

Sangkaj Engineering Pvt. Ltd

WORK INSTRUCTION FOR MATERIAL CHANGE OVER MECHANISM

FORMAT NO:- SEPL /HT/WI/10

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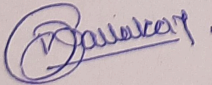
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1 At First Inspect the Received Material Visually If Found OK, Accept it else And Then Check Material with the Heat Treatment Identification Grade (e.g.:-8.8, 10.9, 12.9 etc).

2 If Material Heat Treatment Grade Is Similar But Part In Different Form Then Give The Gap Between Two Parts Is Minimum 10 Min.e.g:-Socket Bolt M8x1.25x27 (Hardening Grade 8.8) Is Running And Then We Have Load Hex Bolt M10x1.25x35 (Hardening Grade 8.8) Then We Have Loading Gap Between Two Parts Minimum 10 Min.

3 If Material Heat Treatment Grade Is Different, Loading Material Is Change From Hardening Grade 8.8 To 10.9 Then We Have Loading Gap Between Two Parts Is Min 30 Min.e.g. Socket Bolt M8x1.25x27 (Hardening Grade 8.8) Is Running And Then We Have Load Hex Bolt M12x1.5x35 (Hardening Grade 10.9) Then We Have Loading Gap Is 30 Min.

Prepared By:-



Approved By:-

