PRECISION METALFORMING ASSOCIATION
NETWORK. LEARN. LEAD.

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Progressive Die Setter Training
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 Force and Energy

- Forward Tonnage
- Reverse Tonnage (Blanking Operations)
- Press Energy (Deep Drawing Operations)
- Counterbalance Pressure
- Off Center Loads

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)

Machine Safeguarding

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

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.

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DAY 2 (3-hours)

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)
- Setting the Feed Length and Roll Pressure
- Setting the Pilot Release

Straightening and Feeding

- Loading Reels and Cradles
- How Straighteners Work
- Roller Depth and Pinch Roll Settings
- Threading Material Through the Feed
- Verifying Feed Length
- Threading Material Through the Die
- Setting the Slack Loop
- Verifying the Pilot Release

Optimizing Progressive Die Performance

- The Impact of 1 SPM
- Factors Impacting Feed Speed
- Factors Impacting Feed Accuracy

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