

PROTOS ENGINEERING CO.PRIVATE LTD.

SERVICE REPORT

To Be Submitted Immediately After The Job is Completed

Date : 13.09.2023

Members present

Members present

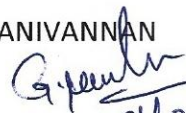

Protos engineering co pvt ltd.,

Bharat forge limited, Mambattu.,

Mr. VIMALKUMAR



Mr. MANIVANNAN



21/09/23
9/19

Worked days : 11.09.2023, 12.09.2023 , 13.09.2023– 3 Days

MODEL : IDRA OL1900CS SO Number : 8633

WORK DESCRIPTION:

1. REPORTED THAT THE PLUNGER MOVING FORWARD DURING METAL POURING

- a. Checked the PA and PB oil pressure during metal pouring, the PA oil pressure is around 150Bar during metal pouring and it lead to move the plunger piston forward.
- b. When the 07YV5 valve is getting OFF then the plunger getting forward around 5mm.
- c. Checked the condition of 07YV10 it is in good condition. Checked the function of 07YV5 it is also working fine
- d. Checked the condition of 07YV1 it is also functioning correct. During the analysis observed there is intensification pressure holding.
- e. IP is not holding from 30th Aug 2023 onwards, the IP holding is not achieved as per the set value. So this is confirmed that there is an oil drop at the IP cylinder.
- f. Once the cylinder opened found there is a damage of Brass bush, RING Bush also o ring.
- g. Found lot of minor damaged brush parts inside of the cylinder, Multiplication accumulator bottom side.
- h. Customer procured the spares from their own source and fitted on the equipment.

- i. Accumulator charging issue found after assembly and identified the core accumulator safety relief valve is damaged. The same was replaced from 1100T for testing purpose.
- j. Now the accumulator is charging up to 150Bar because the N2 pressure is only 120Bar when pump OFF condition. So informed customer to top up N2 between 135Bar to 145 Bar as mentioned on the name plate and suggested to run.
- k. Machine full auto cycle tested , the Multiplication piston is moving only 20mm for 250Bar IP setting.