



**Work Instruction for 8 T
Hammer CDF**

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Scope: 8T Hammer for Close die forging

Responsibility: Operator

Method

1. First hammer start button on.
2. Unload both the dies with the help of crane or chain pulley.
3. Remove the old dowel and fit the required dowel.
4. Clean the area where the dies are going to be loaded with air and cotton waste.
5. Load the preheat dies and remove the support given to ram.
6. Fit the keys from front side.
7. If required, make the use of wedges.
8. Load 10 to 15 pieces of required die number in the furnace. Set furnace temperature at 1220 to 1250 degree Centigrade.
9. After soaking forge samples to establish quality and process.
10. Get the sample checked from supervisor/ inspector as per the drawing.
11. Record the starting temperature of furnace in log book. Count the cut billet. Soak the billet as per earlier time recorded. Record the time of first and last piece forged.

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