



**S & G** PRESS & MACHINERY SALES

## PRESS INSPECTION REPORT

Customer

Press No.	Stock # 2861	Serial No.	P2-100-21059
Model No.	P2-100-48 Piece-Maker	Mfg.	Minster

### 1. General Information

A. Stroke	4"
B. Stroke per minute	75-150 VSPM
C. Adjustment of ram	4"
D. Shut height to bed	18"

### 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)

### 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 50 PSI

C. Cushion N/A

D. Check for leaks & note None

E. General condition & assessment

#### 5. CLUTCH

A. Air leak Yes ☐ No ☒

B. Travel Internal – Can not measure

C. General condition & assessment

#### 6. BRAKE

A. Air leak Yes ☐ No ☒

B. Travel Internal – Can not measure

C. General condition & assessment

#### 7. FLYWHEEL BRAKE

A. Lining thickness NA

B. General condition & assessment -

#### 8. GEAR TRAIN

A. General condition & assessment

Good – Press gears sound normal

## 9. GUARDS & COVERS

A. Damage	None
B. Leaking Oil	None
C. Missing Bolts	None
D. General Assessment	Good

## 10. Main Motor Assemble

A. Belts Assessment	Like New
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 counter balance pressure on

#### Stroke down

LR		RR		LR		RR	
LF	+.002	RF	0	LF	+.002	RF	0

#### Stroke up

#### Stroke at 90 degrees

LR		RR		LR		RR	
LF	+.002	RF	0	LF	+.002	RF	0

#### Stroke at 270 degrees

B. Condition of slide face	Good
C. Condition of bolster face	Recently Skim Cut by S&G Press

### D. General condition & assessment

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### 13. GIB CLEARANCE

#### A. Points of gibbing

8 Point

#### B. Front to back

##### Bottom of gib

LR	<u>.003</u>	RR	<u>.003</u>
LF	<u>.003</u>	RF	<u>.004</u>

##### Top of gib

LR	<u>.003</u>	RR	<u>.002</u>
LF	<u>.003</u>	RF	<u>.003</u>

#### C. Left to right

##### Bottom of gib

LR	<u>.004</u>	RR	<u>.005</u>
LF	<u>.004</u>	RF	<u>.006</u>

##### Top of gib

LR	<u>.005</u>	RR	<u>.006</u>
LF	<u>.005</u>	RF	<u>.004</u>

#### D. General condition & assessment

### 14. RAM ADJUSTMENT

#### A. Limit switches working

Yes



No



#### B. General condition & assessment

Checked – Runs smooth up and down, will need to go back to confirm the adjustment limit switch settings.

#### 15. RAM LIFT READINGS WITH JACK PRESSURE

##### A. Total lift

LR	<u>.035</u>	RR	<u>.030</u>
LF	<u></u>	RF	<u></u>

##### B. Crank shaft or main pin

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

##### C. Connection upper

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

##### D. Connection lower

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

##### E. Screw threads

LR	<u>.005</u>	RR	<u>.005</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

#### 16. RUN PRESS

A. Check for vibration None – Runs Good

B. Check for noise

##### C. Assessment

Very Good

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

#### 18. INSPECTION

Inspected by Dave Ruthenberg

Date 05/15/2024