

Printed on:
~AUTODATE

Description

WASH, MICROCARB HARDEN, QUENCH AND WASH

Process

Material: S-1010

Furnace: Micro Carb

Rack: Std. 12"x11"x2" medium mesh basket

Maximum Load: 1500 per basket, Layered evenly.

2 baskets max. per load. 3000 pcs per load max.

Wash: If Needed Wash. Parts are to be clean, free of cutting fluid, and dry.

Process: Washer Cycle

Wash 2 Minutes with Aqua Pre Cleaner (Wash 100-300/Vol or Equiv) @ 160 - 200 Deg F.

Rinse 10 seconds with Rust Inhibitor (Washed 100-4-60/Vol or Equiv) @ 160 - 200 Deg F.

Air Blow Off 1 Minute.

Temperature: 1600 deg. F

Soak Time: 1 hr. at temp.

Carbon #: 0.75%

Quench: Oil Beacon K-9 or equivalent. Temp. 130 - 180 degrees F

Time: 5 minutes minimum.

Wash: Parts are to be clean, free of quench oil, and dry.

Process: Washer Cycle

Wash 2 Minutes with Aqua Pre Cleaner (Wash 100-300/Vol or Equiv) @ 160 - 200 Deg F.

Rinse 10 seconds with Rust Inhibitor (Washed 100-4-60/Vol or Equiv) @ 160 - 200 Deg F.

Air Blow Off 1 Minute.

Notes: Parts should be clean for temper operation.

Run Shim Stock with each load for Met Chem Inspection.

Inspect: File Hardness

Inspection

Appearance of Parts: Clean And Free of Oil