



Work Instruction for Heat Code system for CDF

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Scope: This document is to be used for implementing heat code system for all dies in CDF except for those die nos. where it is not required by the customer.

Reference: Nil

Procedure

1. Manager Production to receive Heat Code details from route card.
2. Production supervisor to indicate Quantity planned of each heat code in Production Plan and inform die shop and QC.
3. Die-shop person to ensure that heat code to be used is engraved on dies at designated place before release of dies for production as per die drawing.
4. Shift in charge Production to ensure that Heat Code is fully legible in all the parts.
5. Shift in charge production to arrange dummy billets in furnace to allow for time required for change of Heat Code & also to ensure that no mix-up of two heat codes takes place.
6. Hot-Inspection Supervisor / Inspector to report heat-code change in IPIR (In-process Inspection Report). Inform Supervisor for necessary actions if it is not visible.

Shift In charge Production to ensure that forgings are stored in pallets heat code wise and duly identified with Tags.

PREPARED BY.
Production Supervisor

APPROVED BY.
Head production