

 WESTERN HEAT & FORGE	Work Instruction for Operation of Pusher type Continuous Heating Furnace	MASTER COPY	Document No.:	30-WI-PR-13
			Rev No. & Rev Date:	01/10.08.2019
<p>Scope: Operation of Pusher type Continuous Heating Furnace</p> <p>Responsibility : Operator and Supervisor</p> <p>Method :</p> <ol style="list-style-type: none"> Heat the furnace to 700°C minimum and start billet loading into the furnace with the help of Pusher mechanism . Set Furnace temperature as per the Work Instruction 30-WI-MQC-01 Based on the forging cycle time , push the cut billets into the furnace . Monitor the temperature of billet with the help of optical pyrometer on 100% basis. Record the temperature as per Work Instruction 30-WI-MQC-01. If Billet temperature within the specified range, take it for forging. If billet temperature is below the specified range then put in pallet (Yellow Colour) identified as a reheating If billet temperature is above the specified range then put in pallet (Red Colour) identified as a scrap. Do the forging on hammer by putting the heated billet in Die cavity with the help of tong and allow the forging to cool in Air Forging finishing temperature shall not be lower than 870°C . Over heated billets kept in separate pallet shall be sent to scrap yard on daily basis. Under Heated billets kept in a separate pallet will taken for one time reheating in a separate batch and forging will be done within specified forging temperature range. If during reheating, billet temperature observed above or below specified temperature those billets will be kept in scrap pallet and send to scrap yard on daily basis. Separate record will be maintained for reheated billet batch and batch will monitored by shift supervisor. If Forging machine got breakdown , follow below steps, <ol style="list-style-type: none"> Reduce the furnace temp or switch -off (Based on severity of Breakdown) Pullout the billet , considering Under heat billets. Put these billets in Yellow bin for underheated billets & reheat once. Disposal of scrap billets shall be done on weekly basis from the scrap yard to out side of the company 				
Prepared By Production Supervisor		Approved By Production Head		