



		<h2>Service Report</h2>				<b>TRUMPF, Inc.</b> Service Department 111 Hyde Road Farmington, CT 06032 Tel. 860 678-8584 Fax. 860 255-6678	
<b>Plant:</b>	<b>Group:</b>	<b>Engineer:</b>	<b>Personell no.:</b>	<b>Mission no.:</b>	<b>Type:</b>	<b>Case-no.:</b>	<b>Page:</b>
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<b>Machine</b>	<b>Number:</b> A0030A0813		<b>Type:</b> TruPunch 2020	
<b>Customer</b>	<b>Company:</b> Global Polymer Industries			<b>Customer no.:</b> 209140
	<b>Street:</b> 1001 South East 12th Street		<b>City:</b> Madison, SD 57042	<b>Country:</b> US
<b>Order</b>	<b>Customer order no.:</b>	<b>SAP Service order no.:</b>	<b>SAP Warehouse order no.:</b>	<b>SAP Sparepart order no.:</b>
<b>Contact</b>	<b>Contact Name:</b> Dan Palli		<b>Telephone:</b> +1 (605) 256 - 3150	
<b>Travel expenses</b>	<b>Total (miles):</b> 0			
<b>Machine hours</b>	<b>Date:</b> 04/08/2016	<b>NC:</b> 5903	<b>Resonator / HD-Pump 1:</b> 0	<b>Beam on / HD-Pump 2:</b> 0
<b>Customer comments</b>				

04/08/2016		
<b>Date</b>	<b>Engineer Signature</b> 08.04.2016 14:45:23	<b>Customer Signature</b> 08.04.2016 14:45:39
<b>Customer name</b> _____		

\* onward travel estimation

2016.03.01

**Times**

Passive travel=P

Date	Start Travel	Working Time		End Travel	Duration	Breaks	Mission no.
		From	To				
04/04/2016	05:00	14:00	15:47		10:17	00:30	1457624530
04/05/2016		07:30	19:00		11:00	00:30	1457624530
04/06/2016		08:00	19:19		10:49	00:30	1457624530
04/07/2016		08:16	20:17		11:31	00:30	1457624530
04/08/2016		08:30	14:00		05:00	00:30	1457624530

**Activities**

Pos	Pic. Of damage	Objectgroup	Object part	Ins. Code	Product Fault	fixed Y/N	Hours
1						yes	35:00
<b>Problem:</b> Machine frame shows cracks at various points below die base.					<b>Cause:</b> Frequent high-tonnage operation.		
<b>Solution:</b> -Retrofitted air cushions in place of existing rigid wedge mounts. -Drilled 1" holes at ends of cracks to eliminate further propogation of cracks throughout machine frame. -Retrofitted turnbuckles to exterior of machine frame to maintain longitudinal rigidity. -Removed and reinstalled Y-axis motors for clearance. Reinstalled and checked Y-axis offset; good to 0.001". NOTE: Both Y-axis motors show signs of vibration damage. Y1 motor plug connections broken due to vibration. Y2 motor exhibits intermittent hum, accompanied by high temperature. -Recommend reworking high-tonnage program to use a less aggressive tool, since current tool is a 6-pin 0.25" round cluster tool. Calculated tonnage is roughly 14.5 tons per stroke. Uploaded customer .TMT file and .WZG files for current cluster tool in 2-pin and 4-pin configurations.							

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**Activities Continue**

Pos	Pic. Of damage	Objectgroup	Object part	Ins. Code	Product Fault	fixed Y/N	Hours
2	<b>Problem:</b> C1 axis drive motor plugs broken due to vibration.  <b>Solution:</b> Replaced C1 motor. Set radial alignment. Ran machine, tested OK.					yes	05:07
					<b>Cause:</b> Frequent high-tonnage operation.		

**Spare parts**

 Customer part = 10  
 Consignment part = 11  
 TRUMPF part = 20  
 Maintenance box part = 30

Warranty = X

To Pos.	Material No.	Description	Qty:	Status	Warehouse	
1	1212271	Installation Air cushions	1	Inserted		10
1	1625753	Installation package Basi	1	Inserted		10
1	1625772	Service kit torque wrench	1	Inserted		10