



This production checklist provides a convenient method for assuring important factors involved in the purchasing of die cast parts are evaluated and clearly communicated.

This form intended to be used as a supplement to the essential dimensional and alloy specifications detailed on part prints submitted for quotation, since the listed factors directly affect the basis on which our quotation will be made.

**This checklist provides a numbering system in which the lowest numbered description for each requirement can be met at the lowest production cost, as follows:**

### **Cost Effect**

- 1 Most economical basis for production
- 2 Involves additional work which may affect cost
- 3 Additional work and special requirements which increase cost

### **Surface Condition**

- 1 Some residue and chips not objectionable
- 2 Shop run - blown reasonably free of chips but not degreased
- 3 Clean, dry and free of chips

### **Cast Surface Finish**

- 1 Mechanical quality - finish is not significant
- 2 Painting quality - streaks and chill areas coverable with paint
- 3 Highest quality - for electroplating, decorative finishing, O-ring seats

*Note: See NADCA Guideline G-6-6:*

### **Flash Removal - Parting Lines External Profile**

- 1 No die trimming - break off gates and overflows
- 2 Die trimmed to within 0.010 in. (0.25mm) of die casting surface
- 3 Hand filed or polished - flush with die casting's surface

### **Flash Removal - Covered Holes**

- 1 Flash not removed
  - 2 Flash trimmed to within 0.010 in. (0.25mm) of die casting surface
  - 3 Flash to be machined
- 1 Not removed (See NADCA Guideline G-6-5)
  - 2 Crushed or flattened (See NADCA Guideline G-6-5)
  - 3 Removed from specific locations.

## Pressure Tightness

- 1 No requirement
- 2 Pressure-tight to agreed-upon psi (kPa). Testing medium: \_\_\_\_\_
- 3 Other arrangements to be agreed upon.

## Flatness

- 1 No requirement
- 2 To NADCA "Standard" specification tolerances (S-4-5)
- 3 Critical requirement - to NADCA "Precision" specification tolerances (P-4-5)

## Dimensions

- 1 Normal: per NADCA "Standard" specification tolerances
- 2 Semi-critical: "Precision" tolerances on specified dimensions, others "Standard"
- 3 Critical: Must hold all specified dimensions to "Precision" tolerances

## Customer's Receiving Inspection

- 1 No unusual inspection requirements - no Statistical Quality Control
- 2 Statistical Quality Control: Acceptable at Cpk 1.33 or higher (or AQL over \_\_\_\_\_)
- 3 Statistical Quality Control: Acceptable at Cpk 2.0 or higher (or AQL over \_\_\_\_\_)

*Note: #2 and 3 above require details of inspection procedure, with major and minor defects agreed upon.*

## Packaging

- 1 Not critical - bulk packed
- 2 Layer packed, with separations, or weight restriction
- 3 Packed in cell-type separators or individually wrapped

## Casting Insert

- 1 No insert used in cast part
- 2 Inserts required, to be supplied by customer at 10% overage
- 3 Inserts required, to be supplied by Prestige Casting of die cast parts are evaluated and clearly communicated between the customer and Prestige Casting.



## Finish Procedure Checklist

This list is intended to be used as a supplement to the essential dimensional and alloy specifications detailed on part prints submitted for quotation, since the listed factors directly affect the basis on which our quotation will be made.

**This checklist provide a numbering system in which the lowest numbered description for each requirement can be met at the lowest production cost, as follows:**

### Cost Effect

- 1 Most economical basis for production
- 2 Involves additional work which may affect cost
- 3 - 4 Additional work plus special requirements which increase cost
- 5 Most difficult surface to die cast on a production basis

### Parting Lines

- 1 Polishing not required
- 2 Polish only where marked on drawing
- 3 Polish all parting lines (except as noted)

### Surface Preparation

- 1 No buffing required
- 2 Mechanical (burnishing, tumbling, etc.)
- 3 Buff as indicated on drawing

### Plating, Anodizing, or Other Special Finish

- 1 Protective Only - Specify: \_\_\_\_\_
- 2 Decorative - Specify: \_\_\_\_\_
- 3 Severe Exposure Protection - Specify: \_\_\_\_\_

### Painting

- 1 Heavy Paint, Protective Only - Specify: \_\_\_\_\_
- 2 Decorative Paint - Specify: \_\_\_\_\_
- 3 Application requires base coat or special treatment - Specify: \_\_\_\_\_

## Finish Procedure Checklist

### Environmental Exposure

- 1 Normal interior use only
- 2 Exposure to weather - Specify: \_\_\_\_\_
- 3 Exposure to unusual chemistry - Specify: \_\_\_\_\_

### As-Cast Surface - See NADCA Guideline G-6-6

- 1 Utility Grade - Surface imperfections acceptable, non-decorative coatings
- 2 Functional Grade - Slight, removable surface imperfections, heavier coatings
- 3 Commercial Grade - Removable imperfections
- 4 Consumer Grade - No objectionable imperfections as agreed upon when viewed under normal lighting conditions at \_\_\_\_\_ ft. viewing distance.
- 5 Superior Grade - Specified average surface finish value of \_\_\_\_\_microinches, per print.

### Special Requirements: