

Requires High attention  
Requires Medium attention  
Needs to be maintained

## MACHINE HEALTH CHECK UP

|   |                              |                                      |               |
|---|------------------------------|--------------------------------------|---------------|
|   | MAKE                         | HEIDELBERG                           |               |
|   | MODEL                        | SM74 - 4H -P3                        |               |
|   | SERIAL NUMBER                | 623833                               |               |
|   | TOTAL IMPRESSIONS            | 12,19,61,259                         |               |
|   | DATE                         | 10.10.2022                           |               |
|   | ENGINEER                     | AJITH KUMAR                          |               |
| 1 | Raw Water condition          | Water 1                              | Water 2       |
|   | pH                           | 6.55                                 | 8.11          |
|   | Conductivity                 | 61 µS                                | 290 µS        |
|   | Hardness                     | 1                                    | 6             |
|   | Temperature                  | 25 Degree C                          | 25.5degree    |
| 2 | Preparation of Damp Solution |                                      |               |
|   | Tank Capacity                | 80L                                  |               |
|   | IPA 10%                      | 8L                                   |               |
|   | Fountain Solution 2%         | 1.6L                                 |               |
|   | Raw Water                    | 70.4L                                |               |
| 3 | Condition of Damp Solution   | Before                               | After         |
|   | pH                           | 4.93                                 | 4.69          |
|   | Conductivity                 | 1658µS                               | 771µS         |
|   | Temperature                  | 12.5 Degree C                        | 12.5 Degree C |
| 5 | Room Temperature             | 23 Degree C                          |               |
| 6 | Oil Level                    | Half tank was there and was filled   |               |
| 7 | Condition of Feeder          |                                      |               |
|   | Suction Head                 | Good                                 |               |
|   | Lifting Sucker               | Good                                 |               |
|   | Forwarding Sucker            | Good                                 |               |
|   | Pull Lay OS movement         | Requires service to correct movement |               |
|   | Pull Lay DS movement         | Good                                 |               |
|   | Forwarding runners OS        | Average                              |               |
|   | Forwarding runner DS         | Average                              |               |
|   | Forwarding Tapes             | Good                                 |               |
|   | Front lay overall movement   | Good                                 |               |
|   | Front lay DS movement        | Good                                 |               |
|   | Frontlay OS movement         | Good                                 |               |
|   | Front lay sensor OS          | Good                                 |               |
|   | Front lay sensor DS          | Good                                 |               |
|   | Fontlay Height               | Good                                 |               |
|   | Sheet arrival motor          | Good                                 |               |
|   | Sheet arrival chain          | Requires service to correct movement |               |

|           |                           |                                                                                |            |            |            |
|-----------|---------------------------|--------------------------------------------------------------------------------|------------|------------|------------|
|           | Requires High attention   | <div>PRINTOCARE<sup>®</sup></div> <div>SALES   CONSULTANCY   ENGINEERING</div> |            |            |            |
|           | Requires Medium attention |                                                                                |            |            |            |
|           | Needs to be maintained    |                                                                                |            |            |            |
| <b>8</b>  | <b>Printing Unit</b>      | <b>PU1</b>                                                                     | <b>PU2</b> | <b>PU3</b> | <b>PU4</b> |
|           | Pressure Motor            | Good                                                                           | Good       | Good       | Good       |
|           | Lateral register motor    | Slow                                                                           | Good       | Good       | Good       |
|           | Circumfrential motor      | Good                                                                           | Good       | Good       | Good       |
|           | Diagonal motor            | Good                                                                           | Good       | Good       | Good       |
|           | Plate cylinder            | Good                                                                           | Good       | Good       | Good       |
|           | Plate Clamping            | Good                                                                           | Good       | Good       | Good       |
|           | Blanket Packing Sheet     | Un cal                                                                         | Un cal     | Un cal     | Un cal     |
|           | Blanket Torque            | Less                                                                           | More       | More       | More       |
|           | Blanket Packing Height    | 0.15 +                                                                         | 0.12 +     | 0.13 +     | 0.12 +     |
|           | Blanket cylinder          | Good                                                                           | Good       | Good       | Good       |
|           | Impression cylinder       | Good                                                                           | Good       | Average    | Average    |
|           | Perfecting cylinder       | Good                                                                           | Good       | Good       | Good       |
|           | Transfer Jacket T1        | Average                                                                        | Average    | Average    | Average    |
|           | Transfer Jacket T2        | Average                                                                        | Average    | Average    | Average    |
| <b>9</b>  | <b>Inking Unit</b>        | <b>PU1</b>                                                                     | <b>PU2</b> | <b>PU3</b> | <b>PU4</b> |
|           | Ink zone motor            | Good                                                                           | Good       | Good       | Good       |
|           | Ink zone sero setting     | Poor                                                                           | Poor       | Poor       | Poor       |
|           | Rollers status            | Average                                                                        | Average    | Average    | Average    |
|           | Ink Roller setting        | Average                                                                        | Average    | Average    | Average    |
|           | Ink Roller setting screws | Average                                                                        | Average    | Average    | Average    |
|           | Ink form roller on/off    | Good                                                                           | Good       | Good       | Red DS     |
|           | Vibrator roller on / off  | Good                                                                           | Good       | Good       | Good       |
|           | Auto Roller washing       | Not in use                                                                     | Not in use | Not in use | Not in use |
|           | Washing blade             | Good                                                                           | Good       | Good       | Good       |
|           | Intermediate roller       | Good                                                                           | Good       | Good       | Poor       |
|           | Ink duct divider          | Poor                                                                           | Poor       | Poor       | Poor       |
|           | Ink duct consumables      | Changed                                                                        | Changed    | Changed    | Changed    |
| <b>10</b> | <b>Dampening Unit</b>     | <b>PU1</b>                                                                     | <b>PU2</b> | <b>PU3</b> | <b>PU4</b> |
|           | Dampening drive motor     | Good                                                                           | Good       | DS         | Good       |
|           | Water level sensor        | Good                                                                           | No         | No         | No         |
|           | Dampening rollers         | Pan                                                                            | Pan        | Pan        | Pan        |
|           | Form roller on/off        | Good                                                                           | Good       | Good       | Good       |
|           | Dampening roller on / off | Good                                                                           | Good       | Good       | Good       |
|           | Dampening roller setting  | Good                                                                           | Good       | Good       | Good       |
|           | Setting screws            | Average                                                                        | Average    | Average    | Average    |
|           | Roller status             | Average                                                                        | Average    | Average    | Average    |
| <b>11</b> | <b>Print Test</b>         | <b>PU1</b>                                                                     | <b>PU2</b> | <b>PU3</b> | <b>PU4</b> |
|           | Solid Test                | OK                                                                             | OK         | OK         | OK         |
|           | Dampening Test            | Ok                                                                             | Ok         | DS drive   | Ok         |
|           | Infeed Test               | Requires service                                                               |            |            |            |
|           | Runnability               | Good                                                                           |            |            |            |

|           |                                     |                                                                                                                                       |            |            |            |
|-----------|-------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------|------------|------------|------------|
|           | Requires High attention             | <br><small>SALES   CONSULTANCY   ENGINEERING</small> |            |            |            |
|           | Requires Medium attention           |                                                                                                                                       |            |            |            |
|           | Needs to be maintained              |                                                                                                                                       |            |            |            |
|           | Color consistency                   | Average                                                                                                                               | Average    | Average    | Average    |
| <b>12</b> | <b>Delivery Unit</b>                |                                                                                                                                       |            |            |            |
|           | Delivery chain                      | Good                                                                                                                                  |            |            |            |
|           | Air blowers                         | Good                                                                                                                                  |            |            |            |
|           | Air Blower adjustment               | Good                                                                                                                                  |            |            |            |
|           | Fan                                 | 2 Middle fan defective                                                                                                                |            |            |            |
|           | Fan adjustment                      | Good                                                                                                                                  |            |            |            |
|           | Sheet slow down device              | Good                                                                                                                                  |            |            |            |
|           | Spray Podwer system                 | Good                                                                                                                                  |            |            |            |
|           | Sheet releasing cam                 | Good                                                                                                                                  |            |            |            |
|           | Air fliters                         | Good                                                                                                                                  |            |            |            |
| <b>13</b> | <b>Peripheral Units</b>             |                                                                                                                                       |            |            |            |
|           | Technotrans                         | Manual IPA & Fount dose                                                                                                               |            |            |            |
|           | Air compressor                      | Working                                                                                                                               |            |            |            |
|           | Pnemantic Compressor                | Working                                                                                                                               |            |            |            |
| <b>14</b> | <b>CPC Functions</b>                |                                                                                                                                       |            |            |            |
|           | Push buttons                        | Working                                                                                                                               |            |            |            |
|           | Ink Key buttons                     | Working                                                                                                                               |            |            |            |
|           | Ink Key lights                      | Working                                                                                                                               |            |            |            |
|           | Day light lamps                     | Working                                                                                                                               |            |            |            |
|           | Job Saving                          | Working                                                                                                                               |            |            |            |
|           | Light Pen                           | Working                                                                                                                               |            |            |            |
|           | Missing push button                 | Nothing                                                                                                                               |            |            |            |
|           | Electrical Erros                    | Wash up devices                                                                                                                       |            |            |            |
| <b>15</b> | <b>Safety Guards &amp; Switches</b> | <b>PU1</b>                                                                                                                            | <b>PU2</b> | <b>PU3</b> | <b>PU4</b> |
|           | Intermediate guard                  | Gaspring                                                                                                                              | Gaspring   | Gaspring   | Gaspring   |
|           | Dampening system guard              | Ok                                                                                                                                    | Ok         | Ok         | Required   |
|           | Cylinder guard                      | Ok                                                                                                                                    | Ok         | Ok         | Ok         |
|           | Emergency Swtich                    | Ok                                                                                                                                    | Ok         | Ok         | Ok         |
| <b>16</b> | <b>Air Filters</b>                  | Good                                                                                                                                  |            |            |            |
| <b>17</b> | <b>Cleanliness</b>                  | Very Good                                                                                                                             |            |            |            |
| <b>18</b> | <b>Parts Replacement</b>            | Required                                                                                                                              |            |            |            |
| <b>19</b> | <b>Details of Parts required</b>    | Will be sent by mail                                                                                                                  |            |            |            |
| <b>20</b> | <b>Major issues</b>                 | White spot during cold lamination                                                                                                     |            |            |            |

| PARTS RECOMMENDATION |                                                       |          |
|----------------------|-------------------------------------------------------|----------|
| SL.NO                | PARTS DESCRIPTION                                     | QUANTITY |
| 1                    | Compression spring - 66.028.103                       | 2Nos     |
| 2                    | Bellows - L2.072.324                                  | 2Nos     |
| 3                    | Ink fountain divider - M2.008.113 ( O/S )             | 4Nos     |
| 4                    | Ink fountain divider - M2.008.114 ( D/S )             | 4Nos     |
| 5                    | Dampening guard gas spring (Sample part is required)  | 1Nos     |
| 6                    | Intermediate guard gas spring 00.580.4362/ "082538" ? | 4Nos     |
| 7                    | Separator M2.033.571 /02 or Support cpl M2.033.570B/  | 6 Nos    |
| 8                    | Caslibrated Blanket Packing sheet 0.40mm              | 4 Nos    |
| 9                    | Water level sensor - M2.198.1563/02                   | 3 Nos    |

| List of service activities required to be done |                                                                             |             |
|------------------------------------------------|-----------------------------------------------------------------------------|-------------|
| 1                                              | Ink zone zero setting to be done in all the 4 units                         | Mechanical  |
| 2                                              | Blanket packing height must be corrected                                    | Mechanical  |
| 3                                              | On/Off function of 3rd ink form roller (Red) in DS of PU4 must be corrected | Mechanical  |
| 4                                              | Intermediate roller of Printing Unit 4 must be serviced or replaced         | Mechanical  |
| 5                                              | Dampening drive of PU3 must be checked and corrected in DS                  | Mechanical  |
| 6                                              | Water level sensor must be purchased and fixed in PU2, PU3, & PU4           | Electrical  |
| 7                                              | Delivery Fan - 2 numbers are not working and must be checked and corrected  | Electrical  |
| 8                                              | Lateral register motor in PU1 must be checked and corrected                 | Electrical  |
| 9                                              | White spot during cold lamination must be solved                            | Application |