



Guideline of Preparation Cemented Carbide Mixing Powder(2)

4 steps and requirements

4.1 Health and Sanitation

4.1.1 Do wear good clothes, safety shoes, dust masks, rubber gloves and other protective clothing before entry the job site.

4.1.2 Check the crane is in good condition, operating handle without plastic wrap is not allowed. beat, hit is prohibited, wet milling room must use explosion-proof tools.

4.1.3 keep site clean after mixing the ingredients; no materials left on the floor or desktop, tools and instruments should be promptly cleaned after the run, keep the drums, industrial equipment neatly.

4.1.4 clean up the site after loading, unloading and distributing ingredients; clean equipment, keep floors (including ball mill area, dryer area, homogenizing machine area) no slurry, no water, no debris, no powder; tools and instruments should be cleaned after use, without residual slurry, ladders, platforms, racks should be kept clean, industrial equipment neatly.

4.1.5 keep the rest room clean and check the site before shift.

4.2 Ingredients

4.2.1 Check the electronic scales or balance is intact and zeroing.

4.2.2 according to " wet grinding process requirement" , select the right materials and the corresponding ingredients barrel, check each batch of raw materials and grades. Stir the special bucket and clean ingredients barrels and ingredients bucket.

Focus: Clean the bucket, shovel, rake, pan before mixing ingredients, revealing the true nature of each tool, inner wall, no residual material, especially cutting flapper at the bottom of the barrel to the ingredients carefully clean.

4.2.3 shut down the barrel, lift ingredient bucket by a crane on an electronic scale, weigh and record drums weight.

4.2.4 according to " wet grinding process requirements" , weigh WC, Cr₂C₂, Cr, Mo, carbon black, TaC and Co, Ni successively. Except Co, Ni load in keg, the remaining ingredients are loaded into the barrel. Management Focus: Weigh material over $\geq 1.0\text{kg}$ with electronic scales, said, material less than 1.0kg by balance, and electronic scales tolerance $\pm 0.1\text{kg}$, balance tolerance $\pm 1\text{g}$.

4.2.5 Each time after finishing an ingredient, check carefully before adding of a second approved raw material, weigh the total weight and after confirmation of technical supervisor, load the completed ingredients on the loader accompanying the "wet milling process requirement", cover the lid and pass to the next step. Operation is completed, fill in the " original ingredients " carefully.