



JOB CARD

Work No	JB/478/6	Part No	230361
Customer	Astral Products Ltd	Description	Orifice Inverter
Cust Part No	9855/2	Material	Grey Iron
Cust Order No	DRT	Drawing No	Rev #3
Estimate Ref	000-210-000	Sales Contact	

Section	Shell Core	Net Wt	9.50	Serial No Req	
Order Qty	350	No Impressions	1	Chemical Req	12 x 16
Due Date	19/09/11	Total Net Wt	3,325.00	Testbar Req	NO
Planned Cast Date	08/09/11	Gross Wt	12.30	Part Status	CAUTION
Qty in Stock	0	Total Gross Wt	4,305.00		
Moulds to Cast	361	% Yield	77.24%		

Delivery Address Mr J Batty Naseby Street Leicester England, UK LE4 5PU	Order Specific Notes:	Job Specific Notes:
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Process/Item	Qty	Supplier	PR Number	Order Number

Note: Inspection Notes in Bold Type

Route ID : 1

Shell Core (1 days)

Example of product with 'tracked' coremake stage. Book/count items thro' coremaking

See 1794-0000 for complex cored example

If only 'technical details' of coremaking and no book/count stage needed for cores see Part Nnumber 140162

Signature or Inspection Stamp _____ Qty: _____ Date: _____ Comments: _____

Squeezer (1 days)

Tracking / Work Booking enabled at Coremake as well as Mould/Cast stage, then subsequent stages if required.

Notes:

- A. De-phrase carefully here
- B. Scrape the shell-core insert carefully to ensure a good fit.



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

Signature or Inspection Stamp _____ Qty: _____ Date: _____ Comments: _____

Dressing / Cleaning (1 days)

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

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 granar afuera de "BOSS". Necesitas calidad por codigo de calor.

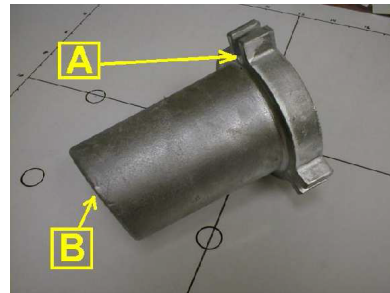
Signature or Inspection Stamp _____ Qty: _____ Date: _____ Comments: _____

Inspection (1 days)

Note safety requirements
Must wear protective clothing and mask

Notes:

- A. Check filling at root
- B. Check for damage



Check for fake size and dispersion



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

Signature or Inspection Stamp _____ Qty: _____ Date: _____ Comments: _____

Shipping (2 days)

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

Signature or Inspection Stamp _____ Qty: _____ Date: _____ Comments: _____

