

Set-Up Checklist

Pull all tools from the machine	
Clean all tools(gauges) and clean machine	
Clean all trap points, shoots, and conveyors	
Clean any parts, oil, and kerosene from the floor	
Pull new tools(gauges) and work order from Tool Room	
Put new tools into machine	
Set Die Lengths	
Set Knockouts and Shoes	
Line up and gap the knife and quill	
Build 1 st and 2 nd transfers	
Line up 1 st and 2 nd transfers	
Check timing on 1 st and 2 nd transfers	
Change Draw Die(s)	
Change Feed Wheels	
Load Wire	
Set Stroke and Stock Stop	
Check machine oil, drip oil, and draw powder	
Balance and center the part	