

PRESS INSPECTION WORKSHEET

DATE	1/10/2008
COMPANY NAME	Durex Products Inc.
MAKE OF PRESS	Komatsu
PRESS SER#	D0100
PRESS MOD#	OBS 200S-VS-3
CUSTOMER IDENTIFICATION	
SERVICE TECHNICIAN(S)	Scott Bilgrien
TYPE OF INSPECTION	Annual

X = OK
 O = NEEDS ATTENTION
 OO = NEEDS IMMEDIATE ATTENTION

ITEMS INSPECTED		REMARKS	
1	Check bolts and screws for looseness. If necessary retighten.	X	
2	Check the oil levels.	X	C/B 11M 2.7 GAL .29 AMPS ON GEARBOX DTE 24 22.5 CHANGED 1.11/08
3	Check rotary cam / resolver chain tension / encoder coupling.	X	
4	Inspect rotary cams / encoder.	X	
5	Check flywheel for looseness and bearing runout.	X	.015 SHAKE/.007 RUNOUT
6	Check V-belt tension.	X	
7	Check V-belt for wear.	X	
8	Lubricate connection screws.	X	
9	Inspect foot operated switch.	N/A	
10	Drain water out of all air tanks and filters.	X	
11	Check rotary connection and piping for air leaks and retighten if necessary.	X	
12	Check counter balance cylinders for leaks.	X	
13	Check the operation of dual solenoid valve for proper actuation and leaks.	X	
14	Check the DSV for secure mounting.	X	
15	Check clutch / brake for clearances and proper actuation.	X	0.125

16	Check function of clutch / brake for top dead center stopping.	X	
17	Check slide adjustment for proper operation.	X	
18	Check slide adjustment limit switches for proper operation.	X	480 / 480.1 360 / 359.9
19	Check indicator lamps, relay hum, loose screws, plugs and wires, and relay / contactor discoloration.		Top stop button is broken.
19a	Measure the main motor current.	X	Running idle. 27.7
19b	Measure the main motor current.	X	Running in continuous. 32 / 30.7
20	Check emergency stops for proper operation.	X	
21	Check emergency stops for proper repair.	X	
22	Check gib clearances.	X	
23	Check ram parallelism to bolster.	X	

24	Do a 90 degree stop time test		1st test time	0.165
			2nd test time	0.170
			3rd test time	0.170
			4th test time	0.165
			5th test time	0.164
			6th test time	0.164
			7th test time	0.167
			8th test time	0.168
			9th test time	0.167
			10th test time	0.167
			Greatest stop time	0.170
25	Check for proper safety distance of light curtains if used		Safety distance from pinch point	11.780
26	Check for proper safety distance of operator station		Safety distance from pinch point	

CLEARANCES

Left

Right

_____	Pocket / Wrist Pin	_____
_____	Con Rod Bushing	_____
_____	Screw to Housing	_____
_____	Cross Shaft Bushing	_____
_____	Total	_____

RAM PARALLELISM

-0.007	BACK	-0.008
	@ BDC	
-0.001	FRONT	0

GIB CLEARANCES

6 SIDED RAM TOP



6 SIDED RAM BOTTOM



V-GIBS RAM TOP

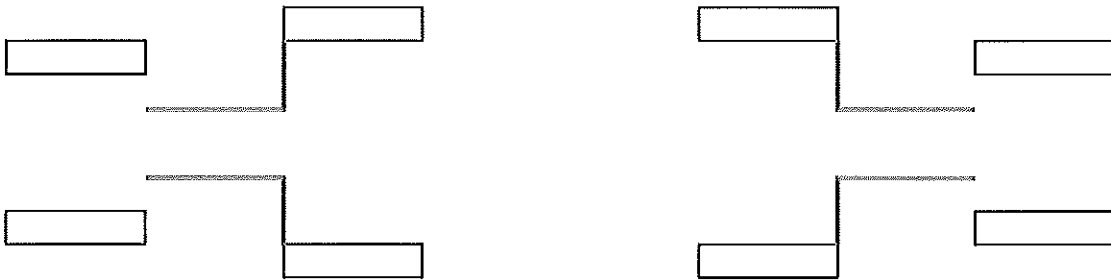


V-GIBS RAM BOTTOM

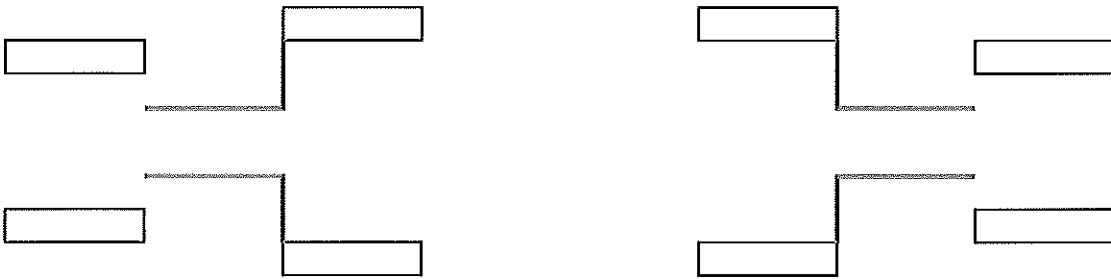


GIB CLEARANCES

8 SIDED RAM TOP



8 SIDED RAM BOTTOM



PRESS INSPECTION WORKSHEET

DATE	2/13/2009
COMPANY NAME	Durex
MAKE OF PRESS	Komatsu
PRESS SER#	D0100
PRESS MOD#	OBS 200S-VS-3
CUSTOMER IDENTIFICATION	
SERVICE TECHNICIAN(S)	Scott Bilgrien
TYPE OF INSPECTION	Annual

X = OK
 O = NEEDS ATTENTION
 OO = NEEDS IMMEDIATE ATTENTION

ITEMS INSPECTED			REMARKS
1	Check bolts and screws for looseness. If necessary retighten.	X	
2	Check the oil levels.	X	Changed Oil 2/13/09
3	Check rotary cam / resolver chain tension / encoder coupling.	X	
4	Inspect rotary cams / encoder.	X	
5	Check flywheel for looseness and bearing runout.	X	FWR=.013 FWS=.007 FWCT=253 SEC.
6	Check V-belt for tension & wear.	X	
7	Lubricate connection screws.	X	
8	Inspect foot operated switch.	N/A	
9	Drain water out of all air tanks and filters.	X	
10	Check rotary connection and piping for air leaks and retighten if necessary.	X	
11	Check counter balance cylinders for leaks.	X	
12	Check the operation of dual solenoid valve for proper		

	solenoid valve for proper actuation and leaks.	X	
13	Check the DSV for secure mounting.	X	
14	Check clutch / brake for clearances and proper actuation.	X	0.105
15	Check function of clutch / brake for top dead center stopping.	X	
16	Check slide adjustment for proper operation.	X	
17	Check slide adjustment limit switches for proper operation.	X	360/359.9 480/480.1
18	Check indicator lamps, relay hum, loose screws, plugs and wires, and relay / contactor discoloration.	X	
18a	Measure the main motor current.	X	Running idle. 24.9
18b	Measure the main motor current.	X	Running in continuous. 32.2
19	Check emergency stops for proper operation.	X	
20	Check emergency stops for proper repair.	X	
21	Check gib clearances.	X	
22	Check ram parallelism to bolster.	X	

23	Do a 90 degree stop time test
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1st test time	0.167
2nd test time	0.168

			3rd test time	0.171
			4th test time	0.169
			5th test time	0.170
			6th test time	0.169
			7th test time	0.169
			8th test time	0.170
			9th test time	0.169
			10th test time	0.171
			Greatest stop time	0.178
24	Check for proper safety distance of light curtains if used		Safety distance from pinch point	
25	Check for proper safety distance of operator station		Safety distance from pinch point	

CLEARANCES

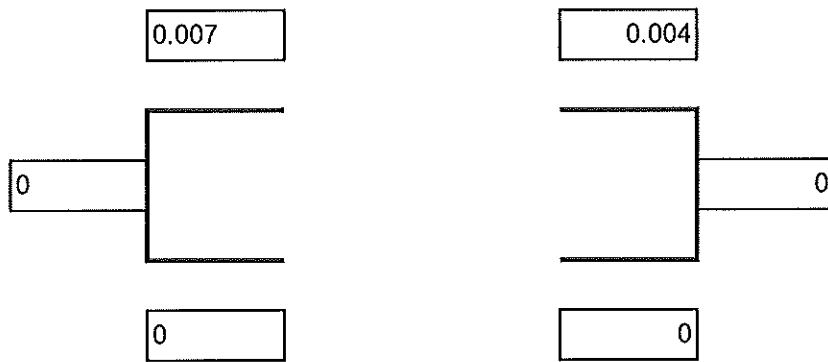
<u>Left</u>		<u>Right</u>	
_____	Pocket / Wrist Pin	_____	0.014
_____	Con Rod Bushing	_____	
_____	Screw to Housing	0.007	
_____	Cross Shaft Bushing	_____	
_____	Total	0.021	

RAM PARALLELISM

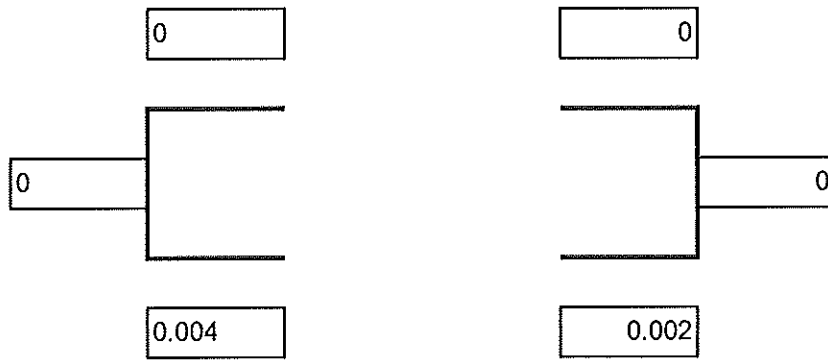
-0.003	BACK	-0.004
	@ BDC	
0.002	FRONT	0

GIB CLEARANCES

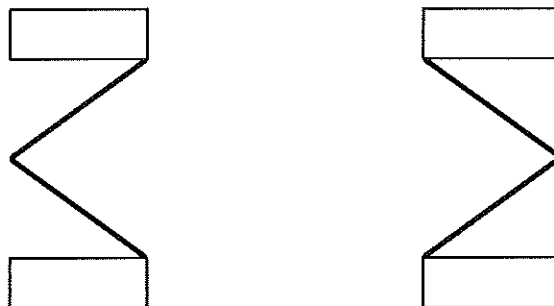
6 SIDED RAM TOP



6 SIDED RAM BOTTOM



V-GIBS RAM TOP



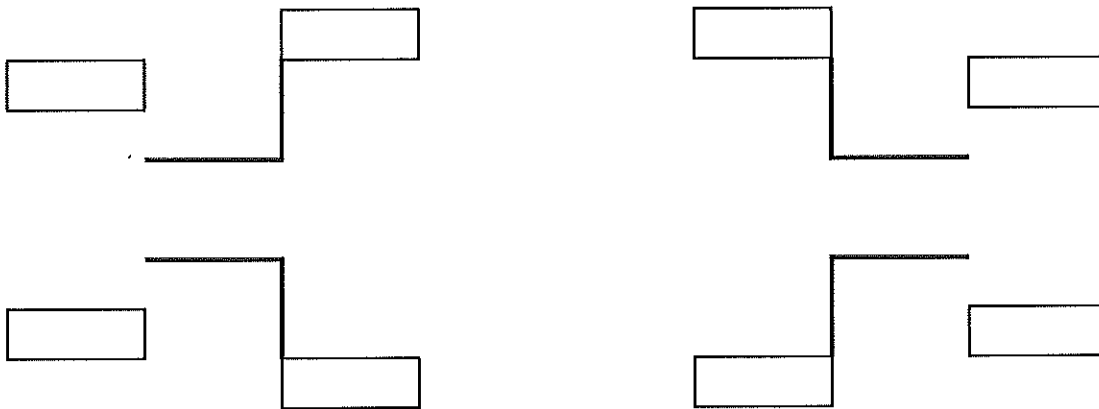
V-GIBS RAM BOTTOM



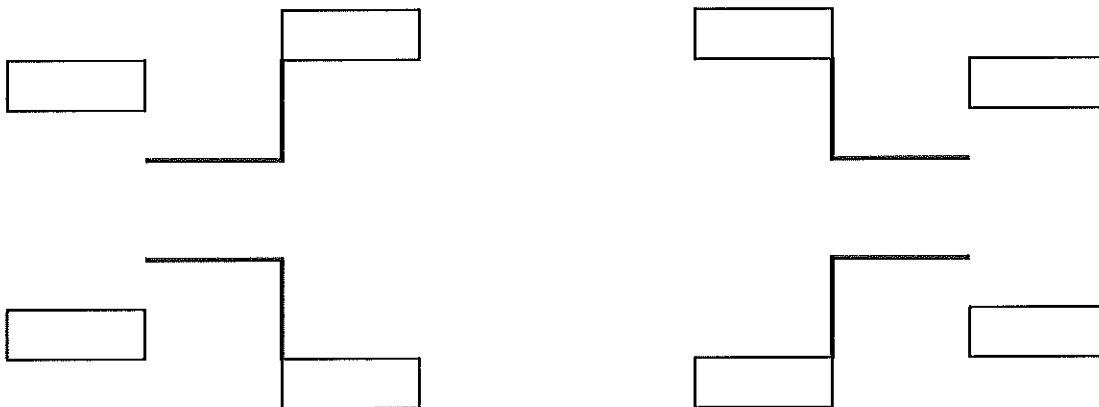


GIB CLEARANCES

8 SIDED RAM TOP



8 SIDED RAM BOTTOM



PRESS INSPECTION WORKSHEET

DATE	7/6/2010
COMPANY NAME	Durex - Windfall, IN
MAKE OF PRESS	Komatsu
PRESS SER#	OBS200S-VS-3
PRESS MOD#	D0100
CUSTOMER IDENTIFICATION	
SERVICE TECHNICIAN(S)	Kurt Wirsching
TYPE OF INSPECTION	Annual

X = OK
 O = NEEDS ATTENTION
 OO = NEEDS IMMEDIATE ATTENTION

ITEMS INSPECTED			REMARKS
1	Check bolts and screws for looseness. If necessary retighten.	X	
2	Check the oil levels.	O	Oil weeps into ram from gibs. Oil changed 07/07/2010.
3	Check rotary cam / resolver chain tension / encoder coupling.	X	
4	Inspect rotary cams / encoder / resolver.	X	
5	Check flywheel for looseness and bearing runout.	X	.008 shake
6	Check V-belt for tension & wear.	X	
7	Lubricate connection screws.	X	
8	Inspect foot operated switch.	N/A	
9	Drain water out of all air tanks and filters.	X	
10	Check rotary connection and piping for air leaks and retighten if necessary.	X	
11	Check counter balance cylinders for leaks.	X	

12	Check the operation of dual solenoid valve for proper actuation and leaks.	X	
13	Check the DSV for secure mounting.	X	
14	Check clutch / brake for clearances and proper actuation.	X	0.105
15	Check function of clutch / brake for top dead center stopping.	X	
16	Check slide adjustment for proper operation.	X	
17	Check slide adjustment limit switches for proper operation.	X	
18	Check indicator lamps, relay hum, loose screws, plugs and wires, and relay / contactor discoloration.	O	Top stop push button is cracked.
18a	Measure the main motor current.	X	Running idle. 29.06
18b	Measure the main motor current.	X	Running in continuous. 30.09
19	Check emergency stops for proper operation.	X	
20	Check emergency stops for proper repair.	X	
21	Check gib clearances.	X	
22	Check ram parallelism to bolster.	X	

23	Do a 90 degree stop time test
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1st test time	0.165
2nd test time	0.166
3rd test time	0.168
4th test time	0.163
5th test time	0.164
6th test time	0.166
7th test time	0.166
8th test time	0.168
9th test time	0.167
10th test time	0.169
Greatest stop time	0.169

24	Check for proper safety distance of light curtains if used		Safety distance from pinch point	N/A
25	Check for proper safety distance of operator station		Safety distance from pinch point	N/A

CLEARANCES

Left

Right

_____	Pocket / Wrist Pin	_____ 0.012
_____	Screw to Housing	_____ 0.015
_____	Con Rod Bushing	_____
_____	Cross Shaft Bushing	_____
_____	Total	_____ 0.028

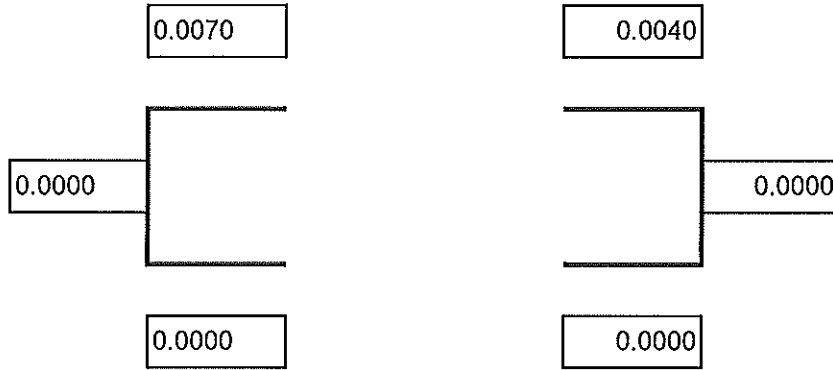
RAM PARALLELISM

NOTE: Measured to customer's ram sub-plate.

-0.0050	BACK	-0.0050
	@ BDC	
0.0000	FRONT	0.0000

GIB CLEARANCES

6 SIDED RAM TOP



6 SIDED RAM BOTTOM

