

E12-3  
MAY

# MOTOCUT

## Final Product Check List MotoTilt

Date of Inspection: [dd/mm/yyyy]	20/02/2021	Overall Inspection Result:	Approved X	Not Approved
Product Name:	MT-25	Product Serial Number:	225010015	
Inspection Performed by:	Tmu	Signature:		


Nr.	Function	Serial Number	
1.	Rotator Serial Number	19101010-0015	
		Version Number	
2.	MotoTilt IO Controller Version	20200716	
3.	Cabin Unit PLC Version	20200716	
		Address	
4.	Cabin Unit Wireless CAN Unit Address	600913258368	
5.	MotoTilt Wireless CAN Unit Address	60091325F210	
Nr.	Function	Result	
		OK	NOK
6.	Leaks of Hydraulic Fittings	OK	
7.	Valve Functions	OK	
8.	Rotator Turning Directions	OK	
9.	Tilt Cylinder Directions	OK	
10.	Auxiliary Valve (Grapple) Directions	OK	
11.	Joystick Functionality	OK	
12.	Safety Labels are on Place (Control Box)	OK	

Final Approver Name	Signature	Date of Approval
		25/02/2021



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## Trial Run Report P-Series

Trial Run Start Date: [dd/mm/yyyy]	09/02/2021	Trial Run End Date: [dd/mm/yyyy]	10/02/2021
Product Name:	P-600	Product Serial Number:	16001010
Trial Run Performed by:	Tmu	Signature:	

Nr.	TEST TYPE	UoM	SPEC. LIMIT	TEST RESULT
<b>Measured Carrier Settings</b>				
1.	Pressure	[bar]	180-220	182
2.	Oil Flow	[l/min]	140-155	150
<b>Machine Calibration Parameters</b>				
			<b>Pile 1</b>	<b>Pile 2</b>
3.	Linear Stuck Error Delay	[ms]	3000	3000
4.	Torch Press Pressure Left	[bar]	25	25
5.	Torch Press Pressure Right	[bar]	25	25
6.	Compressor Pressure	[bar]	7	7
7.	Torch Arm Height Left	[mm]	-	-
8.	Torch Arm Height Right	[mm]	-	-
<b>Grapple Tests</b>				
Nr.	TEST TYPE	UoM	SPEC. LIMIT	TEST RESULT
9.	Max. Pile Lift Test	[OK / NOK]		OK
10.	Grip Pressure	[bar]	Same as carrier pressure	182
11.	Grip Pressure after 10 min holding	[bar]	Max 30Bar drop from initial	OK
<b>Parameters Used During Test</b>				
			<b>Pile 1</b>	<b>Pile 2</b>
12.	Pile Outer Diameter / Thickness	[mm]	510/25	630/16
13.	Nozzle 1 start	[mm]	-25	-15
14.	Nozzle 2 start	[mm]	-50	0
15.	Nozzle 3 start	[mm]	25	15
16.	Nozzle 4 start	[mm]	-20	-25
17.	Pierce Delay	[ms]	25	20
18.	Linear Speed	[% from max.]	50	80
19.	Plasma Current	[A]	85	85
20.	Grapple Pressure	[bar]	100	100



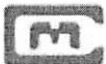
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## Final Product Check List P-Series

Date of Inspection: [dd/mm/yyyy]	09/02/2021	Overall Inspection Result:	Approved X	Not Approved
Product Name:	P-600	Product Serial Number:	16001010	
Inspection Performed by:	Tmu	Signature:	<i>Tmu</i>	

Nr.	Function	Result		
		OK	NOK	Value
1.	Leaks of Hydraulic Fittings	OK		-
2.	Upper Grapple Function	OK		-
3.	Main Grapple Function	OK		-
4.	Electrical measuring report (insulation measurement)	>1GΩ		-
5.	Nozzle Size Torch 1	-	-	85 [A]
6.	Nozzle Size Torch 2	-	-	85 [A]
7.	Nozzle Size Torch 3	-	-	85 [A]
8.	Nozzle Size Torch 4	-	-	85 [A]
9.	Home Sensor Function (Left Side)	OK		-
10.	Home Sensor Function (Right Side)	OK		-
11.	Home Position from Hard End (Left Side)	-	-	2 [mm]
12.	Home Position from Hard End (Right Side)	-	-	5 [mm]
13.	Linear movement (Left side)	OK		-
14.	Linear movement (Right side)	OK		-
15.	ID Plate is on Place	OK		-
16.	Safety Labels are on Place	OK		-
		Version Number		
25.	PLC Program Version	20201122		
26.	HMI Program Version	20201122		

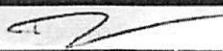


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Max. Pile Diameter								
Pile size: 630mm / 16mm								
Nr.	Test Type	UoM	Spec. Limit	Number of Tests				
				1	2	3	4	5
24.	Nozzle Alignment	[mm]	2	2,0	2,1	1,8	2,0	1,9
25.	Cutting Time	[min]	s	7	7	7	7	7

Pile with 25 mm wall thickness								
Pile size: 510mm								
Nr.	Test Type	UoM	Spec. Limit	Number of Tests				
				1	2	3	4	5
26.	Nozzle Alignment	[mm]	2	3,31	2,7	2,0	2,3	2,1
27.	Cutting Time	[min]	s	8	8	8	8	8

Final Approver Name	Signature	Date of Approval
<i>Jon Munnsterby</i>		<i>25/02/2021</i>

