

*******IMPORTANT*******

PLEASE READ!!!!!!!!!!

1. CHANGES IN SET-UP OR OPERATION PROCEDURE

2. PREVIOUS NON-CONFORMING ISSUES

BACHMAN MACHINE COMPANY WORK INSTRUCTIONS	PREPARED BY: PROD. SUPV.		DATE: 03-03-10	PAGE 1 OF 7
	APPROVED BY: MANUF. MGR.	APPROVED BY: QUALITY MGR..	REVISION: C	WI #
TITLE: SET-UP FOR PART # /TOOL #				

SET-UP MANUAL
for
PART#: _____
TOOL#: _____
RACK LOCATION: _____

PRESS INFORMATION

- A. CUSTOMER NAME: _____
- B. PART NAME: _____
- C. PART LUBRICATION: _____
- D. MATERIAL SPECIFICATIONS: _____
STEEL COIL # _____
- E. SPECIAL PACKAGING:
 - 1. TYPE OF CONTAINERS: _____
 - 2. # OF PCS. PER CONTAINER: _____

PRESS SETTINGS
STARTING REFERENCE

TOOL #

PRESS				
PROGRESSION (INCHES)				
COUNTERBALANCE PRESSURE				
LEAD READING (reference only)				
PRESS SPEED				
PRESS FEED RATE				
ROLL PINCH PRESSURE				
ROLL LIFT (PRESSURE)				
PASS LINE				
WORK ROLL (ENTER)				
WORK ROLL (CENTER)				
WORK ROLL (EXIT)				
OILER CAM SETTINGS				
TOP STOP & HOLDING CAM				
AUTOMATION CAM SETTINGS				
FEED ANGLE				
FEED RESET				
SAFETY SHUT OFF #1 (DEGREES)				
SAFETY SHUT OFF #2 (DEGREES)				
SAFETY SHUT OFF #3 (DEGREES)				
LOAD MONITOR #1-LEFT (TONS)				
LOAD MONITOR #2-RIGHT (TONS)				
LOAD MONITOR #3 (TONS)				
LOAD MONITOR #4 (TONS)				
LOAD MONITOR TOTAL				
PILOT RELEASE ANGLE				

**DIE PROTECTION SETTINGS
STARTING REFERENCE**

(5000 SERIES)

CUSTOMER: _____
PART NAME: _____
PART NUMBER: _____

TOOL #

	PRESS	MODE/OUTPUT			
	PROGRESSION				
1	SHORT FEED				
2	LONG FEED				
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					

SET-UP PICTURES

NOTES:

NOTES:

QUALITY PROCEDURES

- A. SET-UP PERSON TO REQUEST GAGES REQUIRED PRIOR TO SET-UP.
- NO HARD GAGES.
- B. SET-UP PERSON TO SUBMIT FIRST PART TO INSPECTION, AFTER HE VERIFIES THE PARTS MEET ALL GAGES AT THE PRESS.
- C. THE SET-UP PERSON IS TO BRING THE LAST PART TO THE INSPECTION DEPARTMENT, ALONG WITH THE GAGES USED BY THE OPERATOR.

INSPECTOR TO WRITE BMC NON-CONFORMING TAG FOR ALL NON-CONFORMING PARTS OR PART TO BE SORTED PER PROCEDURE.

PRESS OPERATION NOTES

TOOL #

OPERATION NOTES:

1. ALL PARTS RAN PRIOR TO FIRST PART APPROVAL, MUST BE SCRAPPED.
2. ALL PARTS PRODUCED DURING THE FIRST 12 STROKES, AFTER A COIL CHANGE, WILL BE SCRAPPED.
3. GREASE LEADER PINS TWICE PER SHIFT.

PRESS OPERATOR'S QUALITY CONTROL RESPONSIBILITIES:

1. NO HARD GAGES.
2. VISUAL -
3. PARTS MUST BE CHECKED A MINIMUM OF 4 TIMES PER HOUR OR MORE IF NEEDED.
COMPARE TO SAMPLE PARTS
4. ANY OTHER QUESTIONS, CONTACT THE Q.A. DEPARTMENT OR YOUR SUPERVISOR.