

BARDANE MANUFACTURING COMPANY
GENERIC DIE CAST WORK INSTRUCTION

DIE CASTING

Customer - any part that requires **DIE CAST** process

Part Number -

Part Name -

Alloy -

Start up: Apply plunger lube for lubrication on :

A.Cover Half:

As instructed by your foreman/supervisor

B.Ejector Half:

As instructed by your foreman/supervisor

Sprayer/Ladler Startup:

As instructed by your foreman/supervisor

Inspection:

1. Non-Fill
2. Broken Core Pins
3. Broken Ejector Pins
4. "Sinks"
5. Stuck parts
6. Drags on parts
7. Discolored parts

Ask your foreman/supervisor for definitions and/or examples of the above terms.

Notify set-up person,foreman or the quality department of any discrepancies.

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Quality Instructions for the Die Cast Process

Customer any part that requires **DIE CAST** process
Part Number
Part name
Alloy

Inspection Visual:

1. Ensure die cast operator is inspecting per work instructions.
2. Large nonfill, sinks, porosity, grease, cracks, drags and gouges.
3. Broken or bent cores or ejector pins.
4. Stuck, pulled, or cracked parts.
5. Any other visual defect.
6. Place in container left by part movers.
7. Place all necessary tags on container.

Ensure routing tag is filled out correctly.

Inspection Dimensional:

1. Gauge per quality instructions, blue print specification, operation sheet or supervisor/manager instructions.