

DOC357 - PROGRESSIVE DIE BUYOFF CHECK LIST – PAGE 1 OF 2**Date:** _____**AZ job number:** _____**Customer part number:** _____ **Rev Lvl:** _____**Operation number:** _____**On floor inspection**

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|--|-----|----|-----|
| 1. Was tooling built and delivered as scheduled? | Yes | No | N/A |
| 2. Are initial thirty (30) pieces with layout samples approved? | Yes | No | N/A |
| 3. Blank size reduction, can we reduce coil width? | Yes | No | N/A |
| 4. Does die have a start line? | Yes | No | N/A |
| 5. Are there lead slots .050 deep in top of stop blocks? | Yes | No | N/A |
| 6. Is die shoe free of any imbedded marks from stop blocks? | Yes | No | N/A |
| 7. Is key slot milled through end parallels at center & doweled? | Yes | No | N/A |
| 8. Are there any spools in strippers or pads? | Yes | No | N/A |
| 9. Are the die sections, punches, buttons stamped or etched with AZ tool number? | Yes | No | N/A |
| 10. Are there appropriate guards on all moving pads, strippers, springs, etc.? | Yes | No | N/A |
| 11. Are all components de-burred and all unnecessary sharp edges removed? | Yes | No | N/A |
| 12. Have you checked for no preload on gas springs, but no more than 1/8 slop? | Yes | No | N/A |
| 13. Are nitro pressure requirements stamped on die? Also Checked fillers in front & correct? | Yes | No | N/A |
| 14. Is probe mounted at end of die to detect mis-feeds? | Yes | No | N/A |
| 15. Is die stamped with tonnage, material, size, progression, weight & AZ part number? | Yes | No | N/A |
| 16. Is die painted, labeled yellow upper & total weight with AZ tool number on four sides? | Yes | No | N/A |
| 17. Is there a tag with ownership stamped on it? | Yes | No | N/A |
| 18. Are clamp feet dimensions correct? | Yes | No | N/A |
| 19. Are there spaces for Hi-Low forks to pick die up? | Yes | No | N/A |
| 20. Is there proper slug clearance through die shoe? | Yes | No | N/A |
| 21. Did coil feed freely through die, at production run rate? | Yes | No | N/A |
| 22. Is part stamped right & left? | Yes | No | N/A |
| 23. Does part and scrap fall free from die? | Yes | No | N/A |
| 24. Is the offal ejection adequate? | Yes | No | N/A |

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Date: _____

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| 25. Is the latest die strip with the die prior to being shipped? (On top of die, not inside) | Yes | No | N/A |
| 26. Have dies that are interchangeable been made mistake proof with tags? | Yes | No | N/A |
| 27. Does the die meet AZ Automotive Corp. die build standards? | Yes | No | N/A |
| 28. Have you had wire burn paths on tape, final tool & detail drawings to latest revision? | Yes | No | N/A |
| 29. Any welded details? (Form # AZDS9) | Yes | No | N/A |
| 30. Any shims under or behind details? | Yes | No | N/A |

Approval (signatures)

Tool Shop: _____

AZ Automotive: _____
