



**Work Instruction for 3 T
and 2 T Hammer CDF**

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Scope: 3T and 2 Ton Hammer for Close die forging

Responsibility: Operator

Method

1. Close the air valve connected to the 3 Ton hammer and Close the Hydraulic oil Valve of 2Ton Hammer.
2. Collect die and tools from tool room.
3. Open the air valve with the support of rod for 3 Ton Hammer and Open the Hydraulic oil Valve for 2 Ton Hammer, rest the ram at correct desired height & close the valve.
4. Unload both the dies with the help of crane or chain pulley.
5. Remove the old dowel and fit the required dowel.
6. Clean the area where the dies are going to be loaded with air and cotton waste.
7. Load the dies and remove the support given to ram.
8. Fit the keys from front side.
9. If required, make the use of wedges.
10. After dies are set put warmer (hot steel scrap billets) in between the dies for at least an hour.
11. Load 10 to 15 pieces of required die number in the furnace. Set furnace temperature at 1240 degree Centigrade.
12. After soaking forge samples to establish quality and process.
13. Get the sample checked from supervisor/ inspector as per the drawing.
14. 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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