| DIE BUY OFF CHECK LIST DANBRO Tool & Die | | | | | | | | | |
|---|--|--|--------------------------------------|----------|----------|------------|------------------|--|--|
| PART | NUMBER: | | SPM: | | | | | | |
| | NAME: | | | TONNAGE: | | | | | |
| PART NAME: DIE PROCESS: PITCH: WIDTH: | | | | | | THICKNESS: | | | |
| | <u>.</u> | <u></u> | | | | | | | |
| 1 | DYNAMIC | | П | YES | NO | | NOTES | | |
| | 1 HAS THE DIE PILOTS AND / OR LOCATORS IN EACH ST. | ATION ? | 11 | | | | | | |
| | 2 HAS THE DIE FRENCH STOP (OR SIMILAR), SENSOR FIR | NGERS AND FINAL SENSORS? | 11 | | | | | | |
| | 3 ARE THE TRIM AND PIERCE HOLES FREE OF SCRAP AG | CCUMULATION? | | | | | | | |
| | 4 DOES THE DIE HAVE ENOUGH PLUNGERS AND EJECT | ORS TO AVOID PART BE PULLED UP BY STRIPPER PAD? | | | | | | | |
| - | 5 IS THE DIE SPEED (SPM) THE APPROPIATE ? IS THE PR | RESS SPM APROPIATE? WRITE IT | 1 | | | | | | |
| | 6 IS THE PROCESS STABLE ? | | 4 | | _ | | | | |
| | 7 IS THE SESNORS SYSTEM WORKING PROPERLY? | THOUT INTEREST A | 4 6 | | _ | | | | |
| | 8 ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WI' 9 IS THE PART DISCHARGED CORRECTLY TO THE CONV | | 4 | | | | | | |
| l | 10 IS THE DIE IN THE APPROPIATE PRESS ACCORDING TH | | 1 | | | | | | |
| l | 11 DOES THE PART REQUIRES LUBRICATION ? | | 11 | | | | | | |
| | 12 ARE EACH PUNCH AND BUTTON DIE ALIGNED CORREC | CTLY? CHECK ALL HOLES AND TRIMS IN THE PART. | 11 | | | | | | |
| | | | 11 | | | | | | |
| 2 | QUALITY | | | YES | NO | C | COMMENTS / NOTES | | |
| | 1 PART QUALITY APPEARANCE IS ACCEPTABLE RESPEC | CT TO: |] [| | | | | | |
| | A) FREE OF WRINKLES | | | | | | | | |
| | B) FREE OF BURRS | | | | | | | | |
| | C) PART EDGES WITHOUT DAMAGE | | | | | | | | |
| | D) FREE OF SPLITS | |] | | | | | | |
| | E) FREE OF DRAGGING | | 11 | | | | | | |
| | F) FREE OF MARKS OR HITS | | 4 | | | | | | |
| | 2 IS THE PART QUALITY DIMENSIONAL, ACCEPTABLE AC | | 4 | | | | | | |
| | 3 THE PART COMPLIANCE WITH A 1.66 CP AND 1.33 CPK | , ACCORDING TO CMM MEASURES ? | 4 | | | | | | |
| - | 4 IS THE PART AT THE LATEST ENGINEERING LEVEL ? | | 4 | | _ | | | | |
| - | 5 IS THE MATERIAL SPECIFICATION ACCORDING TO THE | | 1 | | | | | | |
| | LIQUIDS OR SECTION CUTS FOR BETTER INSPECTION | RMINGS WITH RISK OF THINING, SPLITS OR CRACKS USING | | | | | | | |
| | | | 11 | | | | | | |
| 3 | STATIC | | L | | | | | | |
| 3 | UPPER DIE. | | Ш | YES | NO | C | COMMENTS/NOTES | | |
| | 1 HAS THE DIE LIFTING HOOKS (THREAD HOLES FOR EY | E BOLTS IF IS NESCESARY)? |] | | | | | | |
| | 2 IS THERE AN INTERFERENCE WHEN OPENING THE DI | E | 4 | | | | | | |
| - | 3 IS THERE A DAMAGED COMPONENT ON THE DIE | -D. AND LEVELEDO | 4 | | _ | | | | |
| | 4 ARE STRIPPERS ARE PROPERLY ATTACHED, BALANCE 5 WHEN STRIPPERS ARE BEING DISASSEMBLIED, IS THE | · | - | | - | | | | |
| | 6 ARE THE STRIPPER PADS GUIDED WITH AMPCO GUIDE | | ┪┠ | | \vdash | | | | |
| | 7 WEAR PLATES: STEEL OVER BRONZE WITH GRAPHITE | | 1 | | | | | | |
| | 8 ARE THE NYTRO CONTROL PANEL PLACED IN A SAFET | |] [| | | | | | |
| | WITH STANDARD CONEXIÓN, AND ALL NYTRO CILINDE | RS COMPONENTS ARE DADCO BRAND ? | | | | | | | |
| | | DOES EXIST A PLATE WITH NYTRO FILL INFORMATION EACH DIE STATION (CAN BE ENGRAVED ON DIE SHOE)? | | | | | | | |
| - | 10 ARE NYTRO CYLINDERS PROPERLY ATTACHED WITH : | 4 | | | | | | | |
| - | 11 ARE THE NYTRO CYLINDER FULL, AND WITHOUT LEAK | 4 | | _ | | | | | |
| - | ARE NYTRO CYLINDERS USING 90% OF STROKE? 3 DOES EXIST ANY DIE COMPONENTS IN BAD CONDITIONS (PUNCHES, DIES BLADES,FORMING INSERTS, ETC.) | | | | | | | | |
| • | 14 HAS IT PUNCHS BALL LOCK TYPE, AND ARE THEY WEL | 1 | | | | | | | |
| | 15 ARE ALL THE FORM, DRAW AND BENT SECTIONS WEL | | 11 | | | | | | |
| | 16 DOES EXIST A GAP BETWEEN THE INSERTS JOINS ? | | ֓֞֞֞֞֞֩֓֞֩֞֩֓֓֓֓֓֓֡֩֞֩֓֓֡֓֓֓֡֓֡֡֡֡֡֡ | | | | | | |
| | 17 ARE THE CAMS MADE WITH POSITIVE RETURN ARM ? | |] [| | | | | | |
| | 18 DO WE HAVE CORRECT SCREW SIZE AND PROPERLY | | ↓ | | | | | | |
| | 19 HAS THE STRIPPER SPRING PLUNGERS TO PREVENT | | ┨╏ | | \vdash | | | | |
| | 20 IS THERE ANY FRICTION BETWEEN THE STRIPPER ANI 21 ARE THE PUNCH HOLDERS IN WELL CONDITIONS AND | | 1 | | \vdash | | | | |
| | 22 HAVE THE PUNCHS SHEAR ANGLE AND EJECTORS? | | 1 | | \vdash | | | | |
| | 23 ARE ALL THE DIE COMPONENTS FREE OF WEAR? | | 11 | | | | | | |
| | 24 IN DRAW, OR FORMING STATIONS, ARE THERE ACCES | S FOR THE LUBE PIPING? Ø8.0MM HOLE SIZE. | ֓֞֞֓֞֞֓֓֞֩֓֓֞֜֞֩֓֓֓֓֡֓֓֡֓֡֓֓֡֓֡֓֡֡֡ | | | | | | |
| | | | | | | | - | | |

| 4 | LOWER DIE. | 7 | MEG | wo | COMMENTS/NOTES |
|---|--|----------|-----|-----------|------------------------------------|
| - | 1. DOES EXIST COMPONENTS WITH DAMAGE ? | 4 | YES | NO | COMMENTO/HOLES |
| | | - | | | |
| | 2 DOES EXIST SCRAP ACCUMULATION ON DIES OR BLADES (MAX. 5 SCRAPS) ? | - | | | |
| | 3 ARE ALL THE SCRAP EXITS WITHOUT OBSTRUCTIONS? | - | | | |
| | 4 ARE ALL THE DIE COMPONENTS PROPERLY THIGHTEN (FORMING INSERTS, DIES, ETC) ? | 4 ŀ | | \vdash | |
| | 5 ARE FORMING AND DRAWING COMPONENTS PROPERLY POLISHED? | 4 | | | |
| | 6 DOES EXIST STARTING AND FINAL SENSORS (IN PROGRESSIVE DIES) OR IN EACH DIE STATIONS | 4 | | | |
| | (IN TRANSFER DIES), AND THE SENSORS WIRE IS PROTECTED AND READY TO WORK IN PRESS ? | 4 | | | |
| | 7 DOES EXIST ADJUSTABLE AND FIXED FEEDING MATERIAL GUIDES? | 4 | | | |
| | (BLANK/PART LOCATORS IN TRANSFER DIES) | 41 | | | |
| | 8 ARE LIFTERS PROPERLY THIGHTEN, WITH 3 RETAINERS TO AVOID ROTATION, GAS SPRINGS WITHOUT LEAKS. | 4 | | | |
| | 9 DOES EXIST A START LINE IN RED? | 4 | | | |
| | 10 DOES EXIST A JULIAN DATE HOLDER PER PART IN EACH DIE (QUICK CHANGE FOR PROG. DIES). | 41 | | | |
| | 11. HAS THE DIE 4 STORAGE BLOCKS (NYTRO) ? | 4 | | | |
| _ | 12. HAS THE DIE FAST CENTERING HOLES TO CENTER IT IN THE PRESS BOLSTER ? | Щ | | | |
| 5 | GENERAL DIE REVIEW | _ | YES | NO | COMMENTS/NOTES |
| | 1 IS THE DIE PROPERLY IDENTIFIED: PART NUMBER, PROCESS FLOW, DIE WEIGHT, | | | | |
| | FRONT, ID PLATE WITH BASIC INFORMATION OF PART & DIE, ETC. | 41 | | Ш | |
| 1 | 2 IS THE DIE PAINTED PROPERLY ? | _ | | Ш | |
| | 3 ARE LIMIT BLOCKS PAINTED ON RED? | 41 | | Ш | |
| | 4 DO DIE COMPONENTS HAVE THE RIGHT HARDNESS (DIES, PUNCHS, FORMS). | 41 | | Ш | |
| 1 | 5 DO ALL DOWEL PINS HAVE THREAD HOLE FOR EASY REMOVAL? | 41 | | Ш | |
| 1 | 6 ARE THERE BOTTOMING MARKS (FOR DIE SH ADJUST) IN THE FORM AND RESTRIKE OPERATIONS? | 41 | | \square | |
| | 7 HAS THE DIE A POST AND BUSHING DISALIGNED TO AVOID AN INCORRECT CLOSURE? | 41 | | Ш | |
| 1 | 8 ARE THERE PROPER RAMPS FOR THE SCRAP EXITS ? | 41 | | Ш | |
| 1 | 9 HAS THE DIE THE CORRECT SHUT HEIGHT ACCORDING TO THE ASSIGNED PRESS ? | 41 | | Ш | |
| | 10 HAS THE CLAMP SLOTS THE CORRECT HEIGHT, WIDE AND DISTANCE BETWEEN CENTERS? | _ | | | |
| | 11 ARE ALL DIE COMPONENTS FREE OF WELDING OR SHIMS ? | _ | | | |
| | 12 ARE ALL DIE COMPONENTS CORRECTLY IDENTIFIES IN THE BACK SIDE ? | _ | | | |
| | 13 ARE ALL DIE COMPONENTS, IN THE METRIC SYSTEM? | Ш | | | |
| | STATIC HOME LINE REVIE | W | | | |
| 6 | DIE RECEIVING | | YES | NO | COMMENTS/NOTES |
| | 1 PACKING CONDITION, VISIBLE DAMAGES, COMPONENTS ARE GREASED? | 71 | | | |
| | 2 ARE PIERCE PUNCHES AND FORM PUNCH IN GOOD CONDITIONS? (FREE OF DRAGGING, WEARING, ETC) | 7 [| | | |
| | 4 HAS THE DIE JULIAN DATE HOLDER? IF YES, PUT THE JULIAN DATE IN. | 71 | | | |
| | 5 ARE SCREWS AND DOWEL PIN PROPERLY THIGTEN? | 71 | | | |
| | 6 HAS THE CONTROL PANEL THE CORRECT NITROGEN CHARGE? IF NOT CHARGE IT. | 7 1 | | | |
| | 7 ARE THERE SPARE PARTS WITH THE DIE? (DELIVER TO THE WORKSHOP LEADER). | 71 | | | |
| | 8 DO THE DIE COMES WITH SAMPLE PARTS.? IDENTIFY THEM AND SEND THEM TO QUARANTINE | 71 | | | |
| | 9 IF THE CHECKING FIXTURE IS INCLUDED WITH THE DIE - IS FREE OF VISIBLE DAMAGES ?- | 71 | | | |
| | GIVE NOTICE TO THE QUALITY ENGINEER FOR DISPOSAL. | 71 | | | |
| | 10 IS THE DIE PROPERLY IDENTIFIDED?(CUSTOMER NUM. ,PROCESS FLOW, ID PLATE, FRONT) | -11 | | | |
| 1 | (| - 1 1 | | \vdash | |
| | 11. IS "PROPERTY OF XXX" TAG INSTALLED PROPERLY | + | | | |
| | |)FF | ' | | |
| 7 | DYNAMIC HOME LINE BUY O | _ | | NO | COMMENTS / NOTES |
| 7 | | _ | YES | NO | COMMENTS/NOTES |
| 7 | DYNAMIC HOME LINE BUY O | _ | | NO | COMMENTS/NOTES |
| 7 | DYNAMIC HOME LINE BUY O DIE MOUNTING 1 DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? | _ | | NO | COMMENTS/NOTES |
| 7 | DYNAMIC HOME LINE BUY O DIE MOUNTING 1 DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2 DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? | _ | | NO | COMMENTS / NOTES |
| 7 | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? | _ | | NO | COMMENTS/NOTES |
| 7 | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? | _ | | NO | COMMENTS/NOTES |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS | | | NO | COMMENTS / NOTES COMMENTS / NOTES |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGTH (OR PASS LINE IN TRANSFER)? | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGTH (OR PASS LINE IN TRANSFER)? DIE PRODUCTIVITY | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGTH (OR PASS LINE IN TRANSFER)? DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGTH (OR PASS LINE IN TRANSFER)? DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? 2. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGTH (OR PASS LINE IN TRANSFER)? DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? 2. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 3. HAS THE DIE SCRAP ACCUMULATIONS ON THE CUTTING ZONES? | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGHT (OR PASS LINE IN TRANSFER)? DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? 2. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 3. HAS THE DIE SCRAP ACCUMULATIONS ON THE CUTTING ZONES? 4. HAS THE DIE, SCRAP ACCUMULATIONS ON THE PRESS BOLSTER? | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGTH (OR PASS LINE IN TRANSFER)? DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? 2. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 3. HAS THE DIE SCRAP ACCUMULATIONS ON THE CUTTING ZONES? 4. HAS THE DIE, SCRAP ACCUMULATIONS ON THE PRESS BOLSTER? 5. IS THE DIE SPEED (SPM) THE APPROPIATE? IS THE PRESS SPM APROPIATE? WRITE IT | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? 2. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 3. HAS THE DIE SCRAP ACCUMULATIONS ON THE CUTTING ZONES? 4. HAS THE DIE, SCRAP ACCUMULATIONS ON THE PRESS BOLSTER? 5. IS THE DIE SPEED (SPM) THE APPROPIATE? IS THE PRESS SPM APROPIATE? WRITE IT 6. IS THE PROCESS STABLE? | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 7. DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? 2. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 3. HAS THE DIE SCRAP ACCUMULATIONS ON THE CUTTING ZONES? 4. HAS THE DIE, SCRAP ACCUMULATIONS ON THE PRESS BOLSTER? 5. IS THE DIE SPEED (SPM) THE APPROPIATE? IS THE PRESS SPM APROPIATE? WRITE IT 6. IS THE PROCESS STABLE? 7. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGTH (OR PASS LINE IN TRANSFER)? DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? 2. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 3. HAS THE DIE SCRAP ACCUMULATIONS ON THE CUTTING ZONES? 4. HAS THE DIE, SCRAP ACCUMULATIONS ON THE PRESS BOLSTER? 5. IS THE DIE SPEED (SPM) THE APPROPIATE? IS THE PRESS SPM APROPIATE? WRITE IT 6. IS THE PROCESS STABLE? 7. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 8. IS THE PART DISCHARGED CORRECTLY TO THE CONVEYOR? | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGTH (OR PASS LINE IN TRANSFER)? DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? 2. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 3. HAS THE DIE SCRAP ACCUMULATIONS ON THE CUTTING ZONES? 4. HAS THE DIE, SCRAP ACCUMULATIONS ON THE PRESS BOLSTER? 5. IS THE DIE SPEED (SPM) THE APPROPIATE? IS THE PRESS SPM APROPIATE? WRITE IT 6. IS THE PROCESS STABLE? 7. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 8. IS THE PART DISCHARGED CORRECTLY TO THE CONVEYOR? 9. IS THE DIE IN THE APPROPIATE PRESS ACCORDING THE TONNAGE REQUIRED BY THE PART? | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGTH (OR PASS LINE IN TRANSFER)? DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? 2. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 3. HAS THE DIE SCRAP ACCUMULATIONS ON THE CUTTING ZONES? 4. HAS THE DIE, SCRAP ACCUMULATIONS ON THE PRESS BOLSTER? 5. IS THE DIE SPEED (SPM) THE APPROPIATE? IS THE PRESS SPM APROPIATE? WRITE IT 6. IS THE PROCESS STABLE? 7. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 8. IS THE PART DISCHARGED CORRECTLY TO THE CONVEYOR? 9. IS THE DIE IN THE APPROPIATE PRESS ACCORDING THE TONNAGE REQUIRED BY THE PART? 10. DOES THE PROCESST REQUIRE LUBRICATION? | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGTH (OR PASS LINE IN TRANSFER)? DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? 2. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 3. HAS THE DIE SCRAP ACCUMULATIONS ON THE CUTTING ZONES? 4. HAS THE DIE, SCRAP ACCUMULATIONS ON THE PRESS BOLSTER? 5. IS THE DIE SPEED (SPM) THE APPROPIATE? IS THE PRESS SPM APROPIATE? WRITE IT 6. IS THE POCESS STABLE? 7. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 8. IS THE PART DISCHARGED CORRECTLY TO THE CONVEYOR? 9. IS THE DIE IN THE APPROPIATE PRESS ACCORDING THE TONNAGE REQUIRED BY THE PART? 10. DOES THE PROCESST REQUIRE LUBRICATION? A) CONTINUOS | | YES | | |
| | DYNAMIC HOME LINE BUY O DIE MOUNTING 1. DO DIE CENTERING HOLES MATCH WITH THE BOLSTER HOLES? 2. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS BOLSTER? 3. DO THE LOWER CLAMPING SLOTS MATCH WITH THE PRESS RAM? 4. DO THE SCRAP CHUTES MATCH WITH THE BOLSTER WINDOWS? 5. IS THE SHUT HEIGHT CORRECT ACCORDING THE PRESS 6. IS THE CORRECT FEEDING HEIGTH (OR PASS LINE IN TRANSFER)? DIE PRODUCTIVITY 1. HAS THE DIE PILOTS AND LOCATORS IN EACH STATION? 2. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 3. HAS THE DIE SCRAP ACCUMULATIONS ON THE CUTTING ZONES? 4. HAS THE DIE, SCRAP ACCUMULATIONS ON THE PRESS BOLSTER? 5. IS THE DIE SPEED (SPM) THE APPROPIATE? IS THE PRESS SPM APROPIATE? WRITE IT 6. IS THE PROCESS STABLE? 7. ARE ALL THE DIE COMPONENTS FUNCTIONAL AND WITHOUT INTERFERENCES? 8. IS THE PRET DISCHARGED CORRECTLY TO THE CONVEYOR? 9. IS THE DIE IN THE APPROPIATE PRESS ACCORDING THE TONNAGE REQUIRED BY THE PART? 10. DOES THE PROCESST REQUIRE LUBRICATION? A) CONTINUOS B) WITH ESTABILISHED FREQUENCY (EVERY 3 OR 5 PARTS) | | YES | | |

| 9 | QUALITY PRODUCT | Ш | YES | NO | COMMENTS / NOTES |
|----|--|----|-----|----|------------------|
| | 1 PART QUALITY APPEARANCE IS ACCEPTABLE RESPECT TO: | | | | |
| | A) FREE OF WRINKLES | 11 | | | |
| | B) FREE OF BURRS |][| | | |
| | C) PART EDGES WITHOUT DAMAGE | 11 | | | |
| | D) FREE OF SPLITS | | | | |
| | E) FREE OF DRAGGING | 11 | | | |
| | F) FREE OF MARKS OR HITS | 11 | | | |
| | 2 IS THE PART QUALITY DIMENSIONAL, ACCEPTABLE ACCORDING TO THE CHECKING FIXTURE ? | 11 | | | |
| | 3 IS THE JULIAN DATE COMPLETE(ALL NUMBERS) AND IN THE CORRECT POSITION? | 11 | | | |
| | 4 THE PART COMPLIANCE WITH A 1.66 CP AND 1.33 CPK, ACCORDING TO CMM MEASURES ? | 11 | | | |
| | 5 IS THE PART AT THE LATEST ENGINEERING LEVEL ? | 11 | | | |
| 1 | 6 IS THE MATERIAL SPECIFICATIONS ACCORDING TO THE APL ? | | | | |
| | 7 VERIFY(CHECK WITH MICROMETER) DRAWS &/OR FORMINGS WITH RISK OF THINING, SPLITS OR CRACKS USING LIQUIDS OR SECTION CUTS FOR BETTER INSPECTION. | | | | |
| 10 | CONDITIONS/ TRY OUT IMPORTANT PARAMETERS/ MOUNTING | | | | |
| | 1 DIE SHUTHEIGHT: | | | | - |
| | 2 RECOMMENDED STROKES PER MINUTE: | | | | |
| | 3 TONNAGE REQUIRED BY THE DIE DURING THE BUY OFF: PER COLUMN FR: FL: RR: | | RL: | | TOTAL: |
| | 4 REQUIRED BLANK SIZE (THICKNESS/WIDTH/PROGRESSION): | | | | |
| | 5 PITCH DISTANCE, AND LIFTERS HEIGHT FROM THE DIE BASE ON TRANSFER DIES: | | | | |
| | 6 GAS SPRING CHARGE ON EACH PLATE BY STATION(INDICATE POSITION): | | | | |
| | | | | | |
| | 7 STRAIGHTENER'S ROLL PRESSURE: | | | | |
| | 8 OPENING DEGREES ON FEEDER'S ROLLS: | | | | |
| | 9 DEGREES ON SCREEN FOR SIGNAL ACTIVATION FOR EACH SENSOR: | | | | |
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