

Workshop standard recondition offer Wartsila DF34

RECONDITIONING CYLINDER HEADS:

SCOPE OF WORKS: (ROCKER ARM WORKS EXCLUDED)

- INSPECTION INCOMING STATUS
- DISMANTLING AND CLEANING OF COVER AND VALVES, MEASURING ALL SEATS
- HYDRO PRESSURE TESTING COVER
- INSPECTION/LAPPING OF ALL LANDINGS, START AIR VALVE, LOWER LANDING INJ. SEAT
- CLEANING AND OVERHAUL OF ALL THREADS
- GRINDING INLET AND EXHAUST SEATS TO MANUF. SPECS. - CLEANING AND GRINDING VALVE STEM TO MANUF. SPECS. - V/V GUIDE O-RINGS TO BE REPLACED
- ASSEMBLING OF CYLINDER COVER
- CYLINDER COVER PAINTED AND PRESERVED

LABOR COST FOR ABOVE SCOPE WORK EUR 950.00

ADDITIONAL WORKS IF REQUIRED:

- RENEWAL OF VALVE SEATS **EUR 65.00**
- RENEWAL OF VALVE GUIDES **EUR 65.00**
- MACHINING OF LANDING SURFACE **EUR 280.00**
- MACHINING + RENEWAL OF OVERSIZE VALVE SEAT **EUR 350.00 – to be confirmed after the in workshop examination.**

RECONDITIONING OF START AIR VALVE (if applies):

SCOPE OF WORK:

- CLEANING OF VALVE BODIES AND SUB COMPONENTS
- INSPECTION OF VALVE SPINDLE, BODY SEATS AND PISTON
- CONDITION REPORT WITH ADVISE IF NEW PARTS NEEDED
- RENEWAL OF INTERNAL AND/OR REFURBISH VARIOUS PARTS AS DESIGNATED
- RENEW LAPPED SURFACE TO SPECIFICATION FOR OVERALL LENGTH
- PRESERVE AND PACKAGE

LABOR COST FOR ABOVE SCOPE WORK EUR 120.00

RECONDITIONING OF SAFETY VALVE (if applies):

SCOPE OF WORK:

- CLEANING OF VALVE BODIES AND SUB COMPONENTS
- INSPECTION OF VALVE SPINDLE - AND BODY SEATS
- CONDITION REPORT WITH ADVISE IF NEW PARTS NEEDED
- RENEWAL OF INTERNAL AND/OR REFURBISH VARIOUS PARTS AS DESIGNATED
- RENEW LAPPED SURFACE TO SPECIFICATION FOR OVERALL LENGTH
- TEST FOR PROPER OPENING PRESSURE AND LEAK DOWN
- SETTING OF OPENING PRESSURE ACCORDING TO MANUFACTURER SPECIFICATIONS
- PRESERVE AND PACKAGE

TOTAL LABOR COSTS FOR ABOVE WORKS EUR 195.00

RECONDITIONING ROCKER ARM ASSEMBLY:

SCOPE OF WORK:

- VISUAL INSPECTION OF COMPLETE ASSEMBLY AS INCOMING STATUS - DISASSEMBLING OF ALL COMPONENTS AND INSPECTION
- ADVISE OF NEW PARTS IF NEEDED
- BLOWING THRU. VARIOUS OIL SUPPLY BORINGS
- INSPECTION AND MEASURING ALL BUSHINGS/SHAFTS.
- RE-ASSEMBLING ALL COMPONENTS

LABOR COST FOR ABOVE SCOPE WORK EUR 355.00

RECONDITIONING LINER:

SCOPE OF WORKS:

- CLEANING AND INSPECTION OF LINER
- MEASURING LINER PRIOR HONING
- CRACK TEST PERFORMANCE AT THE LOWER LINER COLLAR AND O-RING AREAS
- HONING OF LINER TO MANUF. SPECS.
- MEASURING LINER AFTER HONING
- PERFORMING OF ROUGHNESS TEST
- MINIMUM MACHINING/SKIM CUT (TO CLEAN UP) UPPER/LOWER COLLAR LANDINGS
- TAKEN MEASUREMENTS AND FINDINGS RECORDED IN REPORT
- CLEAN, PRESERVE AND PREPARE THE LINER FOR TRANSPORT

LABOR COST FOR ABOVE SCOPE WORK EUR 450.00

RECONDITIONING PISTON:

SCOPE OF WORK:

- DISMANTLING AND CLEANING ALL PARTS, INTERNAL COOLING SPACE - PERFORMANCE OF CRACK DETECTION
- MEASUREMENTS OF ALL RING GROOVES
- PRESERVING, READY TO INSTALL

LABOR COST FOR ABOVE SCOPE WORK EUR 290.00

RECONDITIONING OF CONNECTING ROD:

SCOPE OF WORK:

- CLEANING, MEASURING AND INSPECTION OF BIG AND SMALL BORE
- PERFORMANCE OF CRACK DETECTION TESTING OPERATIONS AND PREPARATION

LABOR COST FOR ABOVE SCOPE WORK EUR 330.00

ADDITIONAL WORKS IF REQUIRED:

REPLACE OF SMALL END BUSH **EUR 380.00**

RECONDITIONING FUEL INJECTION PUMPS:

SCOPE OF WORK:

- DISMANTLING OF ALL COMPONENTS
- CLEANING BY MEANS OF CHEMICAL BATHING
- INSPECTION AND REFURBISHMENT OF ALL PARTS DEEMED GOOD FOR AN ADDITIONAL SERVICE LIFE
- PARTS LIST FOR NEW/RECONDITIONED PARTS
- OVERHAUL OF REUSABLE PARTS
- RE-ASSEMBLY OF ALL COMPONENTS TO SPECIFICATIONS
- PRESERVE AND PACKAGE

LABOR COST FOR ABOVE SCOPE WORK EUR 375.00