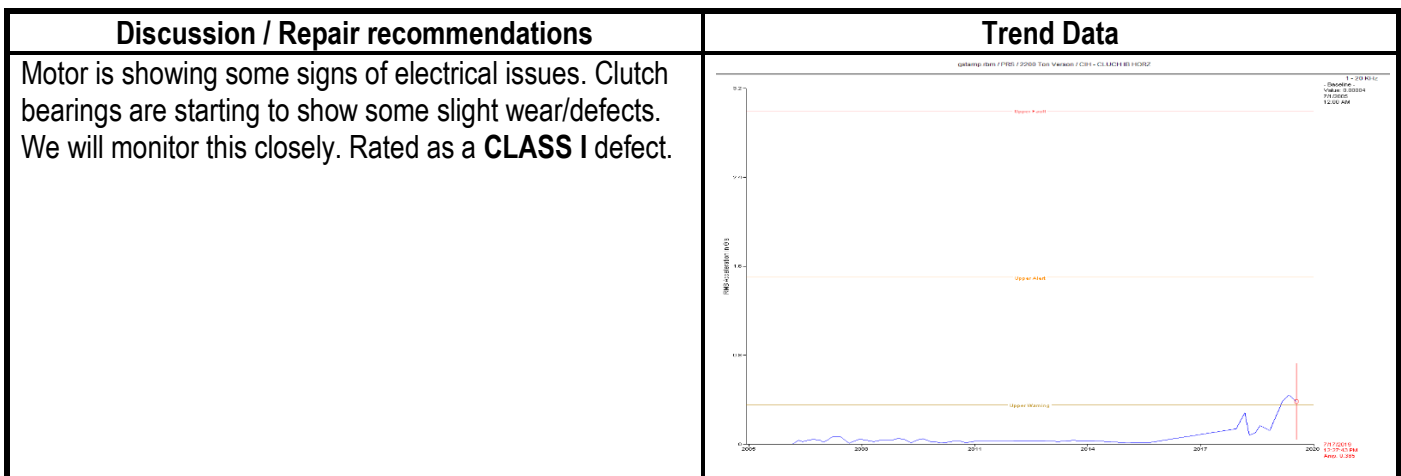
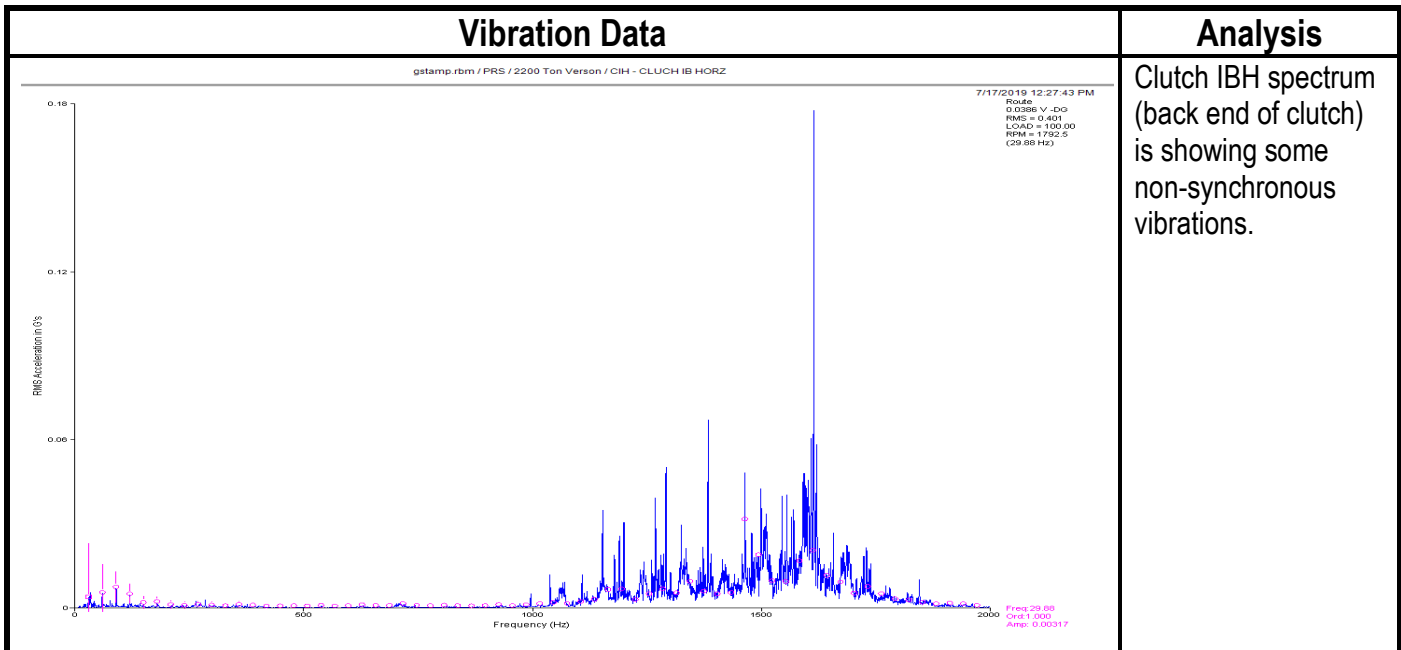




Client	Grenada Manufacturing	Survey Date	7/17/19
Location	Presses	Report Date	7/24/19
Machine	2200 Ton Verson	QMS No.	140195
Component	Clutch	Analyst	KWM

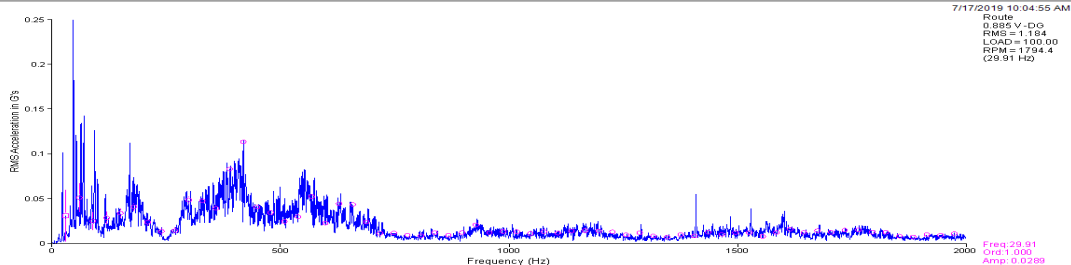
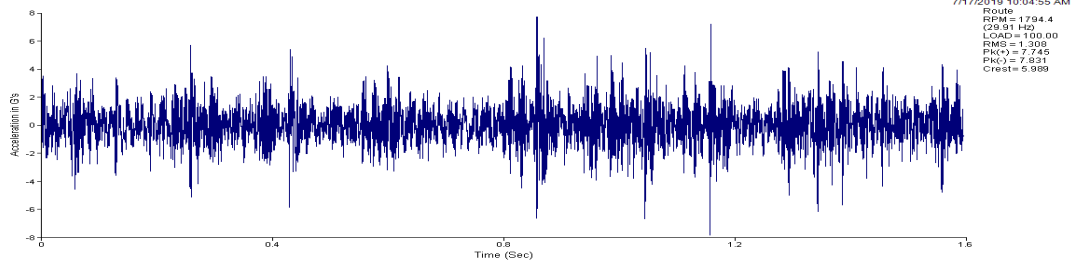
Defect Rating for this machine	CLASS I
Defect Rating System	
Class I : Defect is present , but effect on reliability is not clear; no immediate action is required. Continue normally monitor.	Class III : Defect (s) present that may cause failure in short term (less than 2 mo.). Should be addressed as soon as practical, with a high maint. priority. Increase monitoring frequency.
Class II : Defect (s) present that may cause problem in long term (2-6 mo.). Repair during normal maint. scheduling. Continue to monitor.	Class IV : Defect (s) present that make continued reliability unpredictable, and possibility of secondary damage is high. Repairs should be made ASAP. An unscheduled shutdown should be considered for repairs.

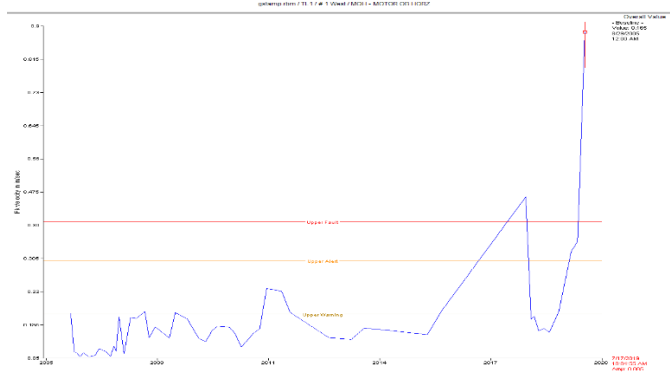




Client	Grenada Manufacturing	Survey Date	7/17/19
Location	Tandem Line 1	Report Date	7/24/19
Machine	# 1 Press	QMS No.	140195
Component	Motor/Clutch	Analyst	KWM

Defect Rating for this machine	CLASS III
Defect Rating System	
Class I : Defect is present , but effect on reliability is not clear; no immediate action is required. Continue normally monitor.	Class III : Defect (s) present that may cause failure in short term (less than 2 mo.). Should be addressed as soon as practical, with a high maint. priority. Increase monitoring frequency.
Class II : Defect (s) present that may cause problem in long term (2-6 mo.). Repair during normal maint. scheduling. Continue to monitor.	Class IV : Defect (s) present that make continued reliability unpredictable, and possibility of secondary damage is high. Repairs should be made ASAP. An unscheduled shutdown should be considered for repairs.

Vibration Data	Analysis
<p>gstamp.rbm / TL1 / # 1 West / MOH - MOTOR OB HORIZ</p>  <p>7/17/2019 10:04:55 AM Route 9.995 V-DO RMS = 1.184 LOAD = 100.00 RPM = 1794.4 (29.91 Hz) Freq: 29.91 Ord: 1.000 Amp: 5.0289</p>  <p>7/17/2019 10:04:55 AM Route RPM = 1794.4 (29.91 Hz) LOAD = 100.00 RMS = 1.306 Phc(+) = 7.745 Phc(-) = 7.831 Crest = 5.989</p>	<p>Motor outboard spectrum shows a significant low frequency noise floor. Waveform data shows heavy impacting with amplitude of over 14 g's peak to peak.</p>

Discussion / Repair recommendations	Trend Data
<p>Motor and possibly the clutch bearings appear to be defective and or have inadequate lubrication. It is highly recommended to inspect the motor bearings and clutch bearings for defects, wear, and lubrication SOON. Rated as a CLASS III defect.</p>	 <p>7/17/2019 10:04:55 AM Route RPM = 1794.4 (29.91 Hz) LOAD = 100.00 RMS = 1.306 Phc(+) = 7.745 Phc(-) = 7.831 Crest = 5.989</p>