

QWISE-FM-HPZDS-2019

Company Standard

Hunan WISE New Material Technology Co., Ltd.

Powder sub-factory

Powder product batch process

Operating instructions

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Powder sub-factory Operating instructions

Batch

1 Main raw and auxiliary materials

1.1 Main raw materials: various carbides.

1.2 Main auxiliary materials: metal powder (such as cobalt powder, nickel powder)

2 Major equipment and tools

2.1 Main equipment: $\phi 900$, $\phi 1200$, $\phi 1800$ double conical mixer, V-type mixer.

2.2 Main tools: 500kg platform scale, 1000kg platform scale, stainless steel insert barrel and packaging barrel.

3 job quality requirements

The ingredients of the batch powder are uniform and uniform, visually free of impurities, and passed the screening test.

4 steps and essentials

4.1 Retrieve the batch notice from the production group. Open the exhaust and lighting, and operate according to the operation and maintenance procedures of the equipment.

4.2 Find materials by batch notification. The material must be accurate and accurate. At the same time, pay attention to the grade, category and batch number. You must not misplace the wrong card. If you have any questions, you must promptly reflect it.

4.3 Installed

4.3.1 Open the cover and place the funnel.

4.3.2 After batch-by-batch verification, the material shall be lifted one by one, placed on the funnel, and the inserting board shall be taken out, and the material shall be thrown into the machine, and the material shall be cleaned as much as possible.

4.3.3 Lift the bucket and return the empty bucket to the ball mill through the sieve room for sorting.

4.3.4 After lifting the single batch of materials, remove the funnel, cover the cover, press it tightly, close the fence, and pull out the locked dumping rod.

4.4 Mixing The batch process system is issued by the process technician.

4.4.1 Press "Startup Program" to start the machine. Write down the downtime.

4.4.2 Fill in the original record and material card.

4.5 Discharge.

4.5.1 Prepare the packing drum and the residual material in the barrel must be cleaned.

4.5.2 After reaching the mixing process time, stop the machine according to the “stop procedure” of the equipment and record the downtime.

4.5.3 Slowly open the discharge opening, discharge the material one by one, and prevent the material from being sprayed out of the barrel. After unloading, hit the casing with a wooden hammer, so that all the residual materials of the wind are discharged, and the discharge port is cleaned.

4.5.4 Overweight, must be accurate.

4.5.5 Fill in the material card weight and put the card checkmark into the bucket surface.

4.5.6 Transfer the materials into the warehouse, arrange them neatly and cover them as required.

4.5.7 Fill in the original record.

4.6 Class inspection.

4.6.1 Is the machine normal?

4.6.2 Whether the machine is missing material.

4.7 Fill in the work record of this class, pack the record book, bind the batch notice and single batch of WC powder card and collect it. The site will be cleaned and the work will be completed.

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