

Procedure: High Pressure Casting Weighing

Purpose

To outline the process of weighing high pressure diecast anodes.

Procedure

WEIGHING

- Before you begin casting with the high-pressure machine, write down the number on the counter attached to the machine. Write it down in the heat log for the day. At the end of the day, please write down the count in the heat log. This is done to see an average quantity cast per day, so we know roughly how many days casting we will need to do per anode type.
- Cast anodes to fall behind high-pressure casting machine.
- Once the anodes have cooled, anodes to be placed into one of our crane ready drums or buckets if no half drums are available. Once the drum is full. Using the crane to lift the bin just off the ground. Move to quarantined area see attached floor plan to show quarantined area. Quarantined area to be clearly marked with line paint. If using buckets use a trolley to move to the quarantined area.
- Place drum/bucket on the table. If lifting by hand, please be mindful of how much weight you are lifting. If it is too heavy (Over 25kg) ask someone else to help.
- Use the high-pressure casting scales. You will also need a small empty bucket with a tare weight.
- Begin by weighing the castings individually to insure they are in the correct range. -5% from catalogue weight, ie CDZ9-004 has a catalogue weight of 70g. If the casting is under 66.5g then it is considered a reject and should be remelted. If you are getting more than 10-15 anodes per small white bucket, please let your Manager know. DO NOT put high pressure castings back into a hot (molten) furnace unless you are wearing the correct PPE.

COUNTING

- First, see Factory Manager to see if we need to bag the anodes (Bags of 50) or bulk half drums.
- Once you have a bucket of checked anodes, we need to know how many there are. There are two ways to do this depending on if you are going to bag them or leave them loose.
- If you are going to bag them you will need to set up the scales to count.

BAGGING

- First zero the scales by pressing the zero key. Then place a small container on the scales and press the Tare key.
- Place a known quantity (10 or 20 ect) on the scales. When the scales are stable enter the quantity using the keypad and then press the SMPL key. This will now show a running tally of anodes. Please note if you haven't weighed the anodes correctly you will not get an accurate count.
- When the count reaches the desired number you can place them in poly-bags with the Part number and qty written on the bag.

BULK STORAGE

- If bulk storage the anodes begin by getting a total weight of the bucket with anodes (Gross weight) minus the empty bucket weight and then divide by the average anode weight, ie if the bucket full with anodes weighs 25kg 25000g minus the bucket weight ie 600 g divided by the average anode weight ie 70g
- $25000-600g=24400$ $24400/70=348.5$ (you will get a number, round down to the closest whole number, ie 348.
- Once finished weighing/counting please write down the quantity of anodes weighed and part number. Ask Stores or Sales staff to do a stock adjustment, once done the anodes can be put into their designated area or into buckets in the Stores area pallet racking. Please see floor plan for location of anodes.

END OF DOCUMENT

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