

Set-Up Checklist Sakamura ½ in.

Pull all tools from the machine	
Clean all tools and clean machine	
Clean all trap points, shoots, and conveyors	
Clean any parts, oil, and kerosene from the floor	
Pull new tools and work order from Tool Room	
Check new tools for repairs	
Change KO Tubes	
Change Dies and Punches	
Change Knife and Quill	
Change Draw Die	
Change die blocks (if needed)	
Set Die Lengths	
Set wedges and lockdown punches and dies	
Set KO Stroke	
Set Feed Stroke	
Set Trim Snap	
Change and set stock stop	
Set, line-up, and gap Knife and Quill, adjust if needed	
Check KO's, adjust if needed	
Set Transfers	
Change Feed Wheels	
Check draw powder, drip oil, and machine grease	
Load Wire	
Straighten Wire	
Set Trim Snap, Trim Die, and Trim Punch	
Balance and center the part	