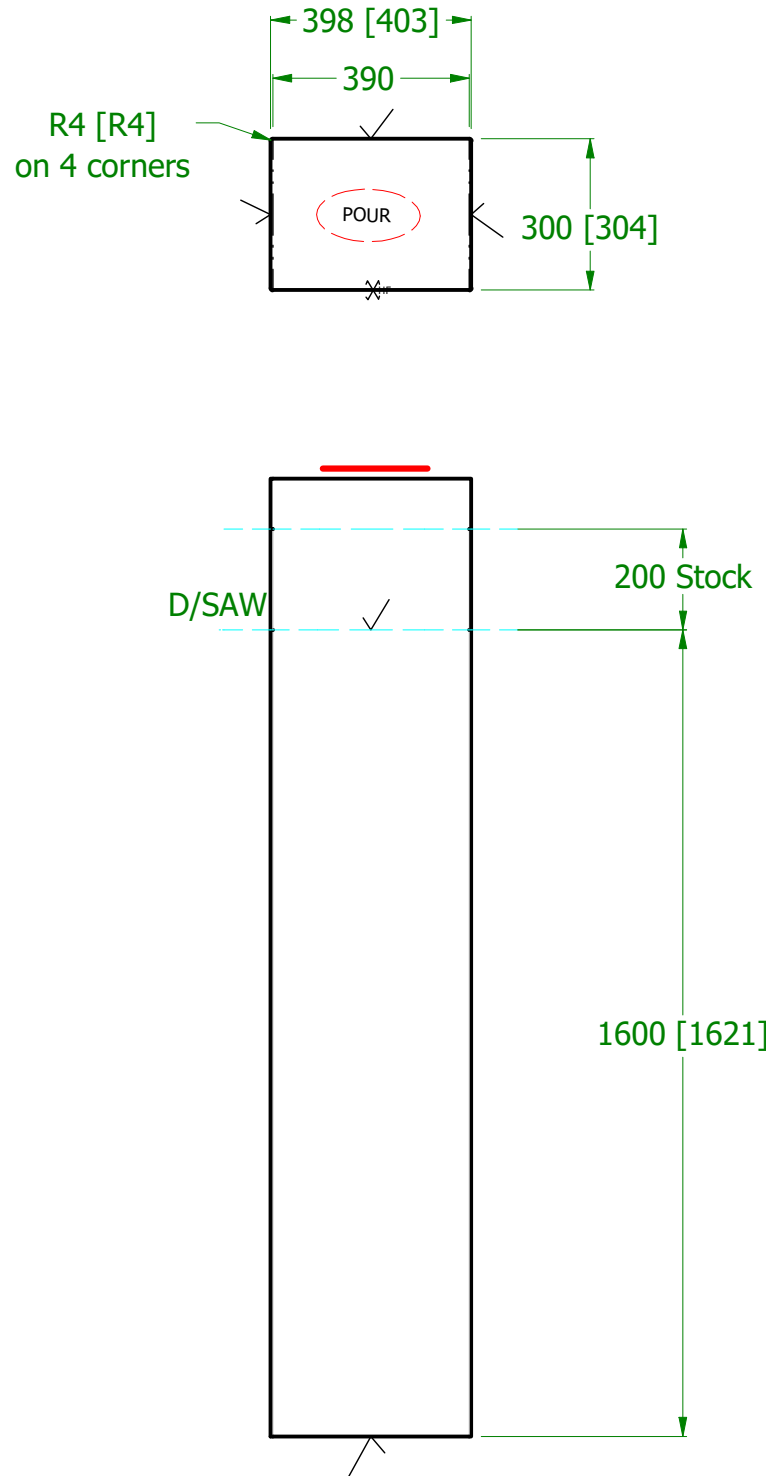
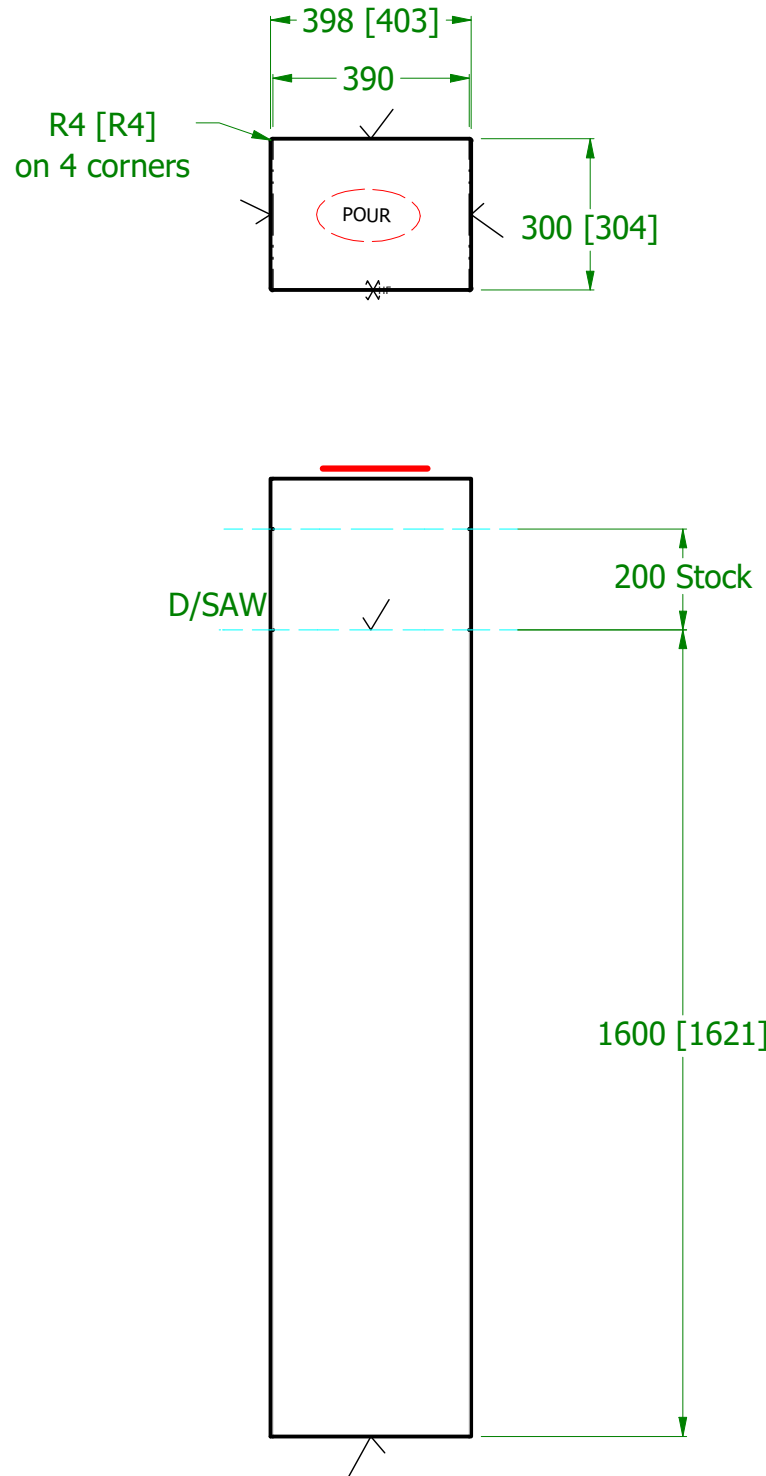


FINISHING PROESS		SPECIFICATION : SEFPRO			OLD M NUMBER :					CATEGORY : A		MODULE : SW 01		Internal major sides metallic chill		CHILLING DETAILS									
PROCESS	0											SPECIAL INSTRUCTION													
HEADER SAWING	1											FOUNDRY :-													
CUTTING	0											1) 43% Header													
GRINDING	3											3) Mould Wall thick bottom 80mm othersides 65mm													
STEP GRINDING	0											2) FENOTEC													
END GRRINDING	2											4) Resin 1.7% , catalyst 20%													
POLISHING	1											5) 30 % Demagnetized recycle sand + 70 % Tada sand formould making													
DRILLING	0	6) Inside coating																							
		1st layer full coating with magnesia + match stick and burner heating																							
		2nd layer full coatingwith zirconand no heating																							
		7) 200 mm stock																							
		FLASKING :-																							
		1) External Major sides metallic Chill																							
		2) Provide dry wood planks on 4 corners of the mould																							
		FURNACE :-																							
		1) No Repour																							
2) Hold the bin for 5 minutes																									
TITLE		MELTER SIDEWALL		---		GATE																			
		(403x304)376.5mm Ht.				HRD.SIZE																			
ASSEMBLY DRG NO :		PA6773-21		<div>104324</div> <div>PLANT</div> <div>SEPR-PALAKAD</div>																					
ITEM NO:		11107																							
CUSTOMER_PA6773		PA6773-21																							
CUSTOMER NAME		OA NO / ITEM																							
		QLY/ TYPE		1		1				1		1		1004		702		187200		SEFPRO		SEFPRO		SEFPRO	
				ORD		MADE		EX		PAT		Pc/Md		POUR		NOM		VOLUME (CC)		DRN		CHD		APPD	
				QUANTITY (NOS)										WEIGHT (KG)											