

Work Process Schedule

WORK PROCESS SCHEDULE		ONET Code: 51-4031
Stamping Press Operator		RAPIDS Code: 0928CB
Job Title: Stamping Press Operator		
Level:	Specialization:	
Stackable Program: <input type="checkbox"/> Yes <input type="checkbox"/> No		
Base Occupation Name:		
Company Contact:		
Address:	Phone:	Email:
Apprenticeship Type: <input type="checkbox"/> Competency Based <input type="checkbox"/> Time Based <input type="checkbox"/> Hybrid		Prerequisites:

Job Function 1: Inspects parts for quality and compliance			
Competencies	Core or Optional	RTI	OJT
A. Measures and verifies materials for quality and size	Core		
B. Matches and inspects parts to print	Core		
C. Measures heights and depths	Core		
D. Checks and records part profiles	Core		

Job Function 2: Plans job and prepares for setup and production			
Competencies	Core or Optional	RTI	OJT
A. Reliably follows the instructions of others	Core		
B. Willingly asks questions about things not fully understood	Core		
C. Works with due regard for the safety of others	Core		

D. Establishes a system of maintaining appropriate notes and reminders and completes any required logs, calibration records, etc.	Core		
E. Ensures proper communications between previous and next shifts, with both operations and supervision	Core		
F. Identifies problems and changes that could lead to problems by exchanging information with operators, supervisors, and others	Core		
G. Establishes trust and rapport with operators, supervisors, and others	Core		

Job Function 3: Sets up safety equipment and devices			
Competencies	Core or Optional	RTI	OJT
A. Cleans, connects, and verifies shortfeed detectors and sensors	Core		
B. Tests and verifies operation of light curtains and mats	Core		
C. Installs and inspects safety equipment	Core		
D. Sets program tonnage monitor to predetermined engineering specifications	Core		

Job Function 4: Sets up die			
Competencies	Core or Optional	RTI	OJT
A. Determines and sets shut height	Core		
B. Cleans bolster, ram, and top/bottom of die	Core		
C. Selects clamping devices and aligns and places die in press	Core		
D. Checks, installs, and sets bolster blocks, dies, and material bridge	Core		
E. Replaces/cleans filters and greases/lubes guide components	Core		
F. Sets pilot release, knockouts, air cushion, and manifold pressure	Core		
G. Installs and adjusts lubrication system or equipment	Core		
H. Runs and inspects first parts	Core		
I. Inspects parts for compliance during run, makes adjustments, and seeks approval	Core		

Job Function 5: Sets up auxiliaries and press			
Competencies	Core or Optional	RTI	OJT
A. Installs conveyors, stackers, and part-out conveyors	Core		
B. Positions/sets uncoiler, magazine or blank, and material/feeder	Core		
C. Sets/adjusts straightener, feed length, and leveler	Core		
D. Sets tension on slack loop	Core		
E. Installs/sets transfer or automated system or devices and hydraulic and/or pneumatic systems	Core		
F. Orients parts for secondary operations, prepares/positions part-cleaning equipment, and sets/positions packaging for production	Core		
G. Cleans feed and straightener rollers	Core		

Job Function 6: Runs production			
Competencies	Core or Optional	RTI	OJT
A. Loads coil, strip, or blanks	Core		
B. Starts and stops press	Core		
C. Feeds and welds material properly	Core		
D. Monitors, removes and replaces, and replenishes parts if necessary	Core		
E. Sets press speed and adjusts shut height	Core		
F. Packages finished parts	Core		
G. Sets and adjusts counter balance	Core		
H. Monitors and adjusts controls and, if necessary, transfers them	Core		

Job Function 7: Troubleshoots operations			
Competencies	Core or Optional	RTI	OJT
A. Determines cause of double hits	Core		
B. Finds out why material has buckled	Core		
C. Diagnoses the cause of a short/overfeed condition	Core		
D. Finds out why press will not start	Core		
E. Responds to sensor faults	Core		
F. Determines why parts have visual defects	Core		

Job Function 8: Conducts end-of-run requirements			
Competencies	Core or Optional	RTI	OJT
A. Submits final parts for inspection and receives approval	Core		
B. Completes end-of-run documentation	Core		
C. Removes die from press, stages for storage, and organizes die-clamping devices for next setup	Core		
D. Stages and organizes die-clamping devices for next setup	Core		
E. Empties scrap bins/containers, cleans conveyors and/or chutes, and stages completed parts for pickup	Core		
F. Returns or prepares unused material (pickup or inventory)	Core		