

## **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. .*

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### **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

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### **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)