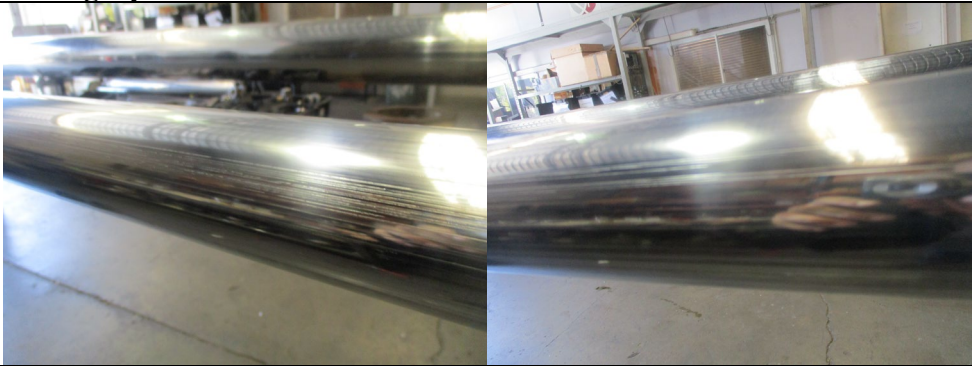










**CUSTOMER ABC REPAIR REPORT**  
**ACTUATING LINEAR CYLINDER**

JOB No:	200048	DATE:	05-05-2020
INSPECTED/REVIEWED BY:	Corey/ Mark		
DESCRIPTION:	CYLINDER ASSEMBLY, ACTUATING LINEAR: HYDRAULIC: D100 X 70 X 4050: DWG 0451291UO V100 DR.SPACER 70: MAXIMUM OPERATING PRESSURE: 95 BAR		
FAULTS ON CYLINDER AS NOTED BY CUSTOMER ABC:			
REQUIRES OVERHAUL			






<b>Qty</b>	<b>Part</b>	<b>Condition</b>	<b>Recommendations/Notations:</b>	<b>Photograph</b>
1	Piston Rod	Replace	<p>Multiple score on one side of the chrome surface along its full length.</p> <p>A new Piston Rod will be made from Induction hardened chrome bar.</p>	
1	Head Cap	Replace	<p>The internal diameter of the Head Cap has scoring and tear marks running through the seal grooves.</p> <p>A new Head Cap will be made.</p>	




1	Barrel and Trunnions	Reclaimable	<p>The thread in the Barrel needs rust treatment and a polish to remove burrs.</p> <p>The bore needs light honing to remove surface defects.</p> <p>The Trunnion Journals have rusted. They will be cleaned up with light to medium abrasives and being chemically treated.</p> <p>The Barrel can be reused.</p>		
1	Piston	Reclaimable	<p>The Piston needs polishing in the seal grooves and can be reused.</p>		


1	Piston Locknut	Replace	<p>The Piston Locknut has some damage through the thread from the scotch key.</p> <p>A new Locknut will be made.</p>		
1	Front Gland	Reclaim	<p>The Front Gland has some rust in some of the sealing areas which will be polished and chemically treated.</p> <p>The Front Glad can be reused.</p>		
1	Stop Tube	Reclaim	<p>The Stop Tube needs polishing internally to remove a couple of light scratches and it can be reused.</p>		

1	End Cap	Reclaim	<p>The End Cap ports face need to be smoothed with an oil stone and the port threads need some rust treatment.</p> <p>The end cap will be reused.</p>	
1	Rod Eye	Reclaim	<p>The Rod Eye was heavily caked with dust and grit. It needs rust treatment in the bearing housing and circlip grooves and a tidy up of the thread.</p> <p>The rod eye will be reused.</p>	



					
1	Manifolds and Valves	Reclaim	<p>The Check Valves were tested individually in an external test rig and both had zero leakage.</p> <p>The Manifolds need their sealing faces smoothed with an oil stone and some rust treatment and they will be reused.</p> <p>The Relief Valve will be checked for operation during testing after the cylinder is assembled.</p>	 	
2	Pipework	Reclaim	<p>The two pipes running along the length of the cylinder will be cleaned through with cleaning projectiles.</p> <p>The flanges welded on the ends will have their sealing faces smoothed with an oil stone and the pipes will be reused.</p>	 	

1	Fittings	Replace	The fittings are different sizes to those in all previous repairs. They will be replaced as instructed by the Smelter so they conform with other equipment as an interchangeable spare.		
1	Bearing	Replace	The bearing is rusted and worn and will be replaced.		
1	Fasteners	Replace	All socket head caps screws will be replaced.		

1	Seals	Replace	All seals will be replaced.	
1	Paint	Repaint	Paint will be stripped from all reusable parts prior to assembly. The cylinder will be repainted international orange after testing.	
1	Welds	Tested	All welds will be inspected and tested.	N/A

**Action Required:**

- Disassemble, Inspect and Report.
- Paint Stripping and Rust Treatment of all Components, Tidy up of Listed Components.
- Manufacture Piston Rod.
- Manufacture Head Cap.
- Manufacture Piston Locknut.
- Hone Barrel and Tidy up Trunnion Journals.
- Supply of Locking Washer.
- Replacement Fasteners and Fittings.
- Mag Particle Testing and Inspection of all Welds.
- Replacement of all Seals and Bearings.
- Testing of all Valves.
- Clean, assemble, test and paint.