

6. Have draw furnace at prescribed temperature with exhaust collar down. After drain, put load in draw furnace. Record time load is put into furnace, and time furnace comes to heat. Check times carefully as cutting or lengthening times may ruin the barrels.
7. After load has been in furnace ten minutes, raise exhaust to prevent heat being drawn from furnace. Collar is left down only to remove oil fumes.
8. When draw time is up, remove load from furnace and air-cool in racks. After cooling, load barrels into a hand truck.
9. The time and temperature for hardening and drawing will be supplied to the Heat Treat foreman by the Control Laboratory. It is the responsibility of the Heat Treat foreman to transmit this information to the operators.
10. The operator will keep accurate records of load number, heat number, amount in load, time load is put into furnace, times up to heat, time out of furnace, temperature and furnace numbers. 83
11. The operator will attach a slip to each load with the following information: heat number, load number, hardening furnace number, draw furnace number, temperatures, operator's number, and a space for test results.
12. In regular production lots of Barrels, Chem. & Met. will grind flats on four barrels from each load picked at random. Flats should be approx. 2-1/2 x 3/8" at the end of the barrels.
13. After flats have been ground on barrels, Chem. & Met. will take two Brinell readings on each of the flattened Barrels and record the results in a notebook furnished for this purpose.
14. The Laboratory will take the hardest and softest Barrel recorded for one day's production on any given model for physical testing.
15. Upon completion of testing, the Laboratory will stamp the routing ticket with a special "Released" stamp if test results are satisfactory. NO BARRELS ARE TO BE RELEASED TO THE NEXT PRODUCTION OPERATION WHICH DO NOT BEAR THE "RELEASED" STAMP.

Operator's Note:

Occasionally racks may stick in furnace, gas supply may fail, or it may be necessary to take two loads out of the furnaces at the same time. Whenever such an irregularity occurs, the foreman should be notified; he will note the irregularity on the recorder chart and hold the load separate for special laboratory testing.