

**Appendix A.7**

**Core Competency Requirements  
NIMS Certified Stamping Press Set-up Operator**

**I. STAMPING PRESS SETUP OPERATOR: BASIC COMPETENCIES**

I. Core Competency Assessment: Stamping Press Setup Operator Basic Competencies

Duty Area	Task	Date Completed	Supervisor Signature
<i>A</i>	<i>Inspect Material &amp; Parts For Quality</i>		
A9	Measure ID/OD		
A10	Verify Type & Characteristics of Raw Material		
A11	Check & Verify Part Cosmetics		
A15	Measure & Verify Material Thickness and Width		
A16	Measure Overall Height and Length of Part		
A20	Clean & Zero Micrometer, Calipers and Indicators		
<i>B</i>	<i>Plan &amp; Prepare for Set-up and Production</i>		
B1	Review Production Packets		
B2	Review/Verify Setup Sheets and/or Checklists		
B3	Locate, Identify & Verify Die		
B5	Verify Raw Material		
B6	Verify Setup of Bins or Chutes and Conveyors		
B7	Verify Stage Lubricant(s)		
B8	Verify & Review MSDS's		
B9	Verify & Stage Packaging		
B10	Clean & Prepare Work Area/Station		
<i>C</i>	<i>Set-up Safety Equipment &amp; Devices</i>		
C2	Clean Sensors and/or Switches		
<i>D</i>	<i>Run Production (Operate Press)</i>		
D2	Start/Stop Press (with approval)		
D3	Set/Re-Set Counters to Zero		
D6	Monitor Scrap/Slugs		
D7	Remove & Isolate Scrapped Parts		

I. Core Competency Assessment: Stamping Press Set-up Operator Basic Competencies  
(cont.)

Duty Area	Task	Date Completed	Supervisor Signature
<i>D</i>	<i>Run Production (Operate Press)</i>		
D10	Replenish Part Lubrication Reservoirs		
D15	Adhere to Frequency of Part Inspections		
D17	Package/Contain or Palletize Finished Parts		
<i>E</i>	<i>Set-up Die</i>		
E2	Clean Bolster & Ram		
E3	Clean Top/Bottom of Die		
E4	Stone Press Bolster		
E12	Replace/Clean Filters		
E13	Grease/Lube Guide Components		
<i>F</i>	<i>Set-up Auxiliaries &amp; Press</i>		
F12	Orient Parts for Secondary Operations (if applicable)		
F13	Prepare/Position Part Cleaning Equipment (if applicable)		
F14	Set/Position Packaging for Production		
<i>H</i>	<i>Conduct End-of-Run Requirements</i>		
H1	Submit Final Part for Inspection		
H2	Get Approval for Final Part		
H5	Stage & Organize Die Clamping Devices for Next Set-up		
H6	Empty Scrap Bins/Containers		
H7	Clean Conveyors and/or Chutes		
H8	Stage Completed Parts for Pick-up		
H9	Submit End-of-Run Samples and/or Strip		

**II. STAMPING PRESS SETUP OPERATOR: INTERMEDIATE COMPETENCIES**

**II. Core Competency Assessment: Stamping Press Setup Operator Intermediate Competencies**

Duty Area	Task	Date Completed	Supervisor Signature
<i>A</i>	<i>Inspect Material &amp; Parts For Quality</i>		
A1	Match Part to Print		
A2	Identify Critical Dimensions		
A3	Check Parts for Absence of Features		
A4	Match Gauge/Fixture to Part Specifications		
A5	Measure Height of Features		
A6	Measure Depth of Coining (if applicable)		
A7	Measure Internal/External Radius or Radii (if applicable)		
A8	Measure Depth of Draw or Cup (if applicable)		
A12	Check & Verify Hole Size and Location(s)		
A13	Measure Hole-to-Edge Dimensions		
A14	Measure Hole-to-Hole Dimensions		
A17	Measure Critical GD&T (if applicable)		
A18	Check/Verify Part Profiles		
A19	Chart/Record Critical SPC Data		
<i>B</i>	<i>Plan &amp; Prepare for Setup and Production</i>		
B4	Verify Gages and Inspection Devices		
<i>C</i>	<i>Set-up Safety Equipment &amp; Devices</i>		
C1	Connect Sensors to Readout Devices		
C4	Test & Verify Operation of Light Curtains and Mats (if applicable)		
C5	Install Safety Blocks		
C6	Inspect Crane/Hoists & Rigging for Safety and Function		
C9	Complete & Submit Safety Inspection Documentation or Checklist (if applicable)		

II. Core Competency Assessment: Stamping Press Setup Operator Intermediate Competencies (cont.)

Duty Area	Task	Date Completed	Supervisor Signature
<i>D</i>	<i>Run Production (Operate Press)</i>		
D1	Load Coil, Strip or Blanks		
D4	Feed (Jog/Inch) Material Through Die		
D5	Weld End-Tail to Beginning of New Coil (if applicable)		
D8	Set Press Speed & Adjust and Control Process		
D9	Adjust Shut Height		
D11	Change out Lubricants		
D12	Monitor & Adjust Press/Press Line Controls (with approval)		
D13	Monitor Transfer Controls (if applicable)		
D16	Label/Tag/Identify Parts for Traceability		
D18	Record Required Production Data /Information		
<i>E</i>	<i>Set-up Die</i>		
E1	Set Shut Height		
E5	Select Clamping Devices		
E6	Align Die to Feed Line		
E7	Place Die Into Press		
E8	Check, Install & Set Bolster Blocks (Quick Die Change) (if applicable)		
E9	Install & Clamp Die in Press		
E10	Connect In-Die Sensors (if applicable)		
E11	Adjust Material Bridge		
E14	Set Pilot Release		
E15	Set Knockouts		
E16	Set Air Cushion (if applicable)		
E17	Set Manifold Pressure (Nitro/Hyd) (if applicable)		
E18	Install/Adjust Lubrication System or Equipment		

II. Core Competency Assessment: Stamping Press Setup Operator Intermediate Competencies (cont.)

Duty Area	Task	Date Completed	Supervisor Signature
<i>E</i>	<i>Set-up Auxiliaries &amp; Press</i>		
E19	Run First Part(s) (with approval)		
E22	Inspect Parts & Obtain First Part Approvals		
<i>F</i>	<i>Set-up Auxiliaries &amp; Press</i>		
F1	Install Conveyors I Stackers (if applicable)		
F2	Install Part-Out Conveyors (if applicable)		
F3	Set/Position Uncoiler, Magazine or Blank Stacker (if applicable)		
F5	Set/Adjust Material Feeder		
F8	Set Tension on Slack Loop		
F9	Install/Set Transfer or Automated System or Devices (if applicable)		
F10	Install/Set/Adjust Hydraulic and/or Pneumatic Systems (if applicable)		
F15	Clean Feed & Straightener Rollers		
<i>G</i>	<i>Troubleshoot Operations (Selected Examples) (if applicable)</i>		
G1	Determine Cause of Double Hits (if applicable)		
G2	Find Out Why Material Has Buckled (if applicable)		
G3	Diagnose the Cause of a Short/Over-Feed Condition (if applicable)		
G5	Determine Why Parts are Sticking in the Die (if applicable)		
G6	Respond to Sensor Faults (if applicable)		
G7	Determine Why Parts Have Visual Defects (if applicable)		
<i>H</i>	<i>Conduct End-of-Run Requirements</i>		
H3	Complete End-of-Run Documentation		
H4	Remove Die From Press and Stage for Storage		
H10	Return or Prepare Un-Used Material (Pick-up or Inventory)		

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**III. STAMPING PRESS SETUP OPERATOR SKILL LEVEL: ADVANCED COMPETENCIES**

Duty Area	Task	Date Completed	Supervisor Signature
<i>C</i>	<i>Set-up Safety Equipment &amp; Devices</i>		
C3	Program Tonnage Monitor to pre-determined engineering specifications		
C7	Fit & Set Pullbacks (if applicable)		
C8	Test Vision System (if applicable)		
<i>D</i>	<i>Run Production (Operate Press)</i>		
D14	Set/Adjust Counter Balance		
<i>E</i>	<i>Set-up Die</i>		
E20	Inspect Parts for Compliance During Run		
E21	Adjust Process/Equipment to Part Compliance		
<i>F</i>	<i>Set-up Auxiliaries &amp; Press</i>		
F4	Set/Adjust Straightener		
F6	Set Feed Length		
F7	Set/Adjust Leveler (if applicable)		
F11	Install/Prepare Butt Welder (if applicable)		
<i>G</i>	<i>Troubleshoot Operations (Selected Examples)</i>		
G4	Find Out Why Press Will Not Start (if applicable)		

Required NIMS Credentials

In order to demonstrate proficiency in all of the competencies listed in this appendix, the apprentice will have completed all of the following NIMS Credentials.

Name of Credential	Date Completed	Supervisor Signature
Metalforming Level I		
Parts Inspection & Quality Control		
<b>One of the following 5 (as applicable)</b>		
Operate with Single Hit Tooling II* Operate with Compound Dies II* Operate with Progressive Dies II* Operate with Deep Draw Dies II* Operate with Transfer Dies II*		
<b>One of the following 5 (as applicable)</b>		
Setup with Single Hit Tooling III* Setup with Compound Dies III* Setup with Progressive Dies III* Setup with Deep Draw Dies III* Setup with Transfer Dies III*		