DIE CHANGEOVER

Complete Visual Instruction & Photo Capture Package

DRAFT / NOT APPROVED
Do not use as an operating procedure

SAFETY PRIORITIES: LOTO before physical work | No one under suspended dies | Bolster-edge pinch points

One document for press operators, new hires, the Saturday photography team, and reviewers.

CONTENTS

02–04 — **Visual work instructions**
18 numbered steps, photo placeholders, acceptance checks

05 — **Process flow poster**
Decision points, quality gate, and approval holds

06–08 — **Saturday photo shot list**
Angles, framing, annotations, good-versus-bad comparisons

SATURDAY CAPTURE PLAN

1. Print pages 06–08 as the photographer checklist.
2. Capture each operation from an approved safe position.
3. Take wide views and close details when practical.
4. Do not stage unsafe, incorrect, or unapproved actions.
5. Keep original photos for later technical review.

APPROVAL HOLDS / [NEEDS INPUT]

Verify coil run-off vs. physical removal timing, isolation/restoration and safe dry-cycle authorization.
Confirm plant-approved lifting/rigging, hold-down torque and sequence, setup criteria and quality release before posting.

600-TON PROGRESSIVE PRESS | DIE CHANGEOVER

VISUAL WORK INSTRUCTION • STEPS 01-06

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STOP: LOTO BEFORE PHYSICAL WORK | NEVER WALK UNDER A SUSPENDED DIE | PINCH POINTS: BOLSTER EDGE

01 Clear Remaining Coil

[MISSING PHOTO]

[NEEDS INPUT]

Wide view of remaining coil and feed path.

ACTION

Run off remaining material only if permitted as a powered operating action. Physical coil removal must follow applicable LOTO.

LOOK FOR

[NEEDS INPUT] Approved run-off or removal method and clearance condition.

STOP: Confirm which coil tasks require LOTO.

02 Apply Lockout Tagout

[MISSING PHOTO]

[NEEDS INPUT]

Close view of designated isolation controls.

ACTION

Apply lockout/tagout before any physical die-change work, following the plant procedure.

LOOK FOR

[NEEDS INPUT] Required isolation and verification points.

STOP: No physical work before approved LOTO.

03 Disconnect Die Air Lines

[MISSING PHOTO]

Close view of air connection locations.

ACTION

Disconnect the air lines from the outgoing die.

LOOK FOR

Lines disconnected at the intended connections. [NEEDS INPUT] Port IDs.

Confirm approved isolation before disconnecting.

04 Disconnect Die Sensor Cables

[MISSING PHOTO]

Close view of die sensor connectors.

ACTION

Disconnect sensor cables from the outgoing die.

LOOK FOR

Intended connectors separated. [NEEDS INPUT] Connector identification.

Do not pull or strain sensor wiring.

05 Release Die Hold Downs

[MISSING PHOTO]

Oblique view of die hold-down points.

ACTION

Release the old die from its bolster hold-down points.

LOOK FOR

All specified hold-down locations released. [NEEDS INPUT] Location map.

Hold-down sequence and lift readiness need approval.

06 Lift Old Die Out

[MISSING PHOTO]

Wide view of controlled outgoing die lift.

ACTION

Crane the old die out using the rated spreader bar.

LOOK FOR

Die removed from bolster. [NEEDS INPUT] Approved lift details.

STOP: Never walk under the suspended die.

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VISUAL WORK INSTRUCTION • STEPS 07-12

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STOP: LOTO BEFORE PHYSICAL WORK | NEVER WALK UNDER A SUSPENDED DIE | PINCH POINTS: BOLSTER EDGE

07 Clean Bolster Surface

[MISSING PHOTO]

Angled view of clean bolster surface.

ACTION
Clean the exposed bolster seating surface.

LOOK FOR
No visible chips or debris where the die seats.

Keep hands clear of known pinch locations.

08 Lift New Die In

[MISSING PHOTO]

Wide view of incoming die over bolster.

ACTION
Crane the incoming die over the bolster.

LOOK FOR
Die positioned for centering. [NEEDS INPUT] Safe alignment method.

STOP: Never enter beneath the suspended die.

09 Center Die On Pins

[MISSING PHOTO]

Detail of locating pin alignment.

ACTION
Center the new die using the locating pins.

LOOK FOR
Locating features engaged. [NEEDS INPUT] Final seating criteria.

CAUTION: Pinch points at bolster edge.

10 Tighten Die Hold Downs

[MISSING PHOTO]

Corner-to-corner hold-down pattern overview.

ACTION
Tighten die hold-downs corner-to-corner in the approved torque pattern.

LOOK FOR
Correct pattern followed. [NEEDS INPUT] Torque source, value and verification.

STOP: Never substitute an assumed torque value.

11 Reconnect Die Air Lines

[MISSING PHOTO]

Close view of reconnected air fittings.

ACTION
Reconnect the air lines on the incoming die.

LOOK FOR
Required air connections matched. [NEEDS INPUT] Connection checks.

Confirm port identities using approved reference.

12 Reconnect Die Sensor Cables

[MISSING PHOTO]

Close view of seated sensor connectors.

ACTION
Reconnect incoming die sensor cables.

LOOK FOR
Required connectors seated. [NEEDS INPUT] Sensor verification method.

Protect cables from damage and pinch points.

600-TON PROGRESSIVE PRESS | DIE CHANGEOVER

VISUAL WORK INSTRUCTION • STEPS 13-18

DRAFT - NOT APPROVED

STOP: LOTO BEFORE PHYSICAL WORK | NEVER WALK UNDER A SUSPENDED DIE | PINCH POINTS: BOLSTER EDGE

13 Jog One Dry Cycle

[MISSING PHOTO]

[NEEDS INPUT]

Safe view of dry-cycle verification point.

ACTION
Jog one dry cycle only after the approved restart process is complete.

LOOK FOR
[NEEDS INPUT] Defined dry-cycle acceptance and permitted controls.

STOP: Restart/LOTO-release sequence is missing.

14 Perform Brass Hammer Seat

[MISSING PHOTO]

[NEEDS INPUT]

Approved brass-hammer seating detail.

ACTION
Perform the brass-hammer seat noted in the process summary.

LOOK FOR
[NEEDS INPUT] Exact contact point, energy state and successful-seat cue.

HOLD: Do not illustrate or teach the strike without approved detail.

15 Set Press Shut Height

[MISSING PHOTO]

[NEEDS INPUT]

Verified shut-height setting reference.

ACTION
Set shut height using the approved die-specific setting method.

LOOK FOR
[NEEDS INPUT] Spec card reference, limit and verification method.

Do not infer a setting from a photograph.

16 Verify Feed Progression

[MISSING PHOTO]

[NEEDS INPUT]

Close view of feed progression reference.

ACTION
Verify feed progression before producing first-off parts.

LOOK FOR
[NEEDS INPUT] Approved progression markers and limits.

Hold if feed progression cannot be verified.

17 Run Five First Offs

[MISSING PHOTO]

Top view of five first-off samples.

ACTION
Run five first-off parts for quality review.

LOOK FOR
Five first-off parts are available for inspection.

Do not substitute fewer parts for the required five.

18 Obtain Quality Sign Off

[MISSING PHOTO]

[NEEDS INPUT]

Close view of approved quality record.

ACTION
Obtain quality approval on the first-off parts.

LOOK FOR
Approved sign-off recorded. [NEEDS INPUT] Form and disposition rules.

STOP: No production release without required approval.

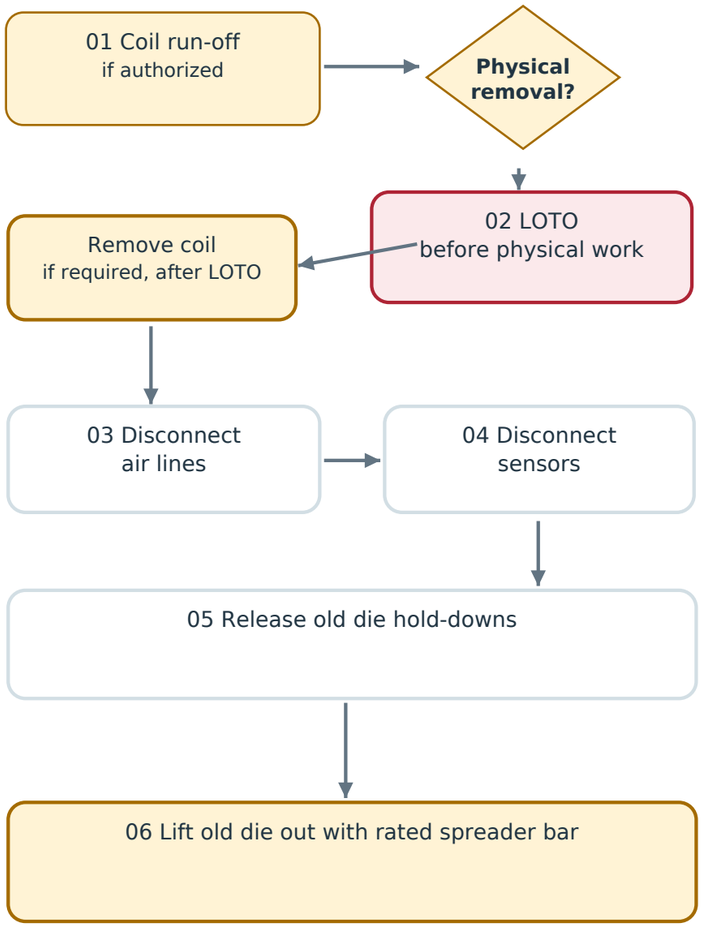
600-TON PROGRESSIVE PRESS | DIE CHANGEOVER

PROCESS FLOW • FLOW DIAGRAM + APPROVAL HOLDS

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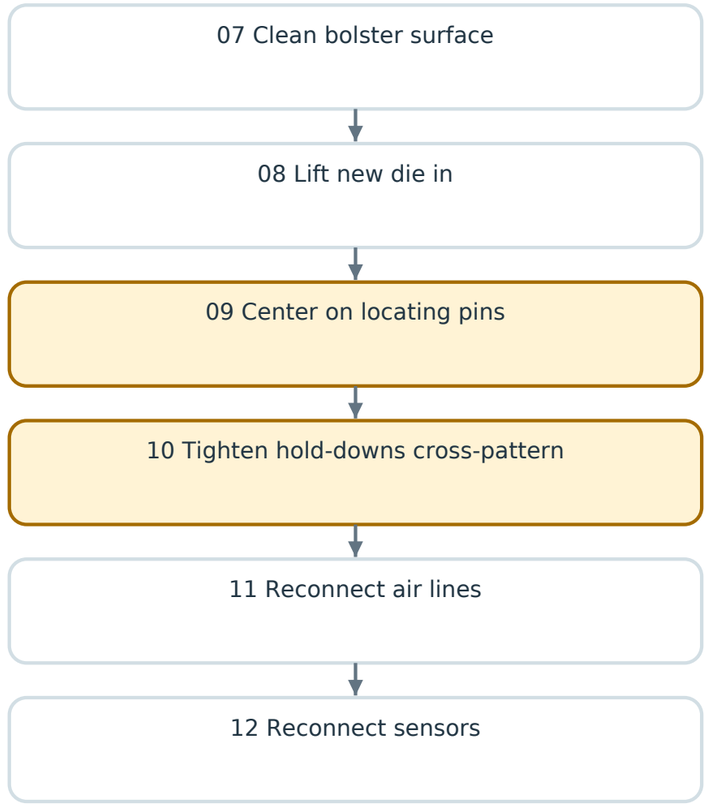
STOP: LOTO BEFORE PHYSICAL WORK | NEVER WALK UNDER A SUSPENDED DIE | PINCH POINTS: BOLSTER EDGE

A. PREPARE + ISOLATE



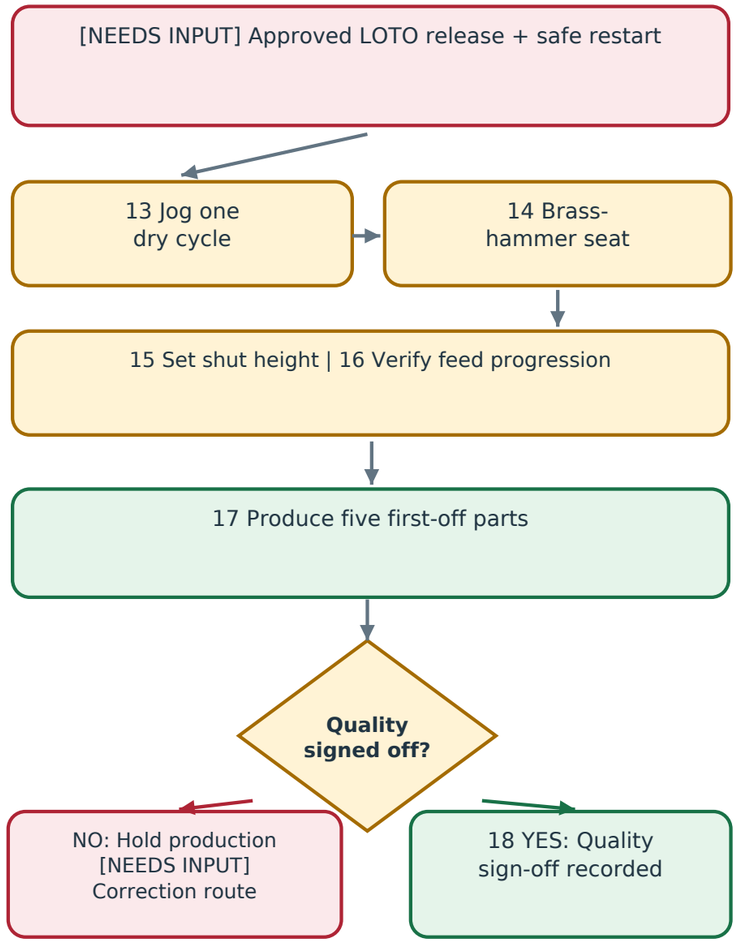
RED: LOTO and suspended-load safety holds

B. REMOVE + INSTALL



YELLOW: Verify seating, rigging, torque data

C. RESTART + RELEASE



No production release without quality approval

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SATURDAY PHOTO CAPTURE GUIDE • SHOTS 01-06

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STOP: LOTO BEFORE PHYSICAL WORK | NEVER WALK UNDER A SUSPENDED DIE | PINCH POINTS: BOLSTER EDGE

Photographer: use approved safe positions only. Do not interrupt the change, stage unsafe conditions, enter the operating envelope, or photograph beneath a suspended die.

01 Clear Remaining Coil

FRAME / ANGLE
Safe 3/4 wide view from feed-side aisle; show coil, entry and press opening.

ANNOTATE / HIGHLIGHT
Arrow to remaining stock and clearance point; label method only after confirmation.

GOOD VS. BAD?
YES: material clear versus material still in path; use historical/safe static image.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

02 Apply Lockout Tagout

FRAME / ANGLE
Close/mid view of plant-approved isolation points from normal safe access.

ANNOTATE / HIGHLIGHT
Circle authorized isolation points; no inferred sequence or control IDs.

GOOD VS. BAD?
ILLUSTRATION ONLY: completed versus incomplete isolation; never stage a hazard.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

03 Disconnect Die Air Lines

FRAME / ANGLE
45-degree close view of die-side air fittings, with enough context to orient.

ANNOTATE / HIGHLIGHT
Number actual connectors after confirmation; directional arrows.

GOOD VS. BAD?
YES: fully disconnected versus still-connected fitting, only when naturally visible.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

04 Disconnect Die Sensor Cables

FRAME / ANGLE
Close view along die edge showing sensor cable connections and routing.

ANNOTATE / HIGHLIGHT
Circle matching connectors and cable routing; use verified labels.

GOOD VS. BAD?
YES: connector separated versus still connected, from genuine process stages.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

05 Release Die Hold Downs

FRAME / ANGLE
Oblique medium view along bolster with visible hold-down locations.

ANNOTATE / HIGHLIGHT
Number actual hold-down points; distinguish released and engaged.

GOOD VS. BAD?
YES: released versus still engaged, only while the die is securely supported.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

06 Lift Old Die Out

FRAME / ANGLE
Wide from designated safe aisle; include crane hook, spreader bar and die.

ANNOTATE / HIGHLIGHT
Yellow suspended-load zone; green safe observer position after EHS review.

GOOD VS. BAD?
NO unsafe re-creation; use a red schematic for prohibited under-load location.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

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SATURDAY PHOTO CAPTURE GUIDE • SHOTS 07-12

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STOP: LOTO BEFORE PHYSICAL WORK | NEVER WALK UNDER A SUSPENDED DIE | PINCH POINTS: BOLSTER EDGE

Photographer: use approved safe positions only. Do not interrupt the change, stage unsafe conditions, enter the operating envelope, or photograph beneath a suspended die.

07 Clean Bolster Surface

FRAME / ANGLE
High oblique view from approved access, entire bolster with closer inset.

ANNOTATE / HIGHLIGHT
Green outline around clean seating areas; circle any observed debris.

GOOD VS. BAD?
YES: debris present versus clean after, photographed during normal cleaning.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

08 Lift New Die In

FRAME / ANGLE
Same safe wide angle as 06; capture spreader bar, die and bolster.

ANNOTATE / HIGHLIGHT
Direction-of-travel arrow and red under-load zone, approved by EHS.

GOOD VS. BAD?
NO unsafe re-creation; annotate only a safe approved position.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

09 Center Die On Pins

FRAME / ANGLE
Before placement: pin close-up; after landing: high oblique alignment view.

ANNOTATE / HIGHLIGHT
Arrows to actual pin positions and final seating indicators.

GOOD VS. BAD?
YES: correctly aligned versus mismatch, as diagram or historical example.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

10 Tighten Die Hold Downs

FRAME / ANGLE
High oblique view covering all anchor/hold-down locations.

ANNOTATE / HIGHLIGHT
Number corner-to-corner pattern after tooling confirms actual sequence.

GOOD VS. BAD?
DIAGRAM: approved cross-pattern versus sequential pattern; do not reenact.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

11 Reconnect Die Air Lines

FRAME / ANGLE
45-degree close view matching step 03 for easy before/after reference.

ANNOTATE / HIGHLIGHT
Green outlines on confirmed completed couplings; verified port labels.

GOOD VS. BAD?
YES: connected versus open fitting, using normal staged process states.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

12 Reconnect Die Sensor Cables

FRAME / ANGLE
Close view matching step 04, showing routing and connector seats.

ANNOTATE / HIGHLIGHT
Arrows to each confirmed connector and routing path.

GOOD VS. BAD?
YES: fully seated versus visibly loose, only if observed safely.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

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SATURDAY PHOTO CAPTURE GUIDE • SHOTS 13-18

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STOP: LOTO BEFORE PHYSICAL WORK | NEVER WALK UNDER A SUSPENDED DIE | PINCH POINTS: BOLSTER EDGE

Photographer: use approved safe positions only. Do not interrupt the change, stage unsafe conditions, enter the operating envelope, or photograph beneath a suspended die.

13 Jog One Dry Cycle

FRAME / ANGLE
Fixed safe-distance view of control area and press, not in operating envelope.

ANNOTATE / HIGHLIGHT
Highlight approved controls and observation point only after validation.

GOOD VS. BAD?
NO unsafe demonstration; use a decision graphic for pass or stop.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

14 Perform Brass Hammer Seat

FRAME / ANGLE
Capture close-up only if engineering/EHS confirms action and safe filming.

ANNOTATE / HIGHLIGHT
Circle approved contact location after review; no guessed strike arrow.

GOOD VS. BAD?
YES if approved: verified seated versus unseated condition; otherwise diagram.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

15 Set Press Shut Height

FRAME / ANGLE
Close view of operator-facing setting and correct approved reference.

ANNOTATE / HIGHLIGHT
Mark readout and spec-card field; add values only after approval.

GOOD VS. BAD?
YES: verified in-spec versus out-of-spec display, from safe training mockup.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

16 Verify Feed Progression

FRAME / ANGLE
Side oblique of feed interface and verified progression reference point.

ANNOTATE / HIGHLIGHT
Add arrows to reference features and valid feed direction.

GOOD VS. BAD?
YES: aligned versus misfed, using archive/diagram, not a live misfeed.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

17 Run Five First Offs

FRAME / ANGLE
Top-down on safe bench, five parts arranged separately and clearly.

ANNOTATE / HIGHLIGHT
Number samples 1 through 5; point to required quality checks once known.

GOOD VS. BAD?
YES: five complete samples versus fewer, safely staged on a bench.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake

18 Obtain Quality Sign Off

FRAME / ANGLE
Close view of actual approval field/status, masking personal or sensitive data.

ANNOTATE / HIGHLIGHT
Green box around approved status; identify authoritative form location.

GOOD VS. BAD?
YES: approved versus pending status with privacy-safe example.

CAPTURE STATUS
[ ] Wide [ ] Detail
[ ] Verified [ ] Retake