

**DOC356 - PIERCE, TRIM, FLANGE, and RESTRIKE 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 offal ejection adequate?  | Yes | No | N/A |
| 6. Is the finish on the working surface acceptable?                                       | Yes | No | N/A |
| 7. If not, indicate on sketch and attached to this form.                                  | Yes | No | N/A |
| 8. Are pressure pads or wear plate's shimmed using only one shim at least 5 mm?           | Yes | No | N/A |
| 9. Did you save one panel from this operation and mark last hit, today's date, AZ part #? | Yes | No | N/A |
| 10. Have all welded areas been blended in and are there any cracks?                       | Yes | No | N/A |
| 11. Are there hard marks on the restrrike dies?   | Yes | No | N/A |
| 12. Does scrap fall controlled, shed angle 30 degree minimum?                             | Yes | No | N/A |
| 13. Is it avoided that neighboring dies shed scrap in same opening?                       | Yes | No | N/A |
| 14. Do slugs and scrap fall freely without catching anywhere?                             | Yes | No | N/A |
| 15. Do all slugs fall into scrap chutes and not inside of cams of die?                    | Yes | No | N/A |
| 16. Are there local strippers provided where possible?                                    | Yes | No | N/A |
| 17. Can the steels be easily removed in the press?  | Yes | No | N/A |
| 18. Are the die buttons keyed into the steels?  | Yes | No | N/A |
| 19. Is the clearance on the trim and pierce holes correct?                                | Yes | No | N/A |
| 20. Can cams be disassembled and replaced in the press?                                   | Yes | No | N/A |
| 21. Do cams return smoothly?  | Yes | No | N/A |
| 22. Is there positive return on the cams?   | Yes | No | N/A |
| 23. Are the cams clear of loading and unloading the panel?                                | Yes | No | N/A |
| 24. Are the strippers spotted in evenly?  | Yes | No | N/A |
| 25. Can the stripper be locked up?  | Yes | No | N/A |

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- |   |     |    |     |
|---|-----|----|-----|
| 26. Can the stripper be dropped in the press and bolster moved out?   | Yes | No | N/A |
| 27. Are stripper lock pins in front and back, are they tapped?  | Yes | No | N/A |
| 28. Are the clearance between the punches, trim edges, and striper minimal correct?   | Yes | No | N/A |
| 29. The dies must have storage block capability.  | Yes | No | N/A |
| 30. All safety block areas must be marked.  | Yes | No | N/A |
| 31. Upper, lower and total weights must be stenciled on dies.   | Yes | No | N/A |
| 32. Six digit AZ Automotive job number and customer part number must be stenciled on die.   | Yes | No | N/A |
| 33. Dies must be painted the correct color – ask the AZ Automotive Engineer for direction.  | Yes | No | N/A |
| 34. Wear Plates – One side must be brass with graphite inserts. The other side must be steel.   | Yes | No | N/A |
| 35. Gas springs must be used. For draw dies, they must be plumbed together to a console. All other dies can be drop-ins. Die springs can only be used with written approval from AZ Automotive. | Yes | No | N/A |
| 36. All dies must have low pressure alarms on manifolds and gas springs.  | Yes | No | N/A |
| 37. All trim dies must have pins and bushings with boxed heels.   | Yes | No | N/A |
| 38. All dies must have hinged chutes.   | Yes | No | N/A |

**Approval (signatures)**

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

\_\_\_\_\_

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

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