



Work Instruction for 1T Close die Belt drop hammer.

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Scope: 1T Close die Belt drop hammer.

Responsibility: Operator

Method:

1. Switch off the motor. Remove both the keys.
2. Switch on the motor and raise the ram, support it with a rod of minimum 2" dia.
3. Remove the dies and dowels and clean the area where dies are going to be loaded.
4. Fir the required dowels. Load and set the dies on hammer. Switch on the motor remove the support, add packing material and set the dies.
5. First set the top die and then bottom. Confirm the alignment of top and bottom die.
6. Keep hot warmer between top and bottom die up to achieve 200 to 250degree Centigrade.
7. Set the furnace temperature as per forging method Sheet .
8. Put 10~15 nos. of required cut billets, soak them and forge samples.
9. Get the samples checked as per forging drawing from the Supervisor/Inspector.
10. Record the starting temperature of furnace in log book. Count the cut billet.
11. Record the time of first and last piece forged.

PREPARED BY.
Supervisor Prodcution

APPROVED BY.
Head Production