

SUGGESTED INSPECTION & MAINTENANCE RECORD



Company		Address	
Press Equipment No.		Location	
Press Model	Make	Serial No.	
Tonnage	Installation Date	Aux Equip: Feed	Scrap Shear
Reel	Cradle	Straightener	Other
Type of Point of Operation guarding:			

	Inspection Interval	OK	Date	Maintenance Required	Date Repaired	Shop Order No.
FRAME CONDITION						
Members solid	M					
Bed Level	3M					
Tie rods secure	M					
Brackets/Components Secure	W					
LEGS (OBI)						
Solid	M					
Secure to frame	M					
Bolted to floor	M					
POINT OF OPERATION						
Guards in place & secure	D					
Adjusted properly	D					
Devices being used properly	D					
Devices adjusted properly	D					
Hand tools used (if req'd.)	D					
KNOCKOUT BAR						
Proper adjustment	D					
Brackets secure	D					
Adjusting screws straight	D					
Bar straight	D					
Brackets secure	D					
AIR PRESSURE SETTING						
Proper air pressure - Clutch, Ctr. Bal., Other (specify)	D					
COVERS						
Flywheel - In place & secure	M					
Gear - In place & secure	M					
Clutch - In place & secure	M					
Brake - In place & secure	M					
Feed & scrap shear in place	W					
Others - In place & secure	M					
FULL ROTATION CLUTCH						
Engage & disengage properly	W					
Tripping mech. Shielded	W					
Proper lubrication	D					

Notes: D = DAILY, W = WEEKLY, M = EVERY MONTH, 3M = EVERY THREE MONTHS, 6M = EVERY SIX MONTHS

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	Inspection Interval	OK	Date	Maintenance Required	Date Repaired	Shop Order No.
AIR CLUTCH						
Engage & disengage properly	W					
Proper lining wear	W					
Proper air pressure	D					
Airline filter clean	D					
Clutch properly lubricated	D					
Air swivel properly lubricated	3M					
BRAKE						
Proper lining wear	W					
Properly adjusted	D					
Proper air pressure	D					
CONTROLS						
Functioning properly	W					
Controls being used properly	D					
Set properly for operation	D					
All electrical covers in place	M					
All wire protected	M					
Proper fusing & thermal units	3M					
Air pres. Switches properly set	3M					
LUBRICATION						
Lubrication functioning prop.	D					
Press lubed properly (visual)	D					
Proper oil level in slide adj.	D					
Oil or grease in reservoir	D					
Lines and fittings intact	D					
BEARINGS						
Main – clearance	6M					
Connection – clearance	6M					
Wrist or ball – clearance	6M					
Total clearance of slide assy.	6M					
Antifriction – properly lubricated	6M					
Antifriction – properly fit	6M					
SLIDE						
Record parallelism	6M					
Record gib clearances	6M					
Even gib wear	M					
Slide flange secure	M					
Slide adj. Functioning properly	M					
SLIDE COUNTERBALANCE						
(Spring Type) intact	W					
Properly adjusted	W					
(Air Type) intact	W					
Proper air. Pressure for job	D					
Proper lubrication	D					
Surge tanks drained	D					

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	Inspection Interval	OK	Date	Maintenance Required	Date Repaired	Shop Order No.
GEARS						
Proper lubrication	W					
Even wear	6M					
Driveshaft & crank, straight	6M					
Proper fit on shaft	6M					
Teeth intact	6M					
Record backlash	6M					
FLYWHEEL/SHEAVE/BELTS						
Flywheel secure on shaft	M					
Sheave grooves aligned with flywheel grooves	3M					
Belt wear	3M					
Proper belt tension	3M					
MOTORS						
Secured to bracket						
Bracket secure to press	M					
Motor brkt. hinge pin wear	M					
Adjusting mechanism secure	M					
Restraining cable secure	M					
Wires protected	M					
OVERLOAD						
Press appears overloaded?	M					
Further inspection required	D					
AIR BLOW OFF						
Hoses & fittings	D					
Proper adjustment	D					
PNEUMATIC CUSHION						
Air controls adjusted properly	D					
Lines & fittings	M					
CLEAR OF SCRAP/DEBRIS						
Well lighted	D					
Oil splatter	D					
Noise level	D					

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Inspection performed by: _____

Date: _____

A complete file of Engineering and Manufacturing records, technical data, and other special information pertaining to your Bliss Clearing Niagara press is kept in our files.

If at any time you need further assistance, please contact our Service Department or our Repair Parts Department. Our qualified Field Service Technicians are also available to you upon request.

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FOUNDATIONS

It is impractical for us as a machine manufacturer to make recommendations on thickness of foundation walls, foundation floors, or foundation footings because of the great variation of soil conditions at the point of installation of our equipment.

Another reason for not making specific recommendations is the great variation in type of concrete mixes and the variation in uses of concrete reinforcing.

As a guide for your general use, however, the table shown here gives a general classification of soils and the safe pressure which they may support. These values approximate the pressures allowed by the building law in most cities.

If there is any question relative to thickness of foundations, types of reinforcing, etc., we would suggest that you consult a local contractor who is acquainted with soil conditions in your locality.

SAFE BEARING IN SOILS

NATURE OF SOIL:	Safe Bearing Capacity, Tons Square Foot
Solid ledge of hard rock, such as granite, trap, etc	25 - 100
Sound shale and other medium rock, requiring blasting for removal	10 - 15
Hardpan, cemented sand & gravel, difficult to remove by picking	8 - 10
Soft rock, disintegrated ledge; in natural ledge, difficult to remove by picking	5 - 10
Compact sand and gravel, requiring picking for removal	5 - 6
Hard clay, requiring picking for removal	4 - 5
Gravel, coarse sand, in natural thick beds	4 - 5
Loose medium and coarse sand, fine compact sand	3 - 4
Medium clay, stiff but capable of being spaded	2 - 4
Fine loose sand	1 - 2
Soft clay.	1

2 x Press Weight = Dynamic load Dynamic load has to be spread over feet areas.

GENERAL FOUNDATION SPECIFICATIONS

As a general guide, the following should be used in determining a foundation:

- A. If the soil on which the foundation is to be poured is of a hard clay type, the bearing capacity of that soil is approximately 4 to 5 tons per square foot.
- B. The foundation should consist of reinforced concrete, rigid enough to support the press weight plus an allowance of approximately 100% to compensate for the dynamic forces of blanking. This condition requires that condition A (above) is met or exceeded.
- C. It is suggested that a local contractor who is familiar with the area soil conditions be consulted.
- D. For best results, the press should be mounted on an isolated inertial block so that vibrations are reduced to the surrounding building and equipment. The size of the inertia block is determined using conditions A, B and C from above. It is suggested that the inertia block be separated from the surrounding floor by at least one inch of material such as insulation board or material which will give and take such things as vibration and expansion from temperature change.
- E. Special care should be taken to provide a smooth, level mounting surface. Concrete alone does not usually provide a good enough surface. One method of providing an accurate mounting surface is to set a steel mounting plate into the concrete when the foundation is poured. Anchor bolts to fix the press to the foundation also be cast into the foundation.
- F. The foundation should also be located away from the building foundation and any ceiling supports by a distance of approximately 8 to 10 feet.

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