YASHI CASTINGS

7-POINT HPML
TOOLING VERIFICATION CHECKLIST

Before approving a moulding box supplier, verify these 7 critical parameters:

1 BUSH HARDNESS VERIFICATION

- ☐ Bush hardness specified on drawing
- ☐ Hardness range confirmed (Recommended: 60–62 HRC)
- ☐ Supplier can provide hardness verification record

2 BUSH MATERIAL GRADE

- ☐ Bush material grade specified
- ☐ Material certificate available
- ☐ Heat treatment process defined

3 PIN CENTRE ACCURACY

- ☐ Pin centre distance verified by measurement
- ☐ Inspection report available
- ☐ Not based on visual fit alone

4 FLANGE FLATNESS

- ☐ Flange flatness tolerance specified
- ☐ Machined surfaces inspected
- ☐ Flatness verification report available

5 PARALLELISM & SQUARENESS

- ☐ Cope and drag parallelism checked
- ☐ Squareness inspection completed
- ☐ Inspection records available

6 CNC MACHINING OF CRITICAL SURFACES

- ☐ Critical faces CNC machined
- ☐ Pin bores machined to drawing tolerance
- ☐ Machining process documented

7 FINAL INSPECTION & DOCUMENTATION

- ☐ Supplier provides dimensional inspection report
- ☐ Material specifications documented
- ☐ Quality records available before dispatch

ASK YOUR SUPPLIER THESE 3 QUESTIONS

1. What hardness will the bushes be delivered at?
2. How is bush hardness verified and documented?
3. Can you provide the inspection report before dispatch?

WHY THIS MATTERS

A moulding box can look perfect at delivery. But production stability depends on specifications that cannot be seen:

- Bush Hardness
- Pin Centre Accuracy
- Flange Flatness
- Parallelism Under Load

Precision at the source is always cheaper than adjustment at the line.

YASHI CASTINGS

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PRECISION. PERFORMANCE. PARTNERSHIP.