

Service Report

Customer: Jaguar Landrover
Location: Jaguar Cars Halewood
Plant Reference: H-75808 41-1

Job Number: SPE 247
Order No: TBA
Date: 18-03-2011

Task:

Customer has reported problems with the bed cushion dropping during down-stroke.

Investigation:

With the press bed empty and the cushion at BDC an error of 2.4mm was present between encoders. With tool loaded in press it became apparent that the maximum possible cushion stroke was only 242mm before the cushion encountered a physical stop within the tooling, at this point a force of 240 KN was being developed in response to the obstruction. The tooling specification was checked with a stroke of 250mm being possible for this tool, the pad stops were inspected with the cushion raised to 242mm a further 15mm of travel remaining before the pad stops limit movement.

Recommendations:

The cause of the cushion malfunction is due to incorrect bolster pin layout this should be addressed before the next tool trial.

The cushion encoders should be recalibrated this will be particularly important on this tool as it uses the maximum available stroke of the cushion (250mm).

Notes:

During our time on site the following items that require attention were observed

1. High / medium pressure pump and motor have excessive vibration this should be investigated and rectified immediately as it will not be possible to use the press in the event of a failure, it should be noted that pump lead time can be up to 16 weeks.
2. Hydraulic tank breather filters, all are heavily contaminated and should be replaced. Oil tank should be checked for excessive oil vapor before replacement.
3. The crown area is flooded with oil and very dirty, this should be cleaned as it makes maintenance and detection of leaks very difficult.
4. Slide is pulsing during upstroke with large increases in pump current, pump command signal remained constant during pulsing. This should be rectified as pump damage could result.



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