

JOB CARD

Job No: JB/478/6 Product: 230361 Cust. Ref: 9855/2 Quantity: 350 Required: 19/09/2011	Issue: Rev # Card Date: Customer: A004 Astral Products Ltd	Description: Orifice Inverter	Other Production Information:	Packaging: Standard Box Labels: No Order Notes:
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Notes:

1 Shell Core Notes: Example of product with 'tracked' coremake stage. Book/count items thro' coremaking See 1794-0000 for complex cored example Quality Notes: If only 'technical details' of coremaking and no book/count stage needed for cores see Part Nnumber 140162

 Shell Core
 Specific
 Spare

 Process Complete: Signed: _____ Date: _____ Comments: _____

2 Squeezer Notes: Tracking / Work Booking enabled at Coremake as well as Mould/Cast stage, then subsequent stages if required. Quality Notes: 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.

 Process Complete: Signed: _____ Date: _____ Comments: _____

3 Dressing / Cleaning Notes: Casting is fragile and requires care in handling Take care with thin web area near ingate. Quality Notes: 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.

 Process Complete: Signed: _____ Date: _____ Comments: _____

4 Inspection Notes: Note safety requirements Must wear protective clothing and mask Quality Notes: 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

 Process Complete: Signed: _____ Date: _____ Comments: _____

5 Shipping Notes: Shrink wrap with heavy gauge PVC sheet when castings are on pallet. Maximum 15 castings per pallet. Quality Notes:

 Process Complete: Signed: _____ Date: _____ Comments: _____

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