

CARLTON FORGE WORKS

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CODE	SUBJECT	REVISION DATE:
28	FORGINGS MANUFACTURED BY ARCTURUS MFG.	02/22/05
REVISIONS: 02/22/05 – Added QWI 16-4. 08/25/03 – Edited Note C.3, removed “and the serial numbers applicable”. Added D, E.		

QWI 16-4: “FORGING OPERATIONS AT ARCTURUS MANUFACTURING COMPANY” APPLIES FOR ALL FORGINGS MANUFACTURED AT ARCTURUS ON CARLTON FORGE WORKS PURCHASE ORDERS.

- A. FORGE LOT:** A forge lot is considered to be "all pieces produced under the same process sheet parameters, using the same or equivalent furnaces and the same family of forging equipment, (i.e. press, hammer, dies, etc.) without interruption in any of the thermal operations."
- B. PROCESSING:** All forgings to be manufactured per approved Arcturus Workmaster unless authorized otherwise, in writing, by Carlton Forge Works.
- C. CERTIFICATIONS:**
1. Arcturus shall certify quantity and serial number of forgings manufactured to the Arcturus Workmaster.
 2. Arcturus shall note any deviations or split lot conditions on the Certification.
 3. In addition to the Certification, Arcturus shall supply copies of Process Controller Records, Summary of Heats used by Serial Number, and loading diagrams.
- D. FORGING LOT (GE):**
All pieces of the same part number, made under the same process sheet, using the same or equivalent furnaces and forging set-ups (equipment/dies/control), without abnormal interruptions in any forging operations.
- A. The process sheet shall define all times that are considered relevant.
 - B. During operations that generate final part mechanical properties, different forging set-ups may be considered equivalent only for flat die processes.
 - C. Examples of normal process interruptions are those that do not require breaking down or repair of the forging set-ups, do not violate established heating/cooling cycles. The GEAE quality representative is to be contacted for clarification of whether other process interruptions are considered abnormal.
 - D. Maximum forge lot size is limited to the shop order quantity.
- E. FORGING LOT (HONEYWELL):**
One hundred forgings or fewer of the same part number, produced consecutively to the final configuration, from a single master heat, utilizing the same forging procedure, die setup, and equipment.