



Certificate of inspection

We hereby confirm that our company has inspected the technical condition of the machine:

Equipment:	Heidelberg SM 102-2-P
Year of Production:	2010
Serial number:	XXXXXX
Date of inspection:	11 September 2024
Certificate number:	3023-dggj27829gs1

During the inspection the current condition of the main components responsible for print quality was determined. Based on the results of the inspection, the data was entered into the report and recommendations for the current condition of the equipment were issued.

Appendices: inspection report, test result, photos and video.



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<https://pressinspection.com>



Printing Machine Report

Machine Manufacturer:	Heidelberg
Machine Type:	SM 102-2-P
Machine Serial No.	XXXXXX
Impression Counter	148.018.716
Machine Date	2010
Present Location of Machine:	XXXXXX
Report carried out by:	SW
Date of inspection:	11 of September 2024
Certificate no:	3023-dggj27829gs1

Check the authenticity of this certificate by this number above on the website <https://www.pressinspection.com>

General Appearance of Machine:

Normal working appearance. The machine needs to be preventively cleaned before dismantle

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✓ = OK

X = Faulty

% = Amount of wear

N/A = Not applicable

P = Picture

Job Test Description

The Heidelberg SM 102-2-P sheetfed printing machine was inspected on 11 September. A detailed description of the technical condition is given below. Here is a description of the conditions and results of the test.

During the inspection of the machine, three jobs were done according to our conditions:

<https://pressinspection.com/our-process/>

1. Kiss-print test.

Both offset webs and lining sheets under them were replaced. The offset web tightening force was checked - 45 n/m, set with a torque spanner. The minimum printing pressure was set to 0.1 and printed in 1+1 mode on both sides.

No sales and damage to the cylinders are not found.

Photos attached.

Kiss-printing is made after the sheets of paper have fallen into the ink rollers unit, so there are traces of scraps on the black ink. Visual inspection of the condition of the cylinders showed no defects.

2. The behaviour of the machine was tested on full size, 40 g/m² thin paper.

The test speed was 8,500 sheets per hour.

We took two similar plates and superimposed them on each other to check the condition of the grippers.

The 40 gram paper is outside of the manufacturer's recommended materials. According to the specification, the feeder is designed to handle papers from 70 grams/sqm. Jams occurred time and time again during operation. We had 500 sheets of paper of the maximum size, but most of it was rejected during setting up. The head of the feeder lifts the sheet and transports it to the feed table, but further on the table jams occurred in various places - both in the area of the side stops and on the table itself. The sheet reached the front stops, but clung to the holes in the feed table and the side stop. The printer tried changing the position of rollers and brushes, we changed the air supply. Three hours were spent on the test, but with no result.

Then we managed to print a 2+0 job on the test paper, at a speed of 8,000 sheets. But only about 100 sheets, after which the sheets began to jam and the machine switched off. On thin paper, a +/-0.1 mm horizontal throw between units was detected. But given the test conditions, the divergence does not indicate a problem with the clamshell bridge.

When the paper was changed to another 60 g/m² paper, the problems disappeared and the machine printed the job without any additional settings.

3- The same 2+0 job is printed at 8,000 speed.

A sample of 50 sheets was taken and the machine behaviour on six random sheets was analysed. No alignment problems were found. Photo attached. Work 1+1 after installation of the perfecting device was without problems.

Conclusions.

The Preset is not designed to work with papers lighter than 70 g/m², although it can handle 60 g/m² without any problems. Paper of 40 g/m² clings to the feeder table elements, and almost all the paper is crumpled and goes to waste paper.

After changing the paper, the problem disappeared and the machine coped with thicker paper perfectly.

In the process of general inspection several significant details were found.

1. The side deflator on the self-folder is broken, repaired with wire. A replacement is needed.
2. The transfer jacket after the first print unit is damaged.
3. The machine is equipped with an IR dryer which could not be checked, it has never been used.
4. Could not find the non-stop feeder rod, only one.
5. Description of inspection results, photos and video are attached.

Feeder: ✓ X % **Comments:** P

Forwarding Suckers		New suction cups	
Lifting Suckers		New suction cups	
Feeder Head		OK	
Pipes on Feeder Head		OK	
Feed Boards		OK	
Pre Loader			
Forwarding Wheels		OK	
Feed Tapes		OK	
Feeder Furniture		OK	
Cocking Motor		OK	
Forwarding flap			
Sheet Advance Motor			
Centring Device		OK	
Feeder Head Motor			
Anti Static device		N/A	
Check Feeder Head Cam			

Any other comments about Feeder:

The side blowout on the operator side is broken and screwed down with wire

Non-stop delivery frame found, but only one sword was found out of the entire non-stop stick kit for the feeder. They promise to have them somewhere. Keep in mind.

In Feed: ✓ X % **Comments:** P

Side Lays	OK	Feed Plate	OK
Head Lays	OK	Transfer in Cylinder	OK
Swing Arm	OK	Gripper Height Motor	OK
Ranger Drum	OK	Lights	OK
		Infeed cams	

Printing units:

Impression Grippers	OK	Duct roller	OK
Impression Gripper pads	OK	Manual Duct Clutch	OK
Transfer Grippers	OK	Duct Motor	OK
Transfer Gripper Pads	OK	Duct keys	OK
Star wheel Bars		Cams	OK
Blanket Washes	Brush	Cam Followers	OK
Roller Washes	Ok	Dampers & Adjusters	OK
Cylinder Washes	Tandem	Damper Gears	OK
Rilsan Rollers	Ok	Z Rollers	OK
Inkers	Ok	Damper Rams	OK
Impression Rams	Ok	Vario Dampening	N/A
Impression arms	Ok	Pressure motors	OK
Button Stations	OK	Inker Rams	OK
Plate Inserting System	Autoplate		

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✓ X % Comments: P

Oscillating Bearings	OK	Transfer Shells	OK
Gripper bar spring posts	OK	Variable drums	
Transfer Jackets	X	Damper Journals	

Perfecting Unit

Pincer Bar	OK	Cam Followers	OK
Pincer Grippers	OK	Storage Drum	OK
Cams	OK	Type of perfector	Semi-auto

Any Other Comments about Units

Transfer Jacket after 1st PU broken and needs to be replaced
Pictures attached

Safety: ✓ X % Comments: P

Is machine elevated?	NO		
Hand rails	OK		
Footboards	OK		
Side Panels	OK		
Drip Trays	OK		

Plate Cylinders:

Unit	Chrome	Cylinder	Bearing	Unit	Chrome	Cylinder	Bearing
1	OK	OK	OK	7			
2	OK	OK	OK	8			
3				9			
4				10			
5				11			
6				12			

Plate Clamp Air Leaks	OK	During inspection a couple of plastic hoses have changed	
Plate Clamp Locking Bolts	OK		
Plate Clamp Manual	OK		

Blanket Cylinders:

Unit	Chrome	Cylinder	Bearing	Unit	Chrome	Cylinder	Bearing
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1	OK	OK	OK	7			
2	OK	OK	OK	8			
3				9			
4				10			
5				11			
6				12			

Blanket Bars	OK	Autoplates checked, both OK	
Blanket Gap Bars			

Impression Cylinder:

Unit	Chrome	Cylinder/Jackets	Bearer	Unit	Chrome	Cylinder/Jackets	Bearer
1	OK	OK		7			
2	OK	OK		8			
3				9			
4				10			
5				11			
6				12			

Description of any damage on Plate, Blanket, Impression Cylinders and Bearers:

No detected damages or scratches on cylinders

Clock Plate, Blanket, Impression Cylinder's & list any running out of true:

Not detected

Delivery

✓ X %

P

Delivery Chains	OK	Deliver Plate	OK
Suction Slow Down	OK	Spray Recovery	
Delivery Fans	OK	Delivery Grippers	
De Curler	OK	Delivery Gripper Bars	OK
Blow Bars	OK	Delivery Joggers	OK
Air Controls	OK	Delivery Rake	OK
Spray Unit	OK	Delivery Back Gate	OK
Delivery Boards	OK	Check Slow Down Carbon Shaft	
Deliver Plate	OK		

Any other comments about Delivery:

Needs to be seriously cleaned. All units are in working condition

I/R Unit

Make of I/R	Heidelberg Drystar 2000 Ink		
Position of Lamps			
Hours on Lamps			

Hot Air Knife			
2 Slide			

UV System ✓ X % P

Make / Model of System			
Position of cassettes			
Lamp hours			
Condition of pipe work			
I/R Cassette			

Any other comments about IR/UV System

The printers don't use IR dryer and never turned on. We did not check due to a dirty delivery

Coating Unit.

Impression Cylinder			
Impression Cylinder Grippers			
Impression Gripper Pads		Coating Pump	
Metering Roller		Make and model of coating pump	
Blanket Cylinder		Coating Pipe Work	
Blanket Bars		Coating Unit Tools	
Pressure Motor		Anylox Roller	
Cocking, Motor		How many Analox rollers	
Lateral Motor		Type of coating unit system	
Circumferential Motor		Pan Roller	

Any other comments about Coating Unit:

Not equipped

Water Circulating Unit: ✓ X % P

Make and Model		Heidelberg BC 713 EF	
Alco Smart / AZR		No	
Dosing Unit			
Screen		No	

Chilled Rollers:

Make and model		Not equipped	
Deublin Couplins			
Pipe work			
In use or not			

Any other comments

A simple HydroStar device for two-color machine

Water Cooled Machine: ✓ X % P

Make and model of pump unit	NO	Is fans & pump complete with the press	
Make and model of Chiller fans		Is any of the pipe manifold to come with press	
Position and access of fan unit & access		Material used for pipe work	
Differential valve		Single or double pump unit	

Main Motor & Drive Belt:

Visually ok

List of Pump and Compressors:

Pneumatic compressor		AirStar. The cover is not mounted on the Airstar cabinet, located separately	
Cut of time of pneumatic Compressor			
Are all pumps complete with press			
KLM Boards			
Are all pumps running in cabinet			
Feeder Air Pressure		No, Preset with brushes and rollers	

Image Control: ✓ X % P

Screen		HET	
Light Values			
Errors Showing			
Soft ware			
Calibration Card			
White Strap			

Any other comments

Off Press Controls:

CP 2000 Screen	OK	Back Board	
CP Tronic Screen		Draws	

CPC Screen	OK	Press locked by Heidelberg	
Ink Zone Glass	OK	Inpress Control	
Light	OK	Prinect / Press Centre	

Technical Books:

Wiring Diagrams	ok	Spray Unit GRAFIX	ok
Operators Books	ok	Pumps Air Star	ok
Floor Plans. Available upon request		Coating Pump/	
Parts Books	ok	Air Star	ok
Technotrans Books / Alco Smart	ok	Dry Star	ok
Off Press Controls			

Electrical Details on main Electrical Panel:

Volts	200-220V/250A; 230-240V/200 A; 380-440V/125A
KW	46,5
I/P	
Fuse ICU:	

Electrical Details on I/R unit:

Volts	200-240V/100A. 350-415V/63A
KW	29
I/P	
Fuse ICU	

Electrical Details on UV System:

Volts	
KW	
I/P	
Fuse ICU	

Check access for removal of press i.e door dimensions, slope, loading area surface, access for transport:

Machine is located on the floor, ramp is available

Any Comments Regarding Specification of Press:

P

Maximum speed of Press		12000 iph	

Any Other Comments: