

**DOC355 - DRAW DIE BUYOFF - PAGE 1 OF 2**

**Date:** \_\_\_\_\_

**AZ job number:** \_\_\_\_\_

**Customer part number:** \_\_\_\_\_ **Rev Lvl:** \_\_\_\_\_

**Operation number:** \_\_\_\_\_

- |  |     |    |     |
|--|-----|----|-----|
| 1. Are die shoes free of any embedded marks from stop blocks?  | Yes | No | N/A |
| 2. Have you verified that the dies are home on stop blocks prior to sample run?                                      | Yes | No | N/A |
| 3. Is there proper slug clearance through die shoe?  | Yes | No | N/A |
| 4. Are parts stamped right and left hand part?   | Yes | No | N/A |
| 5. Is the finish on the working surface acceptable?  | Yes | No | N/A |
| 6. If not, indicate on sketch and attached to this form.   | Yes | No | N/A |
| 7. Are pressure pads or wear plate's shimmed using only one shim at least 5 mm?                                      | Yes | No | N/A |
| 8. Did you save one panel from this operation and mark last hit, today's date, AZ part #?                            | Yes | No | N/A |
| 9. Have all welded areas been blended in and are there any cracks?   | Yes | No | N/A |
| 10. Are there hard marks on the draw die?  | Yes | No | N/A |
| 11. Is the binder ring and beading evenly spotted?   | Yes | No | N/A |
| 12. Can the binder ring only fit on one way?   | Yes | No | N/A |
| 13. Can draw die run dry?  | Yes | No | N/A |
| 14. Is draw panel free of wrinkles?  | Yes | No | N/A |
| 15. Have slip fit insertable lock beads into the lower?  | Yes | No | N/A |
| 16. Can the steels be easily removed in the press?   | Yes | No | N/A |
| 17. Are all thrust details keyed or heeled?  | Yes | No | N/A |
| 18. Can the binder be dropped in the press and bolster moved out?  | Yes | No | N/A |
| 19. Are binder lock pins in front and back, are they tapped?   | Yes | No | N/A |
| 20. Are there bottom markers in die?   | Yes | No | N/A |
| 21. Are sensor swing gages adjusted properly and is box wired properly – can gage be adjusted without disassembling? | Yes | No | N/A |
| 22. Is part stable after forming when press opens?   | Yes | No | N/A |
| 23. Are lifters operational and tied together?   | Yes | No | N/A |
| 24. Are cylinders plumbed to charge back and is there a nitro alarm?   | Yes | No | N/A |
| 25. Wear Plates – One side must be brass with graphite inserts. The other side must be steel.                        | Yes | No | N/A |

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26. The dies must have storage block capability.	Yes	No	N/A
27. All safety block areas must be marked.	Yes	No	N/A
28. Upper, lower and total weights and flow arrows must be stenciled on dies.	Yes	No	N/A
29. Six digit AZ Automotive job number and customer part number must be stenciled on dies.	Yes	No	N/A
30. Dies must be painted the correct color – ask the AZ Automotive Engineer for direction.	Yes	No	N/A
31. The difference in depth between the actual draw panel and the draw die should be no greater than 0.1mm. Draw panel must be fully drawn at the bottom of the stroke.	Yes	No	N/A

**If “P” and “D” are defined as:**

P = The depth of actual draw panel

D = The depth of actual draw die

- Then the relationship between “P” and “D” must be:

$D - P = 0.1\text{mm or } < 0.1\text{mm.}$

32. This can be confirmed by measuring any step, emboss or depression by using a dial gauge. Visual check with bottoming is not good enough for a buy-off. If the panel depth is more than 0.1, the causes must be investigated and corrected.	Yes	No	N/A
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33. All pressure pads must have 80% total contact area with a panel. AZ Automotive requires a blued panel to show contact area. This is for each pressure pad to function properly with evenly distributed pressure.	Yes	No	N/A
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**Approval (signatures)**

**Tool Shop:** \_\_\_\_\_  
\_\_\_\_\_

**AZ Automotive:** \_\_\_\_\_  
\_\_\_\_\_