

**RL24P Checklist      Serial Number \_\_\_\_\_.**  
**Date \_\_\_\_\_ Customer \_\_\_\_\_.**

**Electrical control:**

✓ (Pass)	✓ (Fail)	Description	Comments	Check By	Date
		1) Verify configuration to sales order			
		2) Inspect for correct metering values			
		3) Verify mounting and security of all door meters, switches, push buttons, labels etc.			
		4) Verify wiring service loops are adequate. i.e. no binding or pinch points.			
		5) Verify pwr. transformer rating to metering.			
		6) Perform tug wiring tests on All termination's			
		7) Verify power and E-STOP tests have been performed.			
		8) Perform visual check for overall neatness of layout and cleanliness of control box.			
		9) Verify program was loaded, tested, and EEPROM was burned.			

**Heater head assembly:**

✓ (Pass)	✓ (Fail)	Description	Comments	Check By	Date
		1) Inspect electrical connections for proper crimp and torque.			
		2) Verify S shape strain relief of element leads.			
		3) Perform tug tests on All termination's.			
		4) Check elements for any damage or contamination.			
		5) Verify silver paint on underside of heater head to prevent paint oxidation.			
		6) Verify bake out and power tests performed.			
		7) Perform visual check of paint condition and hardware tightness.			
		8) Verify Dynarad Sign.			

**Ferris Wheel:**

✓ (Pass)	✓ (Fail)	Description	Comments	Check By	Date
		1) Verify doors for proper fit. (no gaps to heater head)			
		2) Verify grease packing of bearings.			
		3) Verify location of thermocouple. ( no interference to ingots)			
		4) Verify door interlocks functional.			
		5) Verify position and function of ingot jam interlock.			
		6) Perform visual check of paint condition and hardware tightness.			
		7) Check set screws on spacer behind the wheel.			

**Extractor :**

✓ (Pass)	✓ (Fail)	Description	Comments	Check By	Date
		1) Verify extraction tests have been performed. (all ingot orientations)			
		2) Verify extractor clearance to wheel. ( approx. 1/2 inch)			
		3) Verify fiber insulation wrap for security on both ends.			
		4) Verify extractor locked in position. ( wiggle arm and check lock bolts)			
		5) Verify air cylinder piston arm greased and locked in position.			
		6) Verify limit switch positions and security.			
		7) Visually inspect for all hardware security.			

**Pneumatic control:**

✓ (Pass)	✓ (Fail)	Description	Comments	Check By	Date
		1) Perform electrical wiring tug tests.			
		2) Verify air line routings			
		3) Verify E-STOP tests for pressure relief of entire air system.			
		4) Verify flow controls on air lines have been set and locked.			
		5) Verify E-STOP button (new) on outboard side of pneumatic control box.			
		6) Verify labeling on outside of control box for pneumatic connections.			

**Optical sensor:**

✓ (Pass)	✓ (Fail)	Description	Comments	Check By	Date
		1) Verify functional testing performed.			
		2) Verify sensor, and relay calibration has been performed. (see sec. F on page 10 of manual.)			
		3) Verify air line flow control set and locked.			

**Motor drives:**

✓ (Pass)	✓ (Fail)	Description	Comments	Check By	Date
		1) Verify motors seated and locked down.			
		2) Verify chain tension. ( approx. 1/2 inch flex)			
		3) Verify chain lightly oiled.			
		4) Verify motor servicing performed.			
		5) Visually inspect for paint condition and hardware security.			
		6) Verify oil level in gear box.			

**General:**

✓ (Pass)	✓ (Fail)	Description	Comments	Check By	Date
		1) Ensure all machine labeling and general appearance is adequate.			
		2) Verify compliance to sales order.			
		3) Ensure all accessories are attached or available to ship.			
		4) Check for manuals or other documentation necessary.			

**Final:**

✓ (Pass)	✓ (Fail)	Description	Comments	Check By	Date
		1) Check packaging for adequacy.			
		2) Verify trucking schedule.			
		3) Supervise loading and handling.			