

SERVICE COMPLETION REPORT

Report Number: SV-VKS-001

Customer: Vina Kyoei Steel Phu My 1 Industrial Zone, Tan Thanh Dist. BRVT Province Tel: (84.64) 3876277 – 3876278 Fax: (84.64) 3876133	Your service order	
	Date of request	
	Date of service	
	Type of machine	Water Cooling Pump
	Product No.	
	Type of service	Maintenance service
	Quantity	01 set

SERVICE DESCRIPTION: **Overhaul of Cooling water pumps and Anticorrosion coating**

No.	Task Description	Result & Notes
1	Check and remove the pump. Dismantle the pump components.	- No highlight.
2	Pump components inspection and checking.	- The pump casing, impeller, stuffing box were found heavy corrosion and lost material at some positions. - The wearing ring of impeller as found worn-out at whole circumference of the ring. The gap of the wearing rings is > 2.5mm. - The impeller was found with many cracks at the root of the blades and shaft bore hole. - The gland packing bore hole was found heavy corroded, depth about 3mm at whole circumference of the part.
3	Repair the Impeller	- Repair the cracks at the impeller blades and shaft bore hole by welding. After welding completed, it was machined to get back its dimension. - Repair the worn-out wearing ring by Nickel and Chrome electroplating technology to fill up the lost material to get correct gap of the rings.
4	Dynamic balancing the impeller after repaired.	- After repaired, the impeller was checked dynamic balancing and found unbalance 65gram at unbalance

SON VU Technical Service Co., Ltd.

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		<p><i>angle 245o. Remove the unbalance material.</i></p> <ul style="list-style-type: none">- <i>The final parameter of balancing was accepted at 1.1gram at angle 232o.</i>
5	<p><i>Repair the stuffing box - gland packing bore hole.</i></p>	<ul style="list-style-type: none">- <i>The corroded bore hole of gland packing was repaired and rebuilt by ARC Coating.</i>- <i>Repaired other parts of stuffing box.</i>- <i>Modified to upgrade the gland packing into mechanical seal Chesterton type S10 size 45mm with successfully..</i>
6	<p><i>Pump casing repairing</i></p>	<ul style="list-style-type: none">- <i>Cleaned and removed all corroded parts of the pump casing.</i>- <i>Coating entire the pump casing by ARC 855 and SD4i.</i>
7	<p><i>Commissioning – leak test.</i></p>	<ul style="list-style-type: none">- <i>The pump was reassembled after repaired and done water pressure test with 8bar to confirm the repaired job completion.</i>
8	<p><i>Install the pump back to system.</i></p>	<ul style="list-style-type: none">- <i>No highlight.</i>

Attached pictures:



Fill up lost material at impeller wearing ring by Electroplating Technology

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The impeller wearing ring after repaired



Repairing of the pump after coating ARC

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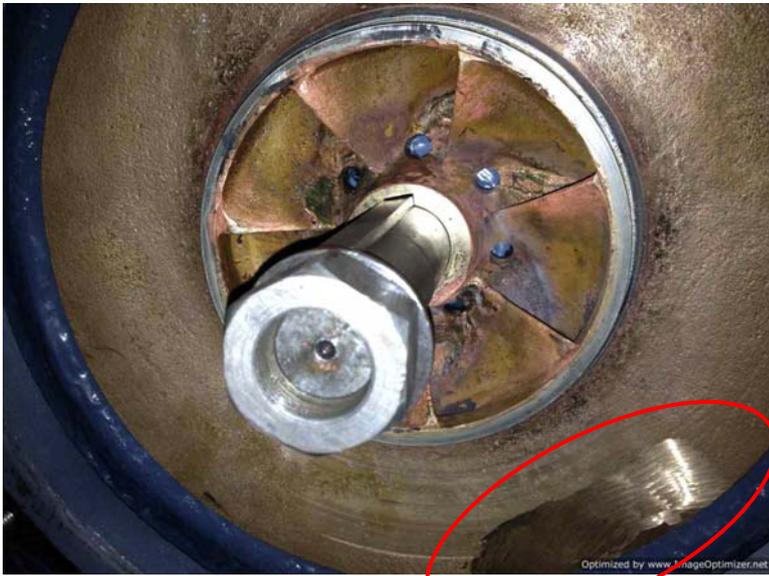
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Mechanical Seal S10-Chesterton

Pump casing repairing



Impeller balancing

Pump casing after Coating ARC

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Pressure test after repaired at 8bar

Recommendation:

No recommendation

Attachments: *Please find the impeller balancing report.*

This Service Completion Note was made by 02 copies; 01 copy for Vina Kyohei Steel and 01 for Son Vu Co.

SON VU TS Co., Ltd

Signed Name: Le Van Phuc

Position: Technical Director Date: 6/3/2013

Vina Kyohei Steel Approve

Signed Name:

Position: Date: