

voestalpine Thermo-Tech – A Division of
voestalpine High Performance Metals Ltd.

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HEAT TREAT REQUISITION

F-7-2-1

Form Released Date:
Oct. 10, 2009

Form Revision #006 Date:
August 27, 2019

Company Name:

Date:

PO#:

Part #:

Job#:

Quantity:

Weight:

Material:

HEAT TREAT REQUIREMENT BY APPLICATION:

DIE-CASTING

COLD WORK

PLASTICS

ANNEALING:

HARDENING:

HARDNESS REQUIRED:

min

max

OF TEMPER: 2

3

STRESS RELIEVE:

STRESS TEMPER:

CRYOGENICS:

VACUUM TEMPERING REQUIRED: Yes

NO

THERMONITE ; Total Case Depth: 0.002"-0.004"

0.004"-0.006"

0.006"-0.010"

THERMONITE II :

THERMOX :

DIE CASTING;

Was stress relieving performed (prior to semi-finish machining)?

YES NO

What is the machining allowance per side?

Was EDM performed prior to hardening?

YES NO

If so, was recast layer completely removed?

YES NO

Was any welding performed prior to hardening?

YES NO

If so, do you want Thermo-Tech to Re-Anneal the Tool? YES NO

Is EDM planned after heat treatment?

YES NO

If so, which EDM process?

SINK WIRE

Do you plan any subsequent coating operations?

YES NO

OTHER PROCESS/INSTRUCTION REQUIRED:

ITEM	DESCRIPTION	DETAIL #	I.D./ SN #	HEAT #	WEIGHT Lbs.	STEEL P.O.	No. of COUPONS ATTACHED		MICRO-STRUCTURE REQUIRED		THERMOCOUPLE HOLE PROVIDED		Hardness HRC
							0, 1, 2, 3		YES	NO	SURFACE	CORE	
#1													
#2													
#3													

CERTIFICATE REQUIRED: Yes

NO

HEAT CHART REQUIRED:

Yes

NO

Contact name:

Phone:

Email:

AS9100-D / ISO 9001 CERTIFIED

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ONE STEP AHEAD.