



**Work Instruction for
Heating Furnaces**

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Purpose

To achieve optimum Forging Temperature

General

Following guidelines shall be followed for soaking of cut billets.

Sr. No.	Section Size (Round /Sq) In MM	Soaking Period In Minutes
01.	Up to 75	15
02.	100	20
03.	125	25
04.	160	35

For Pusher Furnace after forging 30/40 nos. soaking of billets to be done as above.

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