

Work sheet no. 60553

LAUFFER
PRESSEN

Customer		Invoice address		Job classification	
Address customer	Customer no.	Company	Customer no.	Work completed	Warranty
	3547406			Pre-visited	Invoice
Malmo				Follow on visit required	Goodwill
Box 10036				Driver	Status
SE-20035 MALMO					
Contact person		Order no.			

Visit data				Engineer data	
Date	Travel (Start/End)	Breaks	Distance (km)	Name	Pr. No.
20.01.2016	6:30-14:00		120km	Blank Günter	2152
22.01.2016	7:45-16:00	1st			

Machine data (Start/End)						
R.No.	Date	M/C No.	M/C type	Operating hrs.	Preliminary work	Work hrs.
1	20.01	13987	RHV 70			14:00-17:00
2	21.01					7:45-17:00
3						1st
4						
5						
6						
7						

Spare parts (Type: V=by usage, A=quote, B=order, R=return delivery)			
R.No.	Type	Qty.	Description

Problem report / Work report	
R.No.	
	Ausbau der Heizplatten, und Kolben Kolben kann nicht abgesenkt werden, Kolben L 570 mm, Tiefe Zyl. Rohr 570 mm

In the event that special tools have been supplied please return a.s.a.p.

We herewith confirm correctness of a.m. working hours, use of material and proper performance of work subject to the present terms and conditions (general terms as per VDMA, respectively relevant version).

Remarks

Signature

Customer

KAWA
GmbH
LAUFFER Engineering
Günter Blank

Maschinenfabrik LAUFFER GmbH & Co. KG
Industriestraße 101
D-72180 Horb-Industriegebiet
Tel.: (0 74 51) 9 02-199 Fax: (0 74 51) 9 02-114
service@laufer.de

For warranty or exchange items please return parts replaced on site within one week with a copy of this service report.

Kommanditgesellschaft, Sitz Horb a.N., Registergericht Stuttgart HRA 722079, USt-ID DE258034414
Komplementär: LAUFFER GmbH, Sitz Horb a.N., Registergericht Stuttgart HRS 727086
Leiterplattentechnik / Industrievertretung

Copy customer

Oil Hydr. Multilayer Press Plant

Type : RMV 70/4

Design as per Drawing No. 9-02 600.04/2

Heating press		
max. pressure	 (kN)	700
drive power	 (kW)	2.2
speeds -fast advance	 (mm/s)	20.8
-clamping	 (mm/s)	1.7
-retract	 (mm/s)	30
Pressing cylinder -diameter	 (mm)	210
-number		1
		5
Heat. platen -number	 (mm)	600*650
-size		MRST 52-3
-material	 (mm)	84
-daylight		Thermoöl
-electr./thermal oil/steam heated		330
-max. heating temperature	.. (grd C)	+/-1.5
-temp. accuracy	 (K)	

Vacuum device	R5 63-136
Vacuum pump -type	(kW) 1.5
Drive power	(mbar) 2
min. air pressure	(Nm ⁻³ /h) 63
max. suction capacity	(Nm ⁻³ /h) 500
req. suction cap. f. pump cooling	

Heating control	
Temp. control in Microprocess. contr. integr. ..	x
Temperature feeler -type	L

Control of machinery	7-02	411.01/3
Functional sequence schematic	7-02	410.01/2
Hydraulic schematic	7-02	836.25/4
Vacuum schematic	7-02	609.35/3
Pneumatical schematic	7-03	005.01/2
Cooling schematic	7-70	712.10/3
Electrical schematic		x
Modes of operation		x
-setting up		
-semiautomatic		\$5 115U
Microproc. control		Siemens
-type		
-make		(°C) 40
Temperature Control Cabinet - max.		

KAWA
x
\$5 115U
Siemens
(°C) 40
GmbH

	1.	2.	3.
Hydr.drive	1.		
Pump	- Hydr. Aggregat		
Type	- S65740		
Make	- Rexroth		
Rotation(rpm)	- 1450		
Rot. direc. .	- rechts		
Q-max (l/min)	- 4/56		
Motor	- Drehstromflansch-		
Design	- V1-112M		
Power ... (kW)	- 2.2		
Voltage .. (V)	- 380		
Connec./Freq.	- Dreieck/50hz		
Protec.class.	- IP 54		

Hydraulic oil (oil recommend. sh. 00.0301.001)
Quality as per DIN 51525 (high pressure resist.) HLP
Viscosity (cSt) 46
Capacity (ltr) 270

Electr. supply

Connection power	(kW)	7
max. prefuse	(A)	35
Operation voltage	(V)	380
Control voltage	(V)	24 =
Solenoid voltage	(V)	24 =
Frequency	(hz)	50
Nominal current	(A)	11

Miscellaneous

- 4 Floor transport basket
- Depinning Station for Press tools 650*600
- Handlingstation MAK 65/50
- Lay-up Station
- Roller with Base Frame
- 2 Ball table 700*700
- Loading- and offloading Station
- Thermal oil heating plant- oil capacity 100 ltr.