

JOB NUMBER	JB/386/10	INTERNAL O/N	OR/209
DESCRIPTION	G 190565 Bracket Casting	CUSTOMER	J & J Attwell plc
		ORDER STATUS	Firm

QUANTITY	200	CUST. REF.	17778000-1
C OF C	No	MATERIAL	Grey Iron
DELIVERY	Apr 14,2011	ITEM STATUS	OK
		QUALITY STATUS	OK

NOTES
PRODUCTION
PROBLEMS
QA INFORMATION

Squeezer

INSTRUCTIONS

Part has been in production with same tooling now since April 1988
Scrap higher than previous (was 1.75% now 2.95%) - check wear on tooling.

QA INSTRUCTIONS

Check temperature of metal before pouring. Must be in range 1515 - 1525 decrees C. Do not use cores more than 3 days old !!!
Squeezer must be set to maximum on dial.

Dressing / Cleaning

INSTRUCTIONS

Casting is fragile and requires care in handling
Take care with thin web area near ingate.

QA INSTRUCTIONS

English. Feed pad marked with 'R' must be removed prior to shipping.
"Do not grind off " BOSS" Need quantity per heat code

Spanish. La tableta con la marca "R" deberia ser distante anterior de cargamento. "No puedes graniar afuera de "BOSS". Necesitas calidad por codigo de calor.



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Bracket Casting

Inspection

INSTRUCTIONS

Note safety requirements
Must wear protective clothing and mask

This casting draws very badly. The photos show why.



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QA INSTRUCTIONS

Procedure 115/A dated 02/02/98. Die Penetrant testing, 1 minute immersion in die, wash clean 1 minute in running water, dry for 30 seconds then spray with developer. Wait 30 secs then check for cracks

Shipping

INSTRUCTIONS

Shrink wrap with heavy gauge PVC sheet when castings are on pallet.
Maximum 15 castings per pallet.

QA INSTRUCTIONS

