



Anytime. Anywhere. (sm)

D.L. Ricci Corp. Case Study #340

"Flexible Work Scope"

Set-Up: - It is often the case that the level of machining required can not be truly determined until the work area is fully exposed. This happens fairly often and requires our technicians to be flexible and creative to complete the job. One recent example was with an upper Midwest fossil plant that needed the barrel of a boiler feed pump machined. The original plan was for 3 surfaces to be faced, but it ended up to be 6.

Plan: - Ricci Field Coordinators determined that our 4" Portable Bore Bar could do the job. Also, an Axial Feed attachment would be required for the tight machining tolerances. 4 D.L. Ricci technicians would be sent to offer day and night machining. The original plan involved the 4 technicians for 2 full days of machining in order to bring the pump back to original specs (tolerances required were .002").

Operation: - The barrel diameter was 24" ID at a length of 50 13/16". Once the pump barrel was fully exposed, the scope of the work could be accurately determined. The Plant Engineer said, "We encountered more wear than we expected to find. The faces weren't really true to the center line of rotation and quite a bit of material was needed to be removed." The pump manufacturer's rep. was also on hand to guide the process. It took 3 set-ups to get it just right. The 3 original surfaces turned into six which then almost doubled the time on-site for the Ricci Techs.

Results: - Between the weld build up surface and the other minimal clearance areas, the D.L. Ricci Technicians completed their facing work to the satisfaction of the customer. "We achieved the required tolerances and have now started the pumps back up. Between the machining and everything else, we're quite happy with the results."

