Press Operations and Basic Die Setting
In-Plant Training Agenda (Sample)

This agenda is based on training two shifts - or two cohorts - per day
(3 hours of training per shift/cohort)

DAY 1 (3-hours)

Introduction(s)

Press Construction/Press Nomenclature
- Gap Frame Construction
- Straight Side Construction
- Press Nomenclature (Bed, Ram, Uprights, Tie Rods, Bolster, Pitman)
- TDC/BDC
- Drive Systems: Mechanical/Flywheel Drive
- Servo Technology

Press Force and Energy
- Forward Tonnage
- Reverse Tonnage (Blanking Operations)
- Tonnage Monitors
- Press Energy (Deep Drawing Operations)
- Counterbalance Pressure

Press Specifications
- Capacity – Tonnage
- Shut Height
- Stroke Length
- Slide (Ram) Adjustment
- Strokes-Per-Minute (SPM)

Press Controls
- Main Motor ON/OFF
- Press Speed (SPM)
- Slide Adjustment
- Mode Selector
- Multiple Operator Mode(s)

PMA in-plant training programs are fully customizable. Subjects in this agenda can be removed, replaced or additional topics added from other PMA in-plant training programs.
Press Operations and Basic Die Setting
In-Plant Training Agenda (Sample)

This agenda is based on training two shifts - or two cohorts - per day
(3 hours of training per shift/cohort)

DAY 2 (3-hours)

Operator Controls
  • Foot Switches/Run Bars
  • Top Stop/E-Stop
  • Prior Action (Auto/Auto Setup)

Personal Safety
  • Reasons Injuries Occur
  • Personal Protective Equipment (PPE)
  • Warning Signs

Machine Safeguarding
  • Point of Operation
  • Safety Devices (Light Curtains, Two-Hand Controls, Restraints/Pullbacks)
  • Guards (Fixed, Interlocked, Adjustable, Movable)
  • Barriers (Guard Rails, Chains)
  • Operator Responsibilities/Supervisor Responsibilities

Operating the Press
  • Operator Checklist – All Presses
  • Manual Load Operations
  • Automatic Operations
  • Tail Out Procedures (End of Coil)

Changing Coils
  • Loading Coils (Reels and Cradles)
  • Threading Material Through the Straightener (step-by-step)
  • Threading Material Through the Feed
  • Threading Material Through the Die
  • Setting the Slack Loop

PMA in-plant training programs are fully customizable. Subjects in this agenda can be removed, replaced or additional topics added from other PMA in-plant training programs.
Press Operations and Basic Die Setting
In-Plant Training Agenda (Sample)

This agenda is based on training two shifts - or two cohorts - per day
(3 hours of training per shift/cohort)

DAY 3 (3-hours)

Lockout Tagout (LOTO)
- Hazardous Energy
- Controlling Hazardous Energy
- Affected Employees
- Authorized Employees
- Applying Lockout
- When Lockout is Not Required
- Removing Lockout
- Shift Changes
- Outside Contractors

Die Setting Practices
- LOTO During Die Setting
- Removing the Die (step-by-step)
- Die Removal Hazards & Risk Reduction
- Setting the Die Clamping Shut Height
- Setting the Next Die (step-by-step)
- Clamp/Fastener Selection
- Die Setting Hazards & Risk Reduction
- Final Shut Height Adjustments
- Solder Check Procedures (Set Blocks)