



THERMTECH

DIECAST WORK ORDER SHEET

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CUSTOMER SERVICE: csr@thermtech.net

SHIPPING: shipping@thermtech.net

QUOTES: sales@thermtech.net

REQUESTED DATE: _____

CUSTOMER NAME _____ CUSTOMER P.O. NUMBER _____

REQUESTED BY _____ PHONE # _____ DATE _____ THERM-TECH QUOTE # _____

DO YOU WANT US TO CALL THE PROVIDED NUMBER UP UNTIL 6PM TO ENSURE THE JOB DOES NOT GO ON HOLD IN CASE OF MISSING INFORMATION? Y / N

INSTRUCTIONS: PLEASE USE 1 SHEET PER ALLOY. IF USING THE SAME ALLOY BUT DIFFERENT HARDNESS REQUIREMENTS, THEN USE A SEPARATE SHEET FOR EACH.

CONTAINER DESCRIPTION _____ NUMBER _____

QTY	PART #	DESCRIPTION	HARDNESS	JOB NUMBER	UNIT WEIGHT	TOTAL WEIGHT

WELDED - DOES NOT REQUIRE ANNEALING

WELDED - PLEASE ANNEAL FIRST

HOTWORK TOOL STEELS

TRADE NAME	GRADE	TRADE NAME	GRADE
<input type="checkbox"/> H-13 (NOT NADCA)	-	<input type="checkbox"/> THERMODUR 2367	C
<input type="checkbox"/> H-13 PREMIUM	A	<input type="checkbox"/> DH-31 EX	C
<input type="checkbox"/> H-13 SUPERIOR	B	<input type="checkbox"/> W-300	D
<input type="checkbox"/> DIEVAR	C	<input type="checkbox"/> W400	E
<input type="checkbox"/> DAC MAGIC	C	<input type="checkbox"/> TQ1	E
<input type="checkbox"/> W403 VMR	C	<input type="checkbox"/> ADC3	E
<input type="checkbox"/> EXELL HOT DIE	C	<input type="checkbox"/> W350	E
<input type="checkbox"/> RPU	C	<input type="checkbox"/> TUF DIE	E
<input type="checkbox"/> OTHER			

PROCESS SPEC REQUIREMENTS

<input type="checkbox"/> NADCA #207 CLASS 1 (IMPACT TOUGHNESS TESTING REQUIREMENT)
<input type="checkbox"/> NADCA #207 CLASS 2 (NO IMPACT TESTING)
<input type="checkbox"/> NADCA #207 CLASS 2 (FOLLOW NADCA RECIPE BUT DO NOT SUPPLY CERTIFICATION OR CHARTS)
<input type="checkbox"/> FORD AMTD-DC2010
<input type="checkbox"/> GM AWG49658
<input type="checkbox"/> THERM-TECH STANDARD PROCESSING
<input type="checkbox"/> THERM-TECH STANDARD PROCESSING WITH CERTIFICATION AND CHARTS

IMPACT BLOCK PROCESSING

Y / N **DO YOU WANT THERMTECH TO KNOCK THE IMPACT BLOCK OFF OF YOUR DIE AFTER THE FIRST TEMPER TO 44-46 HRC REGARDLESS OF THE HARDNESS WE WILL HEAT TREAT YOUR DIE TO IAW NADCA REQUIREMENTS.**

*IF YOU DO NOT CIRCLE YES WE WILL NOT DO THIS. THERMTECH DOES NOT WARRANTY ANY DAMAGE TO THE DIE THIS MIGHT CAUSE DO TO MATERIAL BEING RIPPED OFF FROM THE DIE DURING THE REMOVAL PROCESS.

HARDENING INSTRUCTIONS

- Y / N VACUUM ANNEAL FIRST
*IF YOU DO NOT ANNEAL WELDED MATERIAL FIRST AND THE PART CRACKS AS A RESULT, THERMTECH WILL NOT WARRANTY.
- Y / N STRESS RELIEVE FIRST
- Y / N VACUUM HARDEN AND DOUBLE TEMPER (IF YOUR DIE IS OVER 5" WE WILL AUTOMATICALLY TRIPLE TEMPER)
- Y / N VACUUM HARDEN AND TRIPLE TEMPER
- Y / N FAST QUENCH TO OPTIMIZE PROPERTIES (10 BAR MIN) (IF YOU DO NOT SELECT THIS WE WILL ENSURE SPEC REQUIREMENT AND TARGET A QUENCH RATE OF 70-80F/ MIN)
*IF THE DIE IS TO BE COATED OR WIRE EDM'D AFTER THEN THERE MUST BE THREE TEMPERS

POST HARDENING PROCESSING

<input type="checkbox"/> FINAL STRESS TEMPER @ _____ F
<input type="checkbox"/> SHOT BLAST CLEAN WITH 110 STEEL SHOT
<input type="checkbox"/> RUST INHIBIT

CUSTOMER PICK UP

THERM-TECH TRUCK

UPS

CALL

COMMENTS/SPECIAL INSTRUCTIONS OR SHIP TO ADDRESS:

RECEIVED BY: _____

STATEMENT OF LIABILITY

ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS:

(Adopted by the Metal Treating Institute)

It is generally recognized that even after employing all the science known to us and capable men with years of training, there still remain hazards in heat treating. Therefore, our liability to our customers shall not exceed twice the amount of our charges for the work done on any material, (first to reimburse for the charges and second to compensate in the amount of the charges), except by written agreement. Warranty will be assumed by us only when made in writing and signed by both you and us. In such event a higher charge will be made for our services. No claims for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by written agreement, as above, nor in any case for rupture caused by subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of materials (i.e. make, brand, and grade of steel) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling, or any other work has been done on said material. No agent or representative is authorized to alter these rules and conditions, except by writing duly approved by us.