



## Scope of Work: 300-ton Eagle Mechanical Metal Stamping Press

### 1. Counterbalance Cylinders:

- A. Disassemble, clean, and inspect.
- B. Set up and wet polish cylinders, rods, and pistons to remove any light scoring.
- C. Furnish new packings and seals.
- D. Reassemble complete and pressure test.

### 2. Slide Assembly:

- A. Disassemble, clean, and inspect all slide & slide adjustment components for wear and dimensional integrity.
- B. Adjustment nuts and housing to be set up and machined accordingly to correct excessive clearance issues (if any).
- C. Ball Screw Seat, and Housing has excessive clearance.
  - a. Reassembled to obtain lift readings and determine best course of action to repair excessive clearance.
  - b. Set Up Ball Screws into Lathe and machined seat to minimum cleanup and polished.
  - c. Set up Housing / Seat into lathe and machined seats to minimum cleanup. Making radius true due to out of round condition.
  - d. Machined the retaining plates as needed to set up proper clearance between the balls and seat.
- D. Remove existing wear strips and install new micarta wear strips onto slide assembly.
- E. Machine bottom of slide to clean up/parallel.
- F. Machine Gibs to clean up/parallel.
- G. Reassemble all components into slide and verify clearances.
- H. Test run adjustment motor verifying smooth operation.



### 3. Upper Connection Arm Bushing

- A. Remove worn upper connection bushing from link and cap.
- B. Furnish bronze material, machine, split and secure into cap and link.
- C. Assemble cap onto link and finish bore to size.

### 4. Bolster Plate:

- A. Grind top and bottom to clean up.

### 5. Lubrication System:

- A. Go through lube system - replace any broken lines.
- B. Inspect all lube blocks are flushed and functional
- C. Inspect and advise as the overall condition and functionality of the Lube system.

### 6. Pneumatic System:

- A. Replace any broken air pipes
- B. Replace any non-functioning regulators

### 7. Reassembly: Reinstall slide assembly onto press and secure, level slide and adjust gibs. Install counterbalance cylinders and test run press to verify operation and heat check.

Note: Prior to removal from operation the clutch and brake were rebuilt by others. Clutch and Brake was thoroughly inspected by S&G Press Team. After significant review clutch and brake were deemed to be in like new condition. Pillow Block, Bearings and Plate appear in like new condition. S&G Press can provide press stopping times at time of inspection under power.