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Technical Release

Punch and Die Inspection Report

Customer POF: Y8A Customer Name: 806-436 Date Inspected: 10/15/2017 10:00 AM
 Tool Job Number: 17827-3 Product Number: 7885-028 Inspector: J.S.P./J.S.P. 10/15/17
 Tool Type: UPPER PUNCH Material Type: R08-07 Hardness (RC): 55.5

Punch #	DIM A	DIM B	DIM C	DIM D	DIM E
1	0.7478	0.2720	2.2276	0.0200	0.0402
2	0.7478	0.1100	5.2100	0.0410	0.0454
3	0.7478	0.3720	5.2202	0.0210	0.0170
4	0.7478	0.3728	5.2100	0.0200	0.0490
5	0.7478	0.2720	5.2102	0.0170	0.0170
6	0.7478	0.2120	2.2207	0.0149	0.0409
7	0.7478	0.1100	5.2101	0.0200	0.0400
8	0.7478	0.2720	2.2207	0.0149	0.0465
9	0.7478	0.1700	5.2100	0.0150	0.0400
10	0.7478	0.2729	2.2203	0.0200	0.0401
11	0.7478	0.1700	5.2100	0.0170	0.0470
12	0.7478	0.2726	2.2207	0.0148	0.0454
13	0.7478	0.2720	5.2206	0.0149	0.0473
14	0.7478	0.1700	5.2101	0.0200	0.0472
15	0.7478	0.2720	2.2207	0.0149	0.0464
16	0.7478	0.2720	2.2207	0.0147	0.0477
Maximum	0.7478	0.2720	5.2205	0.0200	0.0498
Minimum	0.7478	0.1100	5.2100	0.0147	0.0400
Range	0.0000	0.0002	0.0003	0.0007	0.0079

WL: Not to exceed a range of 0.0020" T.I.R., per TSM Specification.



Tooling Certification

Definition:

The Tooling Certification Program includes an inspection report detailing critical punch dimensions such as barrel, major axis, minor axis, overall length, cup depth, working length and die bore dimensions. To ensure manufacturing accuracy, critical measurements are automatically recorded as the tools are inspected using a Coordinate Measuring Machine (CMM).

All tools are laser etched with production date, Thomas Engineering logo and the sequential number of the punch. Any additional information can be etched on the neck of the punch including tablet size, purchase order number and product serial number.

Request for Tooling Certification is placed at the time of order. This documentation eliminates the customer's need for incoming tooling inspection and etching.



Tooling Certification

Purpose

- Ensures superior quality tooling.
- Reduces or eliminates customer inspection time.
- Beneficial in assessing tool life.
- Helps customer to certify a preferred vendor.
- May aid in customer's product validation process.



Applicability

- This program is available for all different size punches.



Benefits:

- Dimensions are automatically recorded as each punch is inspected.
- Tip Fitting is performed to ensure that each punch and die fits together exactly.
- Thomas Engineering's unique instrumentation/software package allows for extreme accuracy.
- Customer receives a hard copy report with each set of new tools. Thomas Engineering retains an electronic copy for archive purposes.
- Tools are etched with a sequential number for easy reference to corresponding measurements on the report.

For more information please contact our Customer Service Department at 800 . 634 . 9910