



11415 St. Rd. Box 248 Boscawen, NY 14020 (716) 343-7130

PRODUCT REQUIREMENTS DATA FOR BUYING DIE CASTINGS

In addition to the normal dimensional and metallurgical details on part prints, supplemental data on specific product requirements may affect the basis on which a die casting quotation is estimated. The check list below provides a numbering system in which the lowest numbered description for each requirement can be met at the lowest production cost. It will be to the advantage of both the buyer and the die caster if such a check list accompanies prints submitted for quotation. The information may also be indicated on your prints by coding with the applicable requirement numbers such as A1, B2, C1, etc. The check list shows the principal information needed and its relative effect on production cost.

	<input type="checkbox"/> 1. ...most economic basis of production. <input type="checkbox"/> 2. ...involves additional work which may affect cost. <input type="checkbox"/> 3. ...additional work and special requirements which increase cost.
A. SURFACE CONDITION	<input type="checkbox"/> 1. Some residue and chips not objectionable. <input type="checkbox"/> 2. Shop run — blown reasonable free of chips but not degreased. <input type="checkbox"/> 3. Clean, dry and free of chips.
B. CAST SURFACE FINISH	<input type="checkbox"/> 1. Mechanical Grade — finish is not significant. <input type="checkbox"/> 2. Painting Grade — some streaks and chill areas that can be covered with paint. <input type="checkbox"/> 3. High Quality — for electroplating, anodizing or other decorative finishing.
C. FLASH REMOVAL Parting Line External Profile	<input type="checkbox"/> 1. No die trimming — break off gates and overflows and remove flash within 1/4". <input type="checkbox"/> 2. Die trimmed — to within approx. .015" of die casting surface (See ADCI Standard E-10). <input type="checkbox"/> 3. Hand filed or polished — flush with die casting surface.
D. FLASH REMOVAL Cored Holes	<input type="checkbox"/> 1. Flash not removed. <input checked="" type="checkbox"/> 2. Flash trimmed to within .010" of die casting surface. <input type="checkbox"/> 3. Flash to be machined.
E. FLASH REMOVAL Ejector Pins	<input type="checkbox"/> 1. Not removed. (See ADCI Standard E-9). <input type="checkbox"/> 2. Crushed or flattened. (See ADCI Standard E-9). <input type="checkbox"/> 3. Removed from specific locations.
F. PRESSURE TIGHTNESS	<input type="checkbox"/> 1. No requirement. <input type="checkbox"/> 2. Pressure tight to agreed upon psi. Testing medium: _____ <input type="checkbox"/> 3. Other arrangements to be agreed upon.
G. FLATNESS	<input type="checkbox"/> 1. No requirement. <input type="checkbox"/> 2. To tolerances shown in ADCI Standard E-5. <input type="checkbox"/> 3. Critical — to special requirement.
H. DIMENSIONS	<input type="checkbox"/> 1. Normal — (As per ADCI Standards). <input type="checkbox"/> 2. Semi-Critical — must hold certain specified dimensions. Others as per ADCI Standards. <input type="checkbox"/> 3. Critical — must hold all specified dimensions.
I. CUSTOMER'S RECEIVING INSPECTION	<input type="checkbox"/> 1. No Statistical Quality Control — no unusual inspection requirements. <input type="checkbox"/> 2. Statistical Quality Control — AQL's over 2.5%. <input type="checkbox"/> 3. Statistical Quality Control — shipment acceptable at AQL of ____%. (2 and 3 above, require details of inspection procedure, with major and minor defects agreed upon)
J. PACKAGING	<input type="checkbox"/> 1. Not critical — bulk packed. <input type="checkbox"/> 2. Layer packed — with separators. <input type="checkbox"/> 3. Packed in cell type separators or individually wrapped.



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L. PARTING LINES	<input type="checkbox"/> 1. Polishing not required. <input type="checkbox"/> 2. Polish only where marked on drawing. <input type="checkbox"/> 3. Polish all parting lines (except as noted).
M. SURFACE PREPARATION	<input type="checkbox"/> 1. No buffing required. <input type="checkbox"/> 2. Mechanical (burnishing, tumbling, etc.). <input type="checkbox"/> 3. Buff as indicated on drawing.
N. PLATING, ANODIZING etc.	<input type="checkbox"/> 1. Protective Only _____ <input type="checkbox"/> 2. Decorative _____ <input type="checkbox"/> 3. Severe exposure _____ Specs _____
O. PAINTING	<input type="checkbox"/> 1. Protective Only _____ <input type="checkbox"/> 2. Decorative: Specs _____ <input type="checkbox"/> 3. Application requires base coat or special treatment (as noted).
P. EXPOSURE	<input type="checkbox"/> 1. Normal interior. <input type="checkbox"/> 2. Exposure to weather: Specs _____ <input type="checkbox"/> 3. Exposure to unusual chemistry: Specs _____
Q. APPEARANCE	<input type="checkbox"/> 1. Utility Grade. <input type="checkbox"/> 2. Commercial Grade. <input type="checkbox"/> 3. Superior Grade.

Remarks or comments: _____

Company: _____

Signed: _____ Dated: _____

Reference: _____

Be Sure with Sure-Cast