



PM CHECK SHEET- GDC DIES

FORMAT NO- FR/TR/28

REV. NO:07

EFF DATE- 05.11.2022

Model Name/ Die Name:-		Die Unloading Date:-		PM Start Date:-			Legends:- O - Initially OK X - Initially NOK ✓ - OK After action		
Die No:-		Standard Die Life :-		PM Done Date:-					
Total No Of Shot Produced Till Date :-		Total No. of Shots after Last PM :-		Total Time Taken For PM:-					
S. N.	PM Part	Check points	Acceptance Criteria	Check Method	PM-Activity		Observation	Action Taken	Remarks
					Before	After			
1	Complete Die	Opening of Die (Die Dismental)	Complete die	Visual					
2	Both Insert & Slides	Cleaning of Die With Shot Blasting Machine	No dirt,dust	Visual					
3	Both sides	Die Flash/Stuck metal Removal *	No flash/no sticking metal	Visual					
4	Both sides	Air Vent Cleaning/Replacement (Air Pressure 3-5 KG/CM ²)	No dust/ no chock	Visual/ Gauge					
5	Both sides	Total No. of Airvent Change (Sand Core Resting & II air vent to be changed at every PM - For EGR DW 10E die)	Quantity of arivents	Visual Quantity			Ø6mm Ø8mm Ø10mm Ø12mm Ø14mm	Ø6mm Ø8mm Ø10mm Ø12mm Ø14mm	
6	Both Sides	Air vent Level to be Check (specified +0.1mm In Die)	+0.1MM	Vernier/HG			Ø6mm Ø8mm Ø10mm Ø12mm Ø14mm	Ø6mm Ø8mm Ø10mm Ø12mm Ø14mm	
7	Both sides	Air Roots Cleaning (Spigot Area, Core Resting area to be clean & polished to remove the carbon marks)	No dust/chock	Visual					
8	Both sides	Fitting of Air Vents	Tight/ level	Visual/Maunally					
9	Slide/Mov. Side	Ejector Pin Height Checking (Max.- 0.2 mm down)*	level- 0.2mm Down	Vernier /HG					
10	Slide/Mov. Side	Ejector Pin Lock Condition Check	Lock condition	Visual					
11	Both sides	Casting Area Polishing	No Catching/no Carbon Mark	Manually					
12	Both sides	Slide Core Blue Matching & Movement of Slide to be check	Minimun 70% blue dist. required	Visual					
13	Both Insert	Die Inserts Blue Matching*	Minimun 70% blue dist. required	Visual					
14	Core print area	Shell Core Print Blue Matching*	Minimun 70% blue dist. required	Visual					
15	Hyd. Cylinder	Hyd. Cylinder Leakage Checking/ repairing	No leakage	Power Pack M/c.					
16	Date/Shift/Month Punch	Date/ Shift/Month Code Condition Checking	No cut	Visual					
17	Both sides	Core Pin Condition Checking/Replacement *	No dent/No broken	Vishal/Manual					

18	Both Sides	Die Coating Thickness 0.03mm - 0.25mm	0.03-.025 mm	DFT Meter					
19	Both Inserts	Post Heating of Die (400°C - 450°C)	400°C - 450°C Temp.	Temp. Gauge					
20	Both Inserts	Pre-Heating of Die (200°C - 250°C)	200°C - 250°C Temp.	Temp. Gauge					
21	Both sides	Placement of Hole Forming Pin*	No Dirt/clean,band & broken	Visual/Vernier/MM					
22	Complete Die	Die Assambly	complete die	Visual					
23	Both sides	Motor Bore Pin Height Shoule be Check 60.80± 1.00 MM* (DW10E 6.3 only)*	60.80 ± 1.00 mm	Vernier/Height gauge					
24	Ejector Fucntion	Ejector Function to be Check (Movement)	Ejector	Visual/Hand					
25	Gas Core Area	Gas Core Area (Spigot Area) Matching 0.5mm	0.5mm	Verniver/MM					
26	Gate Radius	Gate Radius to be check (R2)	R2	Radius Gauge					
27	Holder	Core Holder Matching to check In PM	Minimun 80% blue dist. required	Visual					

Note:-1. All Above Point Shall be Verified during PM.
2. * Point most important after die life 60k.

PM Done By:-	Name:-	Review By:-	Name:-	Approved by	Name:-
	Signature:-		Signature :-		Signature:-