visits under power.

5. CLUTCH

A. Air leak Yes ☐ No ☒

B. Travel Self-contained

C. General condition & assessment

6. BRAKE

A. Air leak Yes ☐ No ☒

B. Travel

C. General condition & assessment

Like new – No visible wear

7. FLYWHEEL BRAKE

A. Lining thickness 3/8" Thickness

B. General condition & assessment - OK

8. GEAR TRAIN

A. General condition & assessment

9. GUARDS & COVERS

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

10. Main Motor Assemble

A. Belts Assessment	Good
B. Shiv & Grooves Assessment	Looks New
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	RR	LR	RR
LF	RF	LF	RF

Stroke at 270 degrees

B. Condition of slide face	Good
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C. Condition of bolster face	Recently Resurfaced by S&G Press Repair
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D. General condition & assessment

13. GIB CLEARANCE

A. Points of gibbing

8 Point

B. Front to back

Bottom of gib

LR .002
LF .005

RR .002
RF .005

Top of gib

LR .005
LF .002

RR .005
RF .002

C. Left to right

Bottom of gib

LR .002
LF .003

RR .005
RF .005

Top of gib

LR .002
LF .003

RR .005
RF .004

D. General condition & assessment

14. RAM ADJUSTMENT

A. Limit switches working

Yes

☒

No

☐

B. General condition & assessment

Runs smoothly through press controls. Limits not checked

15. RAM LIFT READINGS WITH JACK PRESSURE

A. Total lift

LR	<u>.040</u>	RR	<u>.041</u>
LF	<u></u>	RF	<u></u>

B. Crank shaft or main pin

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

C. Connection upper

LR	<u>.017</u>	Aprox. 24" Bushings	RR	<u>.017</u>
LF	<u></u>		RF	<u></u>

D. Connection lower

LR	<u>.007</u>	RR	<u>.007</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>.011</u>	RR	<u>.010</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>None</u>
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C. Assessment

Very Good

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

Appears to be in excellent condition. Install Air Counterbalance Pipes and should be ready to go.

18. INSPECTION

Inspected by	<u>Dave Ruthenberg</u>
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Date	<u>05/01/2024</u>
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