

# PERMACO CASTING ROUTING

M- \_\_\_\_\_  
 MATERIAL \_\_\_\_\_  
 MADE INTO \_\_\_\_\_

SHOP ORDER NO. \_\_\_\_\_  
 DATE POURED \_\_\_\_\_  
 HEAT NO. \_\_\_\_\_

## MOLDING INFORMATION

PATTERN LOCATION _____	TYPE OF MOLD _____	WT. OF MOLD _____
CORE PATTERN LOCATION _____	TYPE OF CORE _____	WT. OF CORE _____
MOLDS / HEAT _____	CORES / HEAT _____	CARBON-CORES / HEAT _____
TOPS / HEAT _____	TOP SIZE _____	WT. OF TOPS _____
BOTTOMS / HEAT _____	BOTTOMS SIZE _____	WT. OF HEAT _____
ROD BOTTOMS / HEAT _____	STACK / HEAT _____	WT. OF BOTTOMS _____
MOLDS / STACK _____	PARTS / CORE _____	QTY. / HEAT _____
DIAMETER OF CARBON _____	LENGTH OF CARBON _____	QTY. CARBON / MOLD _____
INSERT PART NO. _____	INSERTS / MOLD _____	INSERTS / HEAT _____
MOLD CURING CYCLE _____	MOLD GASSING TIME _____	MOLD PURGING TIME _____
CORE CURING TIME _____	CORE GASSING TIME _____	CORE PURGING TIME _____

**STACKING INSTRUCTIONS:** \_\_\_\_\_

\_\_\_\_\_

## POURING INFORMATION

**MELTING PROCEDURE NO.** \_\_\_\_\_ **POURING TEMPERATURE.** \_\_\_\_\_

**SPECIAL POURING INSTRUCTIONS:** \_\_\_\_\_

\_\_\_\_\_

**SHAKEOUT INSTRUCTIONS:** \_\_\_\_\_

\_\_\_\_\_

**SHOTBLAST INSTRUCTIONS:** \_\_\_\_\_

\_\_\_\_\_

**SNAG GRIND INSTRUCTIONS:** \_\_\_\_\_

\_\_\_\_\_

**PREGRIND INSTRUCTIONS:** \_\_\_\_\_

\_\_\_\_\_

**DIRECTION OF ORIENTATION** \_\_\_\_\_

**HEAT TREAT INSTRUCTIONS:** \_\_\_\_\_

\_\_\_\_\_

OPERATION	QTY.	REMARKS	OPERATOR	DATE	APPROVED BY