



COMMISSIONING REPORT

Customer Name: Endurance Technologies Ltd.

Page no. 01/03

Address: Waluj MIDC

City: Aurangabad

State: Maharashtra

Contact Name: Mr. Kakasaheb Amte

Designation: Manager - Maintenance

Phone No.: +91 7030932554

PO No: 1400039038

Equipment details

Model No.: TS0001

Machine Sr. No.: 2103125

Month & Year Supply: 03/2021

Type: High Pr. Air Leak Test Bench for Brake Hose Ass.

MI Reference No: S205026

Commissioned by:

ZAHEER SHAIKH

Date

From

05.08.2021

To

10.08.2021

Visual Inspection

- Machine found physically in OK condition.

Pre-Start-up

Utility :

Utilities	Required	Available
Air Pressure	7 Bar	6 Bar
Medium - Gas	NA	NA
Medium - Liquid	NA	NA
Voltage (V)	230 VAC	230 VAC
Earthing	Yes	Yes

Start-up

05.08.2021:

- Customer complaint of frequent failure of O-rings in machine and also need to close the previous pending points related to software.
- Started the machine and done the communication between machine and user interface software.
- Modified the software for login authentication for different level user (Admin, Engineer, Operator).
- As only got 2 hrs for work so close the day with above activity.

06.08.2021:

- Checked the user login with different user login (Admin, Engineer, Operator).
- Created different level user, modified their access level and found working properly.
- Modified the test screen with easy user access.
- Checked the alarm log tab and found all alarms are logging properly.

Customer Remark:

Maximator India Pvt Ltd

Sign -

Name - Mr. Zaheer Shaikh

Designation- Service Engineer

Date - 10.08.2021

Endurance Technologies Ltd

Sign -

Name - Mr. Kakasaheb Amte *Kiran Patil*

Designation- Manager - Maintenance *Production*

Date - 10.08.2021

Note: The drive air should correspond to ISO 8573-1, purity classes 2 / 4 / 3





- Modified the program database with new user screens.
- Checked and verified the maintenance screen and found working properly.

07.08.2021:

- As per last visit point, done the auto test start logic, once the dpor is closed with all clamped hoses, the test will start automatically, no need to start from HMI (No need to touch HMI).
- Checked the Auto start logic multiple time with both chamber (Left & Right) and found working properly.
- Modified the program as per customer requirement, when test fail due to any reason the respective chamber should be locked and only after entering the Admin user id & password the chamber will unlock.
- Same has been checked and verified.
- The chamber unlock provision given on Admin Id & password and Key operated switch mounted on electrical panel.

08.08.2021:

- Checked and rectified the problem of "Test Fail during Continuity Test"
- Modified the Recipe screen and added the Continuity Test Pressure & Time parameter.
- Now user can define the continuity Test Pressure & Time.
- Operated the machine with modified logic and found machine running properly.
- Now the cycle is performing correctly, after pressing start/Auto Start, continuity test is going as per set parameter, once the continuity comes OK, pressurisation is happening for HP test.
- Created the User and defined the password for the same (Admin, Supervisor and Operator).

09.08.2021:

- Checked the data logging of performed test and found data storing properly.
- Generated the report in .pdf format and same has been saving in report folder on desktop.
- Operated the Left chamber with O-ring provided by customer and right chamber with Parker O-ring provided by Maximator, and found the left chamber O-ring wearing too fast compared to right chamber O-ring.
- Sometime Customer O-ring coming out from the clamping fixture after completion of cycle however Parker O-ring not moving from its place means fixing properly.
- 100 cycle operated with Left and right chamber and found right chamber with Parker O-ring giving good performance.

CUSTOMER REMARK :

Maximator India Pvt Ltd	Endurance Technologies Ltd
Sign -	Sign -
Name - Mr. Zaheer Shaikh	Name - Mr. Kakasaheb Amte <i>Kiran Patil</i>
Designation- Service Engineer	Designation- Manager - <i>Maintenance Production</i>
Date - 10.08.2021	Date - 10.08.2021

Note: The drive air should correspond to ISO 8573-1, purity classes 2 / 4 / 3





10.08.2021:

- While testing in right chamber it is observed, every time hose3 & hose5 showing NOK result.
 - While checking the problem we found out that isolation valve of Hose 3 & 5 leaking (passing the pressure) which are resulting the NOK result.
 - Maximator valve (Isolation valve 3&5) 15V4M071-H2-3MNC are leaking.
 - With reference to above activity commissioning visit completed successfully.
 - With reference to the last visit dated 12.06.2021 we have completed below all pending points raised by Mr. Kiran Patil against their mail reference dated 26th April 2021.
1. First continuity at 6 bar then further for performance test at 150 bar
 2. Password protection if NG detected & Authority to shift engineer relock the m/c.
 3. For auto cycle start no need to touch MMI.
 4. Software hang issue.
 5. Industrial network switch.
 6. Emergency switches for every clamp unit.
 7. Password/Log in for Manager, Supervisor & Operator

REMARKS:

- Maximator will provide solution on the leakage needle valves (15V4M071-H2-3MNC).
- We will recommend to use Parker make O-rings for better performance (N1470.70 - 2.012).

REMARK IF ANY :

CUSTOMER REMARK IF ANY :

NOTE: Customer remarks are subject to approval from MIPL.

Maximator India Pvt Ltd	Endurance Technologies Ltd
Sign -	Sign -
Name - Mr. Zaheer Shaikh	Name - Mr. Kakasaheb Amte <i>Kiran Patil</i>
Designation- Service Engineer	Designation- Manager - Maintenance <i>Prodⁿ</i>
Date - 10.08.2021	Date - 10.08.2021

Note: The drive air should correspond to ISO 8573-1, purity classes 2 / 4 / 3

