

SUBJECT TREATMENT OF CHROME IRON CONES

SUPERSEDED DATE

Treatments to which 26-30% chrome iron (C39D) parts are subject to during drawing and other manufacturing operations are given herein and series of standard treatments, when available for such parts, will be included herein.

1. TREATMENT OF CHROME IRON CONES DURING MECHANICAL WORKING.

a. Lubrication of Metal During Working.

Only those approved lubricants found in Stdzg. Not. 34-29-1 (34-29-1A) shall be used.

b. Cleaning of Parts Before Annealing.

Use cleaning schedule W616 (Stdzg. Not. 34-1-1W, p. 603) for all lubricants.

c. Annealing Parts for Mechanical Working.

Parts shall be annealed at 815° - 900°C. (time depends upon thickness of metal) and cooled as rapidly as possible.

2. SPECIFICATIONS FOR COMPLETED PART

a. Surface and Finish.

Cone finish shall be equivalent to a hot rolled, annealed, and pickled finish which shall be free from scale, seams, slivers, folds, blisters, and cracks. Cones shall be supplied in a completely degreased condition.

STANDARDIZING SECTION
ENGINEERING DEPT.