



**MANOJ INDUSTRIES**  
DIE PREVENTIVE MAINTNANCE SHEET

Formate no-F.PRD.P01.F09

Customer name :-

ETL.

Date :-

09/08/28

Die/Part name :-

K2 Reap Caliper.

No. of shot covered :-

9400.

Cavity No. :-

4/5/16

Sr. No.	Die Check points	Parameter	Inspection Method	Observation	Action taken	Remarks
1	Die first half & second half (Visual inspection)	1) No Dent & Damage 2) No Crack 3) No Rusty 4) Cavity 5) No burr	Visually	OK No Dent clamping OK No crack OK No cavity OK No burr observed	Burr removed from casting profile in die.	OK
2	Die air vent	Should at cavity level	Visually	OK at cavity level		OK
3	Die ejection pins should be free from damage, bend & Ejection plate parallel to die face.	Die air vent free from blockage	Visually	OK free from blockage		OK
		Should at cavity level	Visually	OK cavity level.		OK
		Ejection pin should ok (free from dent, damage)	Visually	OK No damage.		OK
		Ejection plate should parallel to die face	Visually	OK parallel to die face.		OK
4	Die dowel pins/bush	Ejection pin bend	Surface Plate for bend checking	OK No ejection pin bend.		OK
		No. of ejection pins	As per attached sheet	OK 12 Nos		OK
4	Die dowel pins/bush	Ejection pin size (Dia.)	Vernier Caliper	OK $\phi 12, 10, 18, 6$ mm		OK
		No. of dowel pin	As per attached sheet	OK 2 set.		OK
4	Die dowel pins/bush	Dowel pin size	Vernier Caliper	OK 16.00-0.05 } OK		OK
		Dowel pin size	Vernier Caliper	OK 16.00-0.05 } OK		OK
Casting inspection						
			Date :-	0		
Sr no	Product points	Parameter				
01	Casting mismatch	No mismatch	Visually	NO Mismatch.		
02	Parting line	Size	Vernier Caliper	less Parting line		OK
03	Wall thickness	As per part size	Vernier Caliper			
04	Casting flash	No casting flash	Visually	NO flash.		
05	Casting dimension	As per attached sheet	-			

Prepared by

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Approved by

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