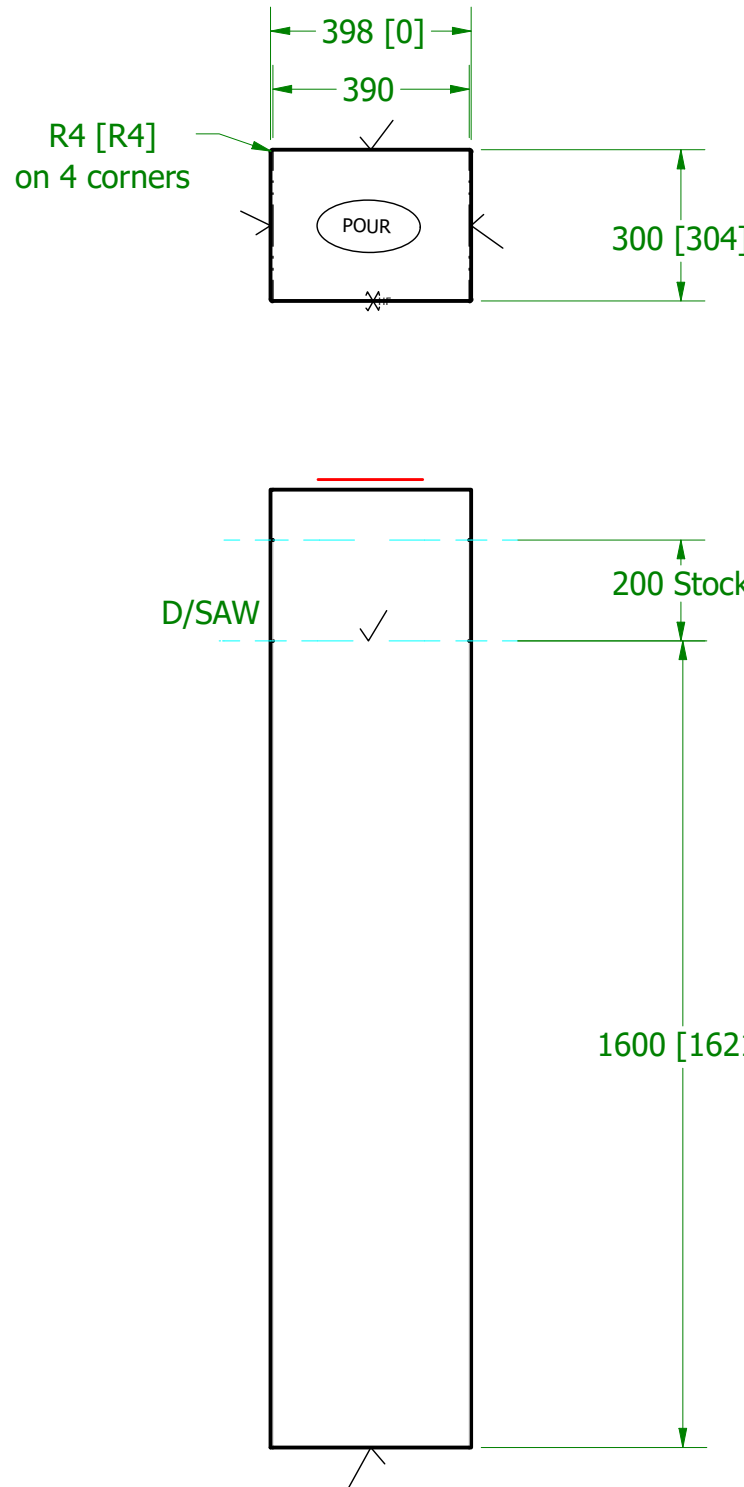


FINISHING PROESS		SPECIFICATION : SEFPRO				OLD M NUMBER :				CATEGORY : A		MODULE : SW 01		Internal major sides metallic chill		CHILLING DETAILS	
PROCESS	0											SPECIAL INSTRUCTION					
HEADER SAWING	1											<b>FOUNDRY :-</b>					
CUTTING	0											1) 43% Header					
GRINDING	3											3) Mould Wall thick bottom 80mm othersides 65mm					
STEP GRINDING	0																
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															
		<b>FLASKING :-</b>															
		1) External Major sides metallic Chill															
		2) Provide dry wood planks on 4 corners of the mould															
		<b>FURNACE :-</b>															
		1) No Repour															
2) Hold the bin for 5 minutes																	