



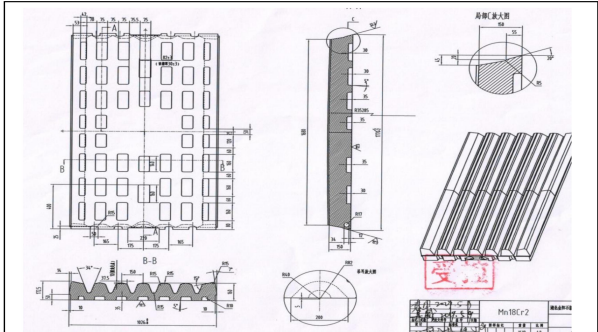
Crusher Jaw Plates

Quality Control Reports

An example of the quality control system of Qiming Casting's crusher jaw plate is the sandvik 442.0433 wear liner.

Size Report

QM-400.0433 Size Report



Part name	Jaw Plate	Part No	400.0433	Order number	51F0507	Check Date	2019.7.4	QA
Location	Drawing	Tolerance	Measured value	Qualified decision	recheck	WT	1618Kg	
1	1770		1773					
2	1026		1020-1024					
3	160		163					
4	82	±3	83					
5	165		163-165					
6	220		218-220					
7	400		400-402					
8	160		162-163					
9	150		150					
10	150		147-148					
11	20°		19°50'-20°8'					
12	30		32-33					
13	95		95-96					
14			≤0.5					
15								
16								

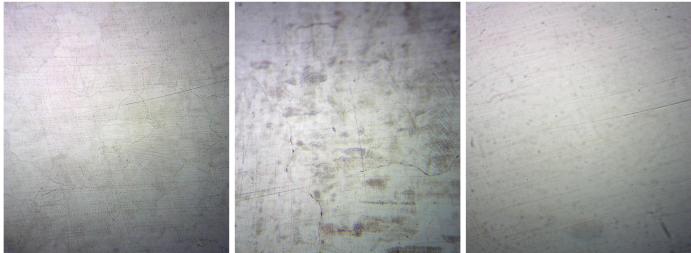
Size Report

Our engineers will draw the dimensions to be inspected on the drawing. After the product has been machined, quality control personnel will check that all dimensions to be inspected are within the tolerances allowed by the drawing. If these tolerances are exceeded, the product will be reworked. Parts with serious dimensional discrepancies must be scrapped.

Metallographic Analysis Report

QM-400.0433 Metallographic Analysis Report

Standard: GB/T 13925-2010 . GB/T 6394-2002 2019/6/15

Part Number	400.0433-02	Casting No.	51F0507	Position	Surface
Technology	Hydraulic Toughness	Date	2019.6.14	Furnace No.	G-182
				Magnetism	Low
Test Item	Undissolved Carbide	Precipitated Carbides	Superheated Carbide	Grain Size	Nonmetallic Inclusion
Test Result	W1	X2	No	2	1A
Standard	≥W3	≥X3	≥G2	±2	≥3
Judgment	OK	OK	OK	OK	OK
					
Result	OK				
Remark	Material: Mn18Cr2. 2019/6/5 cast, cast temperature 1419°C.				

Metallographic Analysis Report

After completing the heat treatment of the crusher jaw plates, our engineers have to check whether the metallographic organization of the liner reaches the standard, those item need check: •

Magnetism

- Undissolved Carbides
- Precipitated Carbides
- Superheated Carbides
- Grain Size
- Nonmetallic Inclusion

Chemical Composition Report

QM-400.0433 Chemical Composition Report

Part name	Jaw Plate	Heat No	SIF0501
Part No	400.0433-02-SIF0507S	Inspector	
Material	Mn18Cr2	审核 Section chief	

Chemical composition(%)

	C	Si	Mn	Cr	P	S
standard	1.18~1.25	0.3~0.6	17.8~19.5	1.8~2.1	≤0.04	≤0.025
practice	1.25	0.360	18.6	1.82	0.0368	0.0072

样品 : SIF0501 Mn18Cr2							
合金 : FE_000 模式 : PA 2019/6/5 23:54:11							
	Fe	C	Si	Mn	P	S	Cr
1	77.5	1.23	0.356	18.5	0.0373	0.0072	1.81
2	77.4	1.24	0.363	18.6	0.0363	0.0072	1.84
平均值	77.4	1.25	0.360	18.6	0.0368	0.0072	1.82
	Mo	Ni	Al	Co	Cu	Nb	Ti
1	0.0784	0.0450	0.0086	0.0131	0.0566	0.0240	0.0197
2	0.0803	0.0502	0.0079	0.0139	0.0558	0.0240	0.0193
平均值	0.0793	0.0476	0.0082	0.0135	0.0562	0.0240	0.0195
	V	W	Pb				
1	0.0429	0.166	0.0609				
2	0.0480	0.164	0.0677				
平均值	0.0455	0.165	0.0643				

合格

2019/7/9 08:59

Remark	ok
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Date:2019.7.9

Chemical Composition Report

The chemical composition test of the crusher jaw plates contains two aspects, one is the chemical composition test of the raw material before the furnace, to detect whether it meets the standards of the ingredients; the second is the chemical composition test after the casting, to detect whether all the chemical composition is up to standard, mainly manganese elements, carbon elements, chromium elements.