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Servo & Proportional Valve Service Report

MFG	Rexroth	Servo		Prop	X	Job#	1022197
MOD	4WREE10E75-20/G24K31/A1V				EVAL DATE	10/13/2023	
S/N	2				EVAL TECH	PT	
Pilot						16010	
Interupt							
INT EXT					PILOT (X)	INT	EXT
INT EXT					DRAIN (Y)	INT	EXT
OBE	R900775832	Amplifier					

Incoming Observation/Problem: Received partially working, valves flow control is poor/unstable. Upon internal inspection the electronics are fatigued and require moderate repair service. The internals of the electronic housing and the circuit board are contaminated, missing seals on the housing allowed contaminants inside the housing. Electronic parts require a good cleaning to remove all contaminants and oil. Valve requires a full overhaul including a complete tear-down, cleaning, seal kit, moderate OBE electronic repair, rework internal parts, assemble and test/calibration to OEM specs.

Prop	X	Servo	Rebuild	Replace	Visual	Poss. Cause(s)	Comments
Solenoid - A			X		X		Rework core tube assembly
Solenoid - B			X		X		Rework core tube assembly
Poppet/Seat							
Coil(s)					X		Both coils ohm out good
LVDT - Mainstage					X		Working properly-calibrate outbound
LVDT - Pilot							
Main Spool/Body			X		X		Light/normal wear-low leakage
Pilot Spool/Body							
Safety Valve							
Connector(s)					X		No Damage
Wiring Box			X		X		Clean out contaminants, new gaskets
OBE Electronics			X		X		FATIGUED-MODERATE REPAIR

Visual Inspections	05 - Varnish build up	10 - Noisy	15 - Out of specs	Recommendations
01 - Light scoring	06 - Electrical damage	11 - External Leak	6 - Solenoid buzz	Change / Replace / Inspect Filters
02 - Heavy scoring	07 - Can not test	12 - Parts missing	17 - OBE intermittent	
03 - Galling / Build up	08 - Restricted flow	13 - High internal leakage	18 - No response	Perform fluid analysis
04 - Physical damage	09 - Rust / Water present	14 - Runs hot		
Possible Causes	E - Incorrect field wiring	J - Incorrect orifice/plug	O - High Temperature	Insure proper PLC command inputs to valve
A - Small Particle contamination	F - Obsolete / Not repairable	K - Defective part	P - Cavitation	
B - Large particle contamination	G - Parts missing	L - Damaged in shipping	Q - No Problem found	Inspect for faulty wiring / connector
C - Parts worn	H - Name tag missing	M - Damaged in field		Inspect Actuator
D - Assembled wrong	I - Leakage due to o-ring	N - Product tampered with		
NOTES:				Inspect proper flow and pressure settings