

15.1.0 WEEKLY PRESS INSPECTION
CHECK LIST PRESS SERIAL NO. _____
MODEL NO. _____

WARNING

BEFORE INSPECTING OR REPAIRING THE PRESS OR AUXILIARY EQUIPMENT, ALWAYS PLACE THE SLIDE AT THE BOTTOM OF THE STROKE AND TURN THE POWER OFF. ALSO TURN THE AIR SUPPLY OFF AND BLEED OFF COUNTERBALANCE AIR IF FURNISHED. LET THE FLYWHEEL COME TO A COMPLETE STOP. IF AIR AND POWER ARE REQUIRED FOR SOME INSPECTIONS, USE EXTREME CAUTION. ONCE THE POWER IS "OFF" LOCK THE DISCONNECT IN THE "OFF" POSITION. PLACE SAFETY BLOCKS IN POSITION.

PNEUMATIC EQUIPMENT

1 AIR FILTER-Shut off air supply and release system air pressure. Open filter drain cock to release trapped moisture and foreign matter. Draining not required if press is equipped with automatic draining filter.

2 AIR GAUGES-Check accuracy, condition, and proper pressure settings.

3 AIR TANKS-Drain accumulated moisture.

4 COUNTERBALANCE CYLINDERS-(if furnished)

a) Drain accumulated moisture from cylinders thru drain in counterbalance tank.

b) Check that counterbalances are properly lubricated.

5 VALVES AND SOLENOID-Check for proper operation in coordinating clutch and brake action. Manually depress the plungers of the dual actuating valves one at a time to "fail" the valves. Reset by depressing pneumatic recock valve mounted on front of solenoid valve. Check for air leakage from valves. Replace entire valve if it is not working properly.

LUBRICATION EQUIPMENT

1 AIR LUBRICATOR

- a) Drain any accumulated water from bowl.
- b) Fill bowl with proper lubricant.
- c) Check condition of and operation of lubricator.

2 LUBRICATION SYSTEMS

- a) Check oil level of reservoir daily.
- b) Check system for loose or broken tubing, worn hoses, loose fittings and connections.
- c) Check that proper lubricant is used.
- d) Check that all points are receiving the proper amount of lubrication.

3 MANUAL LUBRICATION

- a) Check that all gears and pinions are properly lubricated.

- b) Check that all points that require manual greasing or oiling are being lubricated as required.

NOTE: CHECK AND LUBRICATE ACCORDING TO LUBRICATION INSTRUCTION IN SECTION 4.0.0.

ELECTRICAL EQUIPMENT

NOTE: REPLACE COMPONENTS WHENEVER DOUBTFUL ABOUT OPERATING CONDITION. ENSURE THAT COMPONENTS ARE ALWAYS CLEAN.

1 PUSH BUTTONS

- a) Check all "Run" buttons for proper guarding.
- b) Visually inspect all buttons for loose, cracked or broken sections.
- c) Check operational response of all two-hand "Run" buttons.
- d) Check "Stop" and "Top Stop" buttons for proper functioning.

2 SELECTOR SWITCHES

- a) Inspect all selector switches for operational response in each designated mode.
- b) Check each selector switch for damage and wear.
- c) Report any unauthorized use of selector keys to supervision.

GENERAL PRESS EQUIPMENT

1 PRESS COVERS AND PRESS GUARDING

- a) Check that all covers are in place and tightly secured.
- b) Check and report any bypassing of guards or safety devices.
- c) Check and report any conditions that would require additional operational guards.
- d) Inspect the condition of personal protective equipment and material handling tools.
- e) Check for proper functioning of all point of operation guarding.

2 CLEANLINESS

- a) Check that the die area is clean and free of any material, rags, chips scraps, etc., which may have accumulated. Use proper cleaning procedures to eliminate the placing of hands into

die area.

3 CLUTCH ASSEMBLY

(Part Revolution (Air))

- a) Check clutch for loose, damaged or broken parts.
- b) Check clutch for air leakage.
- c) Check for proper operation in engaging and disengaging. Operation must be smooth and positive.
- d) Check for excessive wear.

4 Brakes

- a) Check brake for proper mounting.
- b) Check clutch for air leakage on presses with part revolution clutches.
- c) Check for lining wear.
- d) Check for proper adjustment.
- e) Check that brake lining is free of grease and oil.

Inspected by _____ Date: _____

Press approved for Prod. by _____ Date: _____

Press not approved for Production

By: _____ Date: _____

Description of unsatisfactory conditions

(Use reverse side) Date: _____

Corrective steps taken Date: _____

(Use reverse side)

Comments

(Use reverse side)

15.2.0 MONTHLY PRESS INSPECTION

CHECK LIST

PRESS SERIAL NO. _____

MODEL NO. _____

CHECK BOX IF NOT O.K.

WARNING

BEFORE INSPECTING OR REPAIRING THE PRESS OR AUXILIARY EQUIPMENT, ALWAYS PLACE THE SLIDE AT BOTTOM OF THE STROKE AND TURN THE POWER OFF. ALSO TURN THE AIR SUPPLY OFF AND BLEED OFF COUNTERBALANCE AIR IF FURNISHED. LET THE FLYWHEEL COME TO A COMPLETE STOP. IF AIR AND POWER ARE REQUIRED FOR SOME INSPECTIONS, USE EXTREME CAUTION. ONCE THE POWER IS "OFF" LOCK THE DISCONNECT IN THE "OFF" POSITION. PLACE SAFETY BLOCKS IN POSITION.

PNEUMATIC EQUIPMENT

1 COUNTERBALANCE CYLINDERS

(if furnished)

- a) Ensure that adequate and correct air pressure is being supplied.
- b) Check that all counterbalance mounting bolts

and rods are secured tightly.

- c) Check that counterbalance does not leak.

2 AIR PRESSURE SWITCHES

- a) Check physical condition of pressure switch.
- b) Check for proper functioning by reducing the air pressure below the preset operating range of the pressure switch. This must prevent normal operation of the press.

3 AIR GAUGES

- a) Check for proper operation.

4 AIR PRESSURE REGULATOR

- a) Check for proper functioning by turning the adjustment screw clockwise or counterclockwise.
- b) Ensure that air supply is adequate, clean and constant.

5 AIR PIPING AND CONNECTIONS

- a) Check the condition of all piping, tubing, hoses and fittings. Also check their supporting hardware for loose, broken or missing parts.
- b) With the air pressure on, check all air lines and connections for leaks mashed or broken sections.

6 FLYWHEEL BRAKE

(If furnished)

- a) Inspect lining for wear. Replace if worn.
- b) Inspect flywheel brake mounting screws for tightness.
- c) Actuate flywheel brake and check the operational response.

7 PRESSURE RELIEF VALVE

IN AIR TANK

- a) Check condition valve.
- b) Operate valve manually to determine if working properly.

ELECTRICAL EQUIPMENT

NOTE: REPLACE COMPONENTS WHENEVER DOUBTFUL ABOUT OPERATING CONDITION. ENSURE THAT COMPONENTS ARE ALWAYS CLEAN.

1 CONTROL PANEL

- a) Check that all electrical components, wire terminals and connections are tightened properly.
- b) Check all electrical components for pitted contacts and deposits of foreign matter, etc. Also note any signs of overheated components.
- c) Check motor heaters and fuses for proper size.
- d) Check wiring for damaged insulation.

- e) Check that press frame and control panel are properly grounded.
- f) Check transformer for excessive heat.
- g) Check brake monitor functioning.

2 MOTOR

- a) Check motor mounting bolts and motor bracket mounting bolts for proper tightness.
- b) Clean, lubricate and service motor as recommended in the motor manufacturer's instructions.
- c) Check for overheating.

PNEUMATIC EQUIPMENT

1 COUNTERBALANCE CYLINDERS

(if furnished)

- a) Ensure that adequate and correct air pressure is being supplied.
- b) Check that all counterbalance mounting bolts and rods are secured tightly.
- c) Check that counterbalance does not leak.

2 AIR PRESSURE SWITCHES

- a) Check physical condition of pressure switch.
- b) Check for proper functioning by reducing the air pressure below the pre set operating range of the pressure switch. This must prevent normal operation of the press.

3 AIR GAUGES

- a) Check for proper operation.

4 AIR PRESSURE REGULATOR

- a) Check for proper functioning by turning the adjustment screw clockwise or counterclockwise. The gauge reading should respond accordingly.
- b) Ensure that air supply is adequate, clean and constant.

5 AIR PIPING AND CONNECTIONS

- a) Check the condition of all piping, tubing, hoses and fittings. Also check their supporting hardware for loose, broken or missing parts.
- b) With the air pressure on, check all air lines and connections for leaks, mashed or broken sections.

6 FLYWHEEL BRAKE

(if furnished)

- a) Inspect lining for wear. Replace if worn.
- b) Inspect flywheel brake mounting screws for tightness.
- c) Actuate flywheel brake and check the operational response.

7 PRESSURE RELIEF VALVE IN AIR TANK (if furnished)

- a) Check condition of valve.

- b) Operate valve manually to determine if working properly.

ELECTRICAL EQUIPMENT

NOTE: REPLACE COMPONENTS WHENEVER DOUBTFUL ABOUT OPERATING CONDITION. ENSURE THAT COMPONENTS ARE ALWAYS CLEAN.

1 CONTROL PANEL

- a) Check that all electrical components, wire terminals and connections are tightened properly.
- b) Check all electrical components for pitted contacts and deposits of foreign matter, etc. Also note any signs of over heated components.
- c) Check motor heaters and fuses for proper size.
- d) Check wiring for damaged insulation.
- e) Check that press frame and control panel are properly grounded.
- f) Check transformer for excessive heat.
- g) Check brake monitor functioning.

2 MOTOR

- a) Check motor mounting bolts and motor bracket mounting bolts for proper tightness.
- b) Clean, lubricate and service motor as recommended in the motor manufacturer's instructions.
- c) Check for overheating.

GENERAL PRESS EQUIPMENT

1 CLUTCH ASSEMBLY (Part Revolution (Air))

- a) Check clutch for loose, damaged or broken parts.
- b) Check clutch for air leakage.
- c) Check for proper operation in engaging and disengaging. Operation must be smooth and positive.
- d) Check for excessive wear.

2 SLIDE ADJUSTMENT PARTS

- a) Check adjusting screw threads and worm gears for damage or foreign matter that might impair proper operation.

PRESSES EQUIPPED WITH POWER SLIDE ADJUSTMENT

- a) Check that all chains and sprockets are tight, lubricated and properly aligned.
- b) Clean, lubricate and service slide adjustment motor in accordance with manufacturer's instructions.

3 FLYWHEEL, BELTS AND MOTOR SHEAVE

- a) Check V-belts for proper tension.
- b) Check V-belts for cracks and wear.
- c) Check motor sheave groves for wear,

cracks or rough areas.

- d) Check motor sheave mounting for proper tightness.
- e) Check for proper alignment between sheave and flywheel.

4 BOLSTER PLATE

- a) Check that bolster plate is securely mounted to bed.
- b) Check that no foreign material is lodged between bolster plate and bed.
- c) Check that bolster plate is free of nicks and scratches.

5 FASTENERS

- a) Check all screws, nuts and bolts for tightness.
- b) Replace any missing or broken screws, nuts and washer.

6 SHAFTS

- a) Check shafts for run out and end play.

7 KEYS

- a) Check all keys for tightness.

8 CONNECTING RODS

- a) Check bushings for excessive clearance.

9 NAME PLATES AND DECALS

- a) Check that none of the "Warning" and instruction signs have been removed, defaced, hidden or covered.

10 DIES

- a) Inspect the dies for safe operation conditions.
- b) Examine dies for sharp edges and pinch points which may have developed as a result of a new installation or usage.
- c) Check for proper guarding.

11 BRAKES

- a) Check brake for proper mounting.
- b) Check for air leakage on presses with part revolution clutches.
- c) Check for lining wear.
- d) Check for proper adjustment.
- e) Check that brake lining is free of grease and oil.

12 GEAR AND PINIONS

- a) Check gear and pinion for evidence of wear.
- b) Check that pinion and gear keys are tight and properly aligned.

13 BEARINGS

- a) Check bronze sleeve bearings for excessive wear and/or looseness.
- b) Check anti-friction bearings for noise and heat.

14 LEVELNESS

- a) Check that press weight is being sup

ported proportionately at all points.

- b) Check levelness of press with precision level on bolster (or bed). Press should be level within .001" per foot of bolster width right-to-left and front-to-back.

15 GENERAL INSPECTION

- a) Check major components not previously inspected for wear, cracks or broken sections.
- b) Check press for missing parts or missing accessory items.
- c) Check press foundation. Replace foundations that are loose, broken or sinking.
- d) Check appearance of press. Repaint or clean if required.

Inspected

by _____ Date: _____

Press approved for Prod.

by _____ Date: _____

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(Use reverse side) Date: _____

Corrective steps taken

Date: _____

(Use reverse side)

Comments

(Use reverse side) _____
