

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 #07
Date: April 26, 2021

Company Name:

PO#:

Quantity:

Part #:

Weight:

Date:

Job#:

Material:

HEAT TREAT REQUIREMENT BY APPLICATION:

DIE-CASTING

COLD WORK

PLASTICS

ANNEALING:

STRESS RELIEVE:

VAC HARDENING:

ATMOSPHERE TEMPER: 2 3

HARDNESS REQUIRED:

min max

VAC TEMPER REQUIRED:

CRYOGENICS REQUIRED:

FINAL STRESS TEMPER:

SOLUTION ANNEAL:

AGE in: ATM or VAC

HARDNESS REQUIRED:

DIE CASTING;

1-Was stress relieving performed (prior to semi-finish machining)? YES NO

2-Was EDM performed prior to hardening? YES NO

If YES, EDM layer must be completely removed or there is risk of cracking

3-Was any welding performed prior to hardening? YES NO

If YES, tool must be annealed prior to hardening or there is a risk of cracking

4- Tool free of any Plug or Foreign object? YES NO

SURFACE TREATMENT:

THERMONITE (GN) Total Case Depth: 0.002"-0.004"

0.004"-0.006"

Max (0.006"-0.010")

Special Instruction:

THERMONITE II (Thermonite+ Steam Oxide);

Subsequent coating operations? YES Coating

SPECIFICATION /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

voestalpine
ONE STEP AHEAD.