

Set-up Procedures Check List

Press _____

BMC Tool No. _____

check when done

1. Retrieve and REVIEW (ESPECIALLY THE 1ST PAGE) the set-up manual.
2. Recall Job verify settings.
3. Wipe down the bolster & ram.
4. Wipe down & remove burrs on the top & bottom of the die and/or parallels.
5. Scale the height of the die.
6. Scale the shut height with the ram at 180° and set the shut height at least 1/8" over the scaled dimension of the die.
7. Set the die on the bolster, square it up & physically center it (unless noted differently in the set-up book).
8. Inch the ram around to assure proper scaled dimensions (make sure on the 300 you do not stop the press between 170° and 190° due to the possibility of sticking the ram on bottom). Bring the shut height down until you are sure you are resting completely on top of the die.
9. Clamp the die in, double check to make sure the clamps are tight and not interfering with anything (stop blocks, bushings, etc.)
10. Complete the shut height setting by bringing the shut height down (when the ram is at top), to the appropriate lead reading
11. Set feed height & stock guides.
12. Check Hyson pressure, when applicable.
13. Feed strip to start mark or notch.
14. Check the program for pilot release settings & set them as appropriate.
15. Feed strip through the die to full progression. Set block readings according to set-up manual.
16. Check to insure that the pilot release settings are right.
17. Check die protection channels.
18. Set other safety devices.
19. Set oilers.
20. Check position of window oiler - oiler must spray width of strip.
21. Progressively run for the first part check.
22. Install conveyors.
23. Position scrap tanks.
24. Receive stamped job sheet with labels and sample part.
25. Run the die progressively for approximately 5 minutes or 1,000 strokes to assure a proper set-up.
26. Tonnage monitor is on and set; Record tonnage on Form FM93.
27. Record final shut height, lead reading and material thickness on Form FM93.
28. Inspect die protection & safety devices.
29. Check with shipping personnel for any partial containers from previous run.

Set-up person's Signature & Date

Qualified personnel verbally confirming with set-up person that all safeties have been checked Signature & Date