

POWER PRESS MACHINE SPECIFIC INSPECTION REPORT FORM

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| Customer: | Machine Make: | Machine Model: | Machine Serial # | |
| Name of Customer Contact: | Explanation of symbols shown in result | | | |
| Date of Inspection: | N: Nothing unusual or operates normally. R: Repair or adjustment is required. | | | |
| Name of Inspector: | B: Be careful about machine conditions. A: Machine was repaired or adjustment was done. | | | |
| | Inspection Item | Specified Value or Condition | Measured value (or remark) | Result |
| Overall press | Check if there are any faults in the overall press | Should be free from serious damage | | |
| | Check mounting bolts and nuts for various parts of press such as gib, covers, point, plunger holder, and devices | Should be free from crack, damage and no loose bolts or nuts | | |
| Machine frame | Check all welds for visual cracks | should have no cracks | | |
| Lubrication system | Check external faults on piping and devices | Should be free from crack, damage | | |
| | Check for operating condition of pump motor | Should be free of unusual noise and vibration and shall otherwise operate normally | | |
| | Check motor current during running | Should be less than 70% of motor rated current | | |
| | Check thermal-overload setting | Should be motor full load amps | | |
| | Check for oil leakage | Should have no oil leaking | | |
| | Check oil level and dirty oil in the gear box | Should be proper oil level. Should be free from foreign matter, foaming, whitening, discoloration and dirt | | |
| | Clean suction filter | | | |
| | Check flow units in the line for blockage | Should have no blockage. | | |
| | Replace flow units | Flow units are recommended to be replaced every year | | |
| | Check on/off setting value of pressure switch | Should be set to specified pressure | | |
| Change oil | Should change oil every 2000 hrs. | | | |
| Gib Lubrication System | Check external faults on piping and devices | Should be free from crack, damage | | |
| | Check for operating condition of pump motor | Should be free of unusual noise and vibration and shall otherwise operate normally | | |
| | Check thermal-overload setting | Should be motor full load amps | | |
| | Check for oil leakage | Should have no oil leaking | | |
| | Clean suction filter | | | |
| | Check flow units in the line for blockage | Should be no blockage. | | |
| Replace flow units | Flow units are recommended to be replaced every year | | | |
| Pneumatic Lines | Check external faults on piping and devices | Should be free from crack, damage | | |
| | Check air for air leaks in the lines | Should not drop more than 60% after 10 minutes | | |
| | Adjust air regulator and check the pressure gages | They should change normal | | |
| | Check pressure gages make sure they are working | The needles should go back to zero | | |
| | Check the pressure switch and on/off settings | Set to specified pressure | | |
| | Check the function of the air filter, oil lubricator, and muffler | Should be free of damage and function correctly | | |
| | Check Auto Drain Filters | Should be free from matter and water | | |
| Open the air drain valves for the tanks | Should be free from matter and water | | | |
| Clutch Brake | Check external faults on piping and devices | Should be free from crack, damage | | |
| | Check external faults on clutch brake unit | Should have no damage | | |
| | Check oil level and for dirt in clutch housing | Should be proper oil level. Shall be free from foreign matter, foaming, whitening, discoloration and dirt | | |
| | Check for oil leakage | Should have no oil leak | | |
| | Check movement of center disk in inching operation | Disks should move smoothly and quickly | | |
| | Measure clutch stroke | Stroke should be within specified range | | |
| Clutch / brake valve | Check for air leaking from clutch piston | Should not have any air leaks | | |
| | Change oil | Change oil every 2000 hrs. | | |
| | Check for damage valve | Should have no damage showing and operate smoothly | | |
| | Check each side of the valve for performance | Should work properly | | |
| air rotary joint / hose | Check for air leaks | Should have no air leaks | | |
| | Check for dirt on the muffler | Should have no dirt build up | | |
| Overload protector | Check oil level in the overload protector tank | Should be at proper oil level | | |
| | Check for oil leakage | Pump sound intervals shall not be 15 sec. or more | | |
| | Check overload operation with reset handle | Reset handle open and closes pump should stop | | |
| | Check overload setting value | Recalibrate with load cells if incorrect | | |
| Slide adjust device | Check external faults on motor, gears, shaft and indicator | Should be free from crack, damage | | |
| | Run the motor and check for faults | Should be free from unusual noise and vibration | | |
| | Check motor current during running | Should be less than 70% of motor rated current | | |
| | Check thermal-overload setting | Should be motor full load amps | | |
| | Check oil level in the points | Should be proper oil level | | |
| | Check oil for leaks in the points | Should have no oil leaks | | |
| | Check slide adjust upper and lower limits | upper limit trip settings lower limit trip settings | | |
| Check operating condition of the slide adjust mechanism | Should operate smoothly throughout entire range | | | |

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| | Check play on worm shaft and key way | Should be follow specified value | | |
| | Change oil in the points | | | |

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| Plunger and screw | Check external faults on plunger surface and screw | Should be free from crack,damage | | |
| | Check for oil leakage from plunger and packing | Should have no oil leaks | | |
| | Apply rocol paste to screws | | | |
| Balancer cylinder | Check external faults on rod and balancer cylinder | Should be free from crack,damage | | |
| | Check for air leakage from rod packing and piston packing | Should have no air leaks | | |
| Main motor | Put 50cc of lubrication oil into cylinder | Every 6 months | | |
| | Check external faults on motor | Should be free from crack,damage, and dirt and oil | | |
| | Run the motor and checkfor faults | Should be free from unusual noise and vibration | | |
| | Check motor current during running | Start-up amperage at maximum speed | | |
| | | flywheel idling amperage at maximum speed | | |
| | running continuous amperage at maximum speed | | | |
| | Bearing Noise or heat | Should not here noise from bearing or heat build up | | |
| Pully and V-belts | Check vibration of pulley and play on keyway | Should be free from vibration and play on keyway | | |
| | Check for external faults and testion of V-belts | Should be free from crack,damage and proper tension | | |
| Flywheel | Check external faults of flywheel | Should be free from crack,damage, and dirt and oil | | |
| | Check tightness of flywheel end nut and lock bott | Should be no looseness | | |
| | Check out grease levels | Re-grease if nessary | | |
| | Measure wobble of the flywheel using a dial gauge | radius / 1000 = wobble vibration | | |
| | Check the flywheel idling operation condition | Should be free from unusual noise and heat generation | | |
| | Check duration of the free running time of the flywheel | Should be no less than the specified time | | |
| Flywheel Brake | Check circumferential play between flywheel and spline s | Should be less than 0,05mm | | |
| | check flywheel brake movement | Should be normal movement | | |
| | Check out grease levels | Re-grease if nessary | | |
| Rotary cam drive | check flywheel brake limit switch movement | Should be normal movement | | |
| | Check mounting condition and rotary cam drive | Should not have any play or looseness | | |
| Slide | Check chain tenision | Should be tight and no slilage | | |
| | Check slide exterior and t-slots for damage | Should have no damage showing and operate smoothly | | |
| Rotation angle Indicator | Check number of strokes by its own inertia | Should be within specified value | | |
| | Check for external faults | Should have no damage | | |
| overrun monitor device | Check indication at BDC (use daii indicator) | Indication should be correct | | |
| | Check encoder coupling | Should not have any play or looseness | | |
| | Check faults of the motion detector limit switch | Should have no damage | | |
| overrun monitor device | Check stroke on the limit switch | Should be normal movement | | |
| | Check faults of the motion detector proximity switch | Should have no damage | | |
| | Check operation of the overrun switch | Should work properly | | |
| | Check clearance between proximity switch and trigger | Cclearance :3mm +/- 1mm | | |

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| Emergency stop | Check for external faults | Should have no damage | | |
| | Check press for immediatly stop | Should stop immediatly | | |
| Safety blocks | Check for external faults | Should have no damage to block or chain | | |
| | Check press for interlock | Should stop immediatly | | |
| Electrical wiring | Check for external faults | Should have no damage | | |
| | Check condition of the ground wire | Should be properly connected | | |
| | Check for loose wires, connectors,labels and terinal block | Should be properly tighten, no burn marks, and all wires labeled | | |
| | Check ac control voltage | Should be within specified value | | |
| | Check dc control voltage | Should be within specified value | | |
| control panel | Check control current | Should be within specified value | | |
| | Check for foreign matter | Should have no oil or foreign matter in it | | |
| Selector switch | Check for external faults | Key should be tight and move smothly | | |
| | Check operation in each position | press should operated in accordance with switch mode | | |
| relays contactors | Check contacts for faults | Should be properly tighten and no burn marks | | |
| | Check coils for faults | Should be properly tighten and no burn marks | | |
| | Check main motor fwd / rev. contactor | Should work in rev. only in inch mode | | |
| lamps | Check all lamps | Should be working | | |
| Rotary cam switch | Check for external faults | Should have no damage | | |
| | Check encoder coupling | Should not have any play or looseness | | |
| | Check settings angle for each cam | Cam setting should be correct | | |
| fuses/breakers | Check settings | Should be within specified value | | |
| Contoler | Check for external faults | Should have no damage | | |
| | Check for loose wires, connectors,and terinal blocks | Should be properly tighten and no burn marks | | |
| Electrical equipment | Clean card holder | | | |
| | Check for external faults | Should have no damage | | |
| | Check for loose wires, connectors,and terinal blocks | Should be properly tighten and no burn marks | | |
| Daul push | Check anti-vibration mounts | Should be not broken | | |
| | Check for external faults | Should have no damage | | |
| | Check operation of buttons | Should move smoothly | | |
| | Check protection rings | Should have no damage | | |

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| button panel | Check for loose wires, and terinal blocks | Should be properly tighten and no burn marks | | |
| | Check buttons for anti-repeat | Press should not run | | |
| | Check buttons for anti-tie down | Press should not run | | |
| | Check buttons for time circuit .5 sec. | Press should not run | | |
| Light Curtains | Check for external faults | Should have no damage | | |
| | Check operation of safety lights | Press should not run when blocked | | |
| | Check height of protection | Should be securley mounted and specified height | | |
| | Check stop time (90) deg. Measure 10 times | Check stop time at 90 deg. Average of 10 times | | |
| | Check safety distance | Should be securley mounted and specified distance | | |

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| Top Stop Position | Check top stop position at max speed in singel stroke | press speed 0 -150 spm +/- 5 deg. | | |
| | Measure 10 times | press speed 151 -300 spm +/- 15 deg. | | |
| Safety Gates or hard Guarding | Check for external faults | Should have no damage | | |
| | Check operation of safety gates or guarding | Press should not run when opened | | |
| Ejector | Check height of protection | Should be securley mounted and specified height | | |
| | Check for air leakage | Should have no air leaks | | |
| Die Cushions | Check operation of sol.valve | Should move smoothly | | |
| | Check external faults on piping and devices | Should be free from crack,damage | | |
| | Check air for air leaks in the lines | Should not drop more than 60% after 10 minutes | | |
| | Adjust air regulator and check the pressure gages | They should change normal | | |
| | Check pressure gages make sure they are working | The needles should go bake to zero | | |
| | Check the pressure switch and on/off settings | Set to specified pressure | | |
| | Check the funcation of the air filter,oil lubricator,and muffler | Should be free of damage and funcation correctly | | |
| | Check Auto Drain Filters | Shold be free from matter and water | | |
| Slide Knockout(s) | Open the air drain valves for the tanks | Shold be free from matter and water | | |
| | Check external faults on piping and devices | Should be free from crack,damage | | |
| Die Lifter Die Clamper Upper Die Clamper Lower | Check for external faults | Should have no damage | | |
| | Check external faults on piping and devices | Should be free from crack,damage | | |
| | Check for smoth operation | should move smoothly and have no leaks | | |
| | Check clamping force | should move smoothly and have no leaks | | |
| | Check calmping force | should move smoothly and have no leaks | | |
| | Check interlocks with press | Should be as drawings for safety | | |
| Conveyor | Check for external faults | Should have no damage | | |
| | Check operation of convetor and belts | Should move smoothly and no damage | | |
| | Check for loose wires, and terinal blocks | Should be properly tighten and no burn marks | | |
| | Check interlocks with controler | Press should not work when not on | | |
| Die Lubrication | Check for external faults | Should have no damage | | |
| | Check operation of pump | Should be free from unusual noise and vibration | | |
| | Check for loose wires, and terinal blocks | Should be properly tighten and no burn marks | | |
| | Check interlocks with controler | Press should not work when not on | | |

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| Automation Clamp/Unclamp | Check external faults on piping and devices | Should be free from crack,damage | | |
| | Check air for air leaks in the lines | Should not drop more than 60% after 10 minutes | | |
| | Adjust air regulator and check the pressure gages | They should change normal | | |
| | Check pressure gages make sure they are working | The needles should go bake to zero | | |
| | Check the pressure switch and on/off settings | Set to specified pressure | | |
| | Check the funcation of the air filter,oil lubricator,and muffler | Should be free of damage and funcation correctly | | |
| | Check Auto Drain Filters | Shold be free from matter and water | | |
| | Open the air drain valves for the tanks | Shold be free from matter and water | | |
| Moving Bolster Clamp Moving Bolster Lift Moving Bolster Run | Check external faults on piping and devices | Should be free from crack,damage | | |
| | Check external faults on piping and devices | Should be free from crack,damage | | |
| | Check for air leaks in the lines | Should not drop more than 60% after 10 minutes | | |
| | Adjust air regulator and check the pressure gages | They should change normal | | |
| | Check pressure gages make sure they are working | The needles should go bake to zero | | |
| | Check the pressure switch, limit switches | Set to specified pressure | | |
| | Check the funcation of the air filter,oil lubricator,and muffler | Should be free of damage and funcation correctly | | |
| | Check Auto Drain Filters | Shold be free from matter and water | | |
| Load Monitor | Open the air drain valves for the tanks | Shold be free from matter and water | | |
| | Check external faults on piping and devices | Should be free from crack,damage | | |
| | Check interlocks with controler | Press should top stop when in an alarm staties | | |
| | Check left front strain link | Should be torque to 150 inch lbs or manufactur specs | cal. Factor # | off set # |
| | Check left rear strain link | Should be torque to 150 inch lbs or manufactur specs | cal. Factor # | off set # |
| | Check right front strain link | Should be torque to 150 inch lbs or manufactur specs | cal. Factor # | off set # |
| | Check right rear strain link | Should be torque to 150 inch lbs or manufactur specs | cal. Factor # | off set # |
| | Check external faults on piping and devices | Should be free from crack,damage | | |
| | Check air for air leaks in the lines | Should not drop more than 60% after 10 minutes | | |
| | Adjust air regulator and check the pressure gages | They should change normal | | |
| | Check pressure gages make sure they are working | The needles should go bake to zero | | |
| | Check pressure gages make sure they are working | The needles should go bake to zero | | |

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| Feeder | Check the interlocks and on/off settings | Set to specified settings | | |
| | Check the function of the air filter, oil lubricator, and muffler | Should be free of damage and function correctly | | |
| | Check Auto Drain Filters | Should be free from matter and water | | |
| | Check out grease levels | Re-grease if necessary | | |
| Warning Horn | Check out interlocks with the press | Should come on when there is a danger present. | | |
| misfeed | | | | |
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| Overall | Check overall clearance of connections | Should be within specified value | | |
| Clearance | Check individual clearance of connections | Should be within specified value | | |
| Gear | Check teeth on main gear, intermediate gear, and pinion | should not have any wear or damage | | |
| | Check gear for backlash | Should be within specified value | | |

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| Accuracy | Check gib clearances | Should be within specified value | | |
| | Check parallelism | Should be within specified value | | |
| | Check machine level | Should be within specified value | | |

