	ANGLE PROJECT				SSIONS				SCALE: NTS			C NO: F 201/D			
FINISHING PRO		SPECIFICATION : SEFPRO OLD M NUMBER :						:		CATEGORY: A MODULE: SW 01				_	
PROCESS	0										CIAL INSTRUCTION	ON		)	
HEADER SAWING	1									FOUNDRY			etallic		
CUTTING	0				<b>⊸</b> 30	98 [0] –				1) 43% F	leader			,	
GRINDING	<del></del>								3) Mould Wall thick bottom 80mm othersides 65mm				)		
STEP GRINDING	0		R4 [R on 4 cor				1	<u> </u>						)	
END GRRINDING	2				\ F	POUR	K	300 [304]		4) 5	4 70/	. 200/		<u>-</u>	DETAILS
POLISHING	1					<del>X</del> ::-	<u> </u>	<u> </u>		_	1.7% , catalys		ָרַ בַּרָ	5	
DRILLING	0									5) 30 % Demagnetized recycle sand + 70 % Tada sand formould making				•	CHILLING
							7			6) Inside	coating		Interna		Ö
		D/SAW 200 Stock							1st layer full coating with magnesia + match stick and burner heating				chill	chil	
				D/SAI	VV   		<del> </del>			2nd layer heating	full coatingwi	ch zirconand no			
										7) 200 m	m stock				GATE
										FLASKING	<u>:-</u>				G
										1) Extern	al Major sides	metallic Chill			
									Provide dry wood planks on 4     corners of the mould						
								1600 [1621]					/ALL	Ħ.	
													SIDEWALL	5mm F	IZE
									FURNACE :-					HRD.SIZE	
									1) No Repour			MELTER	(403×304)376		
			2) Hold							2) Hold th	) Hold the bin for 5 minutes			3x3(	
													TITE	(40	
					,	/							F		
ASSEMBLY DRG NO :	123456									L				, , /	
ITEM NO:	11071												7499F		
CUSTOMER_PA677	<b>3</b> A6773-21	1685 RR	1	<b>1</b> MADE	EX	<b>1</b> PAT	1 Pc/Md	<b>1004 702</b> POUR NOM	187200	TEST	TEST	TEST		PLANT	ALAKAO
CUSTOMER NAME	OA NO / ITEM	QLY/ TYPE	ORD QUANTI			EAT	FC/IMU	WEIGHT (KG)	VOLUME (CC)	DRN	CHD	APPD	] / /	/ SEX /	