



### PREVENTIVE MAINTENANCE CHECK LIST FOR DIES









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**SCHEDULE**                      **Preventive maintenance to be done**  
**1. First 5000 shots**  
**2. Between Every 20000 Shots to 25000 Shots**

Note :- Part Name, Die no.& Date must to maintained on report

Part Name :- \_\_\_\_\_ Die No. :- \_\_\_\_\_ PM Date :- \_\_\_\_\_

#### Routine / Preventive Maint. Check List

1	Open the Die & clean properly to remove the rust, dirt & dust	
2	Cleaning of cooling line to be done & check the thread nad drill out & repair if required 	
3	Leakage of Cooling pipe to be checked & Replace if required 	
4	Hole forming pins replaced if required, Bend not allowed in Hole forming pin & Harden Pin to be used. 	
5	Bush Fitting Pins to be check for bend & replace if required. 	
6	Gap not allowed between hole forming pins 	
7	Cleaning of slides & stoppers to be done	
8	Blue matching to be done of inserts, sprue bush, Diffuser & punches etc.	
9	Polishing to be done	
10	To check & repair the die block, ejector box, mounting surface, clamp slots, guide pins	
11	Guide pillar & bush to be checked & repair if req. & changed every One Month.	
12	Sprue bush & diffuser to be checked & repair if required every 45000 shots. 	
13	Stress relieving & nitriding to be done every 40000 shots	
14	Check the Gate erosion, Depth & Width	
15	Check the Heat check marks, Crack ,dent & Damage	
16	EDM Marks to be checked	
17	Attend the NG Point as per Last Shot Report (Die /Tool Rectification)	
18	Check the hydraulic cylinder & accumalator	
19	Pillars to be cheked for bending before loading	
20	Check all ejector pin head & if required , to be changed & ensure the height also	
21	Ejector pins hole to be lubricated & Checked for Play (Play not allowed)	
22	Ejector plate to be check for depression (deformation) during preventive maintenance	
23	Tie Bar rod Condition to be checked before die loading	
24	Engraving must be clear & visible. 	
25	Engraving height /Width to be checked at customer end during Dovelopment /New Die 	

Comment If Any :-

Initial Effective Date : 13.09.18

**CHECKED BY:**

**VERIFIED BY:**