

ROUTING –PROCESS DESIGN FOR 1050-O-1.5mm Circles – M/s Savio India Ltd

1.0 Purpose

To set up a process route practice of 1050/O to meet the quality requirements of circles for M/s Savio India ltd.

2.0 Scope

Supply of Aluminium coil/sheet as per below specification

AA1050 / 'O' / 1.50 mm X 350 / 400 mm Dia

3.0 Responsibility & Authority

Managers/Section-in-Charge of the departments using this process are responsible for implementing this procedure.

4.0 PPEs

1. Safety helmet
2. Safety shoes
3. Gloves (if required)

5.0 Process Method

- Caster coil is to be selected from standard internal cast coil composition.

Chemical Compositions Limit-Internal


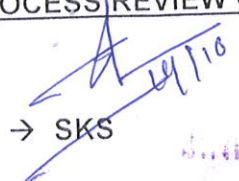
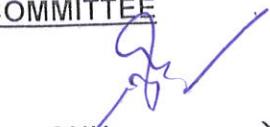

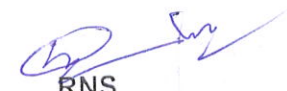
| Alloy | Si | Fe | Cu | Mn | Mg | Cr | Zn | Ti | Al |
|--------|--------|----------|----------|----------|----------|----------|----------|------------|-----------|
| AA1050 | 0.2max | 0.35 max | 0.01 max | 0.01 max | 0.01 max | 0.01 max | 0.01 max | 0.020-0.03 | 99.50 min |

- Process route for AA1050 / O is followed – For 1.5 mm
(UTS to achieve 55-95 MPa, Elongation Min 29%)

CAST COIL => CRM => 4.5 mm => HOMO => CRM => FG (1.5 mm) => CTL => Circle Punching => Circle Annealing => Packing

*HOMO, Circle Annealing cycle: As per SOP

APPROVED BY, PROCESS REVIEW COMMITTEE

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