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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.

	☐ 1. ...most economic basis of production. ☐ 2. ...involves additional work which may affect cost. ☐ 3. ...additional work and special requirements which increase cost.
A. SURFACE CONDITION	☐ 1. Some residue and chips not objectionable. ☐ 2. Shop run — blown reasonable free of chips but not degreased. ☐ 3. Clean, dry and free of chips.
B. CAST SURFACE FINISH	☐ 1. Mechanical Grade — finish is not significant. ☐ 2. Painting Grade — some streaks and chill areas that can be covered with paint. ☐ 3. High Quality — for electroplating, anodizing or other decorative finishing.
C. FLASH REMOVAL Parting Line External Profile	☐ 1. No die trimming — break off gates and overflows and remove flash within 1/16". ☐ 2. Die trimmed — to within approx. .015" of die casting surface (See ADCI Standard E-10). ☐ 3. Hand filed or polished — flush with die casting surface.
D. FLASH REMOVAL Cored Holes	☐ 1. Flash not removed. ☒ 2. Flash trimmed to within .010" of die casting surface. ☐ 3. Flash to be machined.
E. FLASH REMOVAL Ejector Pins	☐ 1. Not removed. (See ADCI Standard E-9). ☐ 2. Crushed or flattened. (See ADCI Standard E-9). ☐ 3. Removed from specific locations.
F. PRESSURE TIGHTNESS	☐ 1. No requirement. ☐ 2. Pressure tight to agreed upon psi. Testing medium: _____ ☐ 3. Other arrangements to be agreed upon.
G. FLATNESS	☐ 1. No requirement. ☐ 2. To tolerances shown in ADCI Standard E-5. ☐ 3. Critical — to special requirement.
H. DIMENSIONS	☐ 1. Normal — (As per ADCI Standards). ☐ 2. Semi-Critical — must hold certain specified dimensions. Others as per ADCI Standards. ☐ 3. Critical — must hold all specified dimensions.
I. CUSTOMER'S RECEIVING INSPECTION	☐ 1. No Statistical Quality Control — no unusual inspection requirements. ☐ 2. Statistical Quality Control — AQL's over 2.5%. ☐ 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	☐ 1. Not critical — bulk packed. ☐ 2. Layer packed — with separators. ☐ 3. Packed in cell type separators or individually wrapped.



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

Remarks or comments: _____

Company: _____

Signed: _____ Dated: _____

Reference: _____

Be Sure with Sure-Cast