


ISS. LEVEL: 01	ISSUE DATE: 25 June 2018	SUPERSEDES: None	AUTH 
DOC REF: AEU01020	TITLE: WORK INSTRUCTION – STANDARD HEAT TREATMENT TOLERANCES		

1 Purpose

To define the standard tolerances to be applied for the heat treatment process used to stress relieve product manufactured by Advanex Europe.

2 Scope

The tolerances defined within this document are to be applied to any specified heat treatment where no tolerances are stated.

3 Terms and Definitions

None

4 Procedure –

All heat treatment process' are subject to a tolerance on the temperature. Where a single temperature is stated a standard tolerance of $\pm 5\%$ will apply unless otherwise stated on the appropriate works order or drawing.

Where a temperature range is stated these figures will be considered as minimum and maximum temperatures.

In cases where an Operator believes that to manufacture parts correctly temperatures outside of these parameters are required, the Operator must obtain authority from the Technical Department to proceed. The technician will sign the work instruction document to signify acceptance

The table below shows a number of common examples for the tolerances applied in single temperature cases.


$\pm 5\%$ TOLERANCE EXAMPLES.			
Temp °C	Tolerance in °C	Min Temp °C	Max Temp °C
160	± 8	152	168
210	± 10.5	199.5	220.5
230	± 11.5	218.5	241.5
270	± 13.5	256.5	283.5
350	± 17.5	332.5	367.5
430	± 21.5	408.5	451.5
470	± 23.5	446.5	493.5
530	± 26.5	503.5	556.5
830	± 41.5	788.5	871.5

5 Health & Safety / Environmental

Within the factory area safety footwear is mandatory.
Within the factory area Safety glasses must be worn.

6 Associated Documents

Works order Instruction

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