

 WESTERN HEAT & FORGE	Work Instruction for operation of Press (1000 / 1600 T)	Document No.	30-WI-PR-16
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		MASTER COPY	

Scope: 1000 / 1600 T Press Forging

Responsibility: Press Operator & Production Supervisor

Method:

1. Check the condition of machine before starting operation for ex. Cleanness, Tightness of nut & bolts.
2. ON the Emergency switch, also put operating button into Inching mode (1) & start the motor.
3. Before starting actual production kept operator button switch in Singly Stroke mode (2) and wait till light appears on stroke ready button.
4. Please ensure the forging die shall be properly heated before starting forging.
5. Heated billets from induction heater dropped near die via conveyor.
6. Hold heated billets by tongue & kept for upset. By paddle press forging done in one stroke each in sequence of Up setter → Blocker → Finisher as per forging method sheet.
7. After finisher operation job taken for trimming operation & then trimmed finished job put it into pallets.
8. Flash generated in trimming operation kept in other pallets for its disposition.
9. Record production in register.

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