The code of artificial heat aging process

According to the characteristics of heat aging process rules and my company casting high precision, making the operation procedures
1 prescription preparation work before
A) castings shall be cleaned before aging, there shall be no debris
B), check each part of body of furnace flue duct, gate, trolley, blower, drag mechanism is normal.
C) thermocouple meter calibration of all measuring points, so that it is in normal working condition.
According to the characteristics of D) casting ready pad iron, tooling
2 charging
A) each installed furnace should strive to casting thickness, complicated structure coefficient is close to, in order to facilitate the selection of appropriate processing parameters.
B) should grasp the big pressure is small, heavy pressure light principle.
C) casting emission and support
1 casting emissions should be conducive to the uniform heating and furnace gas circulation.
2 key parts, key aspects should not put the castings, such as bed rail surface
3 in order to prevent the workpiece deformation caused by self weight, add new stress, maximum offset is not greater than the pad iron castings of maximum width 1/3, layer when installed under the pad iron shall not stagger
4 casting from car surface not less than 100mm, from the top of not less than 400mm, the casting layer spacing of not less than 50mm, and the adjacent casting spacing of not less than 100mm, the casting from Taiwan door not less than 200mm
5 casting in the iron pad to stably placed neatly, not high, not ultra wide
6 qualified inspection personnel inspection, inspection trolley enters the furnace started Taiwan sand car seal after normal furnace; furnace wall alignment, gap of asbestos or mud Yan
The 7 heating, insulation, cooling
A) heating, insulation, cooling process of axis as shown above
B) casting into the furnace temperature not exceeding 200 degrees, the heating speed of not more than 100 DEG C / hour, if the workbench, body shell and other chores for long time, heating rate should be less than 60 DEG C / h, in the heating process of three measuring points should be less than 100 DEG C temperature difference
C) insulation: insulation time is 5 hours, such as the loading amount, should be appropriate to extend the time of high insulation, the insulation in the process of the three temperature measuring point temperature should be controlled within 60 DEG
D) cooling, general temperature should be controlled at 70 degrees / hour below, if the control at 50 DEG / h the following cooling chores less. Below 200 c can be released
E) in order to facilitate the examination analysis, shall truthfully fill in the furnace heat aging process record, and record the paper together make inspection personnel to save for future reference