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Heat treatment — Control of quality

Traitement thermique — Maîtrise de la qualité



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Contents

	Page
Foreword.....	v
Introduction.....	vi
1 Scope.....	1
2 Normative references.....	1
3 Terms and definitions.....	1
4 System for assessment and scoring of requirements and recommendations.....	3
4.1 General.....	3
4.2 General requirements.....	4
4.3 Scoring of requirements and recommendations.....	4
4.3.1 General.....	4
4.3.2 Scoring of requirements.....	4
4.3.3 Scoring of recommendations.....	4
4.4 Assessment of the heat treatment facility.....	5
5 Requirements and recommendations.....	6
5.1 General organisation of a heat treatment facility.....	6
5.1.1 Documentation (references G01 to G03).....	6
5.1.2 Management responsibility (references G04 and G05).....	6
5.1.3 Human resources management (references G06 to G010).....	7
5.1.4 Infrastructure and equipment management (references G011 to G025).....	7
5.1.5 Internal audit (reference G026 and G027).....	8
5.1.6 Control of nonconforming product (references G028 to G036).....	8
5.1.7 Continuous improvement (references G037 and G038).....	9
5.1.8 Failure mode, effect and criticality analysis (FMECA) (references G039 to G041).....	9
5.1.9 Monitoring plan (references G042 to G044).....	9
5.1.10 Preproduction quality planning (reference G045 and G046).....	9
5.1.11 Statistics: (references G047 to G049).....	9
5.1.12 Controlling monitoring and recording (references G050 to G062).....	10
5.2 Contract review and heat-treatment conception.....	11
5.2.1 Contract review.....	11
5.2.2 Heat-treatment conception.....	11
5.3 Carrying out heat treatments: preparation.....	11
5.3.1 General.....	11
5.3.2 Load preparation.....	12
5.4 Carrying out heat treatment: Control of the thermal cycle.....	13
5.4.1 Temperature drift and heat-treatment temperature error (references T1 to T10).....	13
5.4.2 Measuring equipment error SAT (system accuracy test) (references T11 to T17).....	15
5.4.3 Temperature uniformity survey (TUS) of furnace (references T18 to T31).....	17
5.4.4 Drift of the soak times of the various heat-treatment phases (references HTT1 to HTT2).....	20
5.5 Mastering of the heat-treatment medium.....	21
5.5.1 General.....	21
5.5.2 Control of carbon-containing atmosphere.....	21
5.5.3 Control of nitriding, nitrocarburising and derived heat-treatment atmospheres.....	22
5.5.4 Control of salt bath and drift of treatment medium.....	22
5.5.5 Control of operational conditions of surface hardening after induction superficial heating.....	22
5.5.6 Laser hardening (references L1 to L4).....	23
5.5.7 Vacuum or low-pressure heat treatment (references V1 to V7).....	24

5.6	Control of cooling	24
5.6.1	Equipment control and heat-treatment reproducibility (references CEQ1 to CEQ3)	24
5.6.2	Control of cooling parameters (references CPM1 to CPM12)	24
5.7	Control of product	25
5.7.1	Drift of testing means (references CP1 and CP2)	25
5.7.2	Non-conforming product (references CP3 to CP5)	25
5.8	Finishing process	25
Annex A (normative) Equipment calibration and frequency control		27
Annex B (informative) Example of scoring table for requirements and recommendations		29
Annex C (informative) Example of heat-treatment facility assessment		35
Annex D (normative) Measuring chain testing methods (SAT - system accuracy test)		36
Bibliography		41

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO document should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 244, *Industrial furnaces and associated processing equipment*.

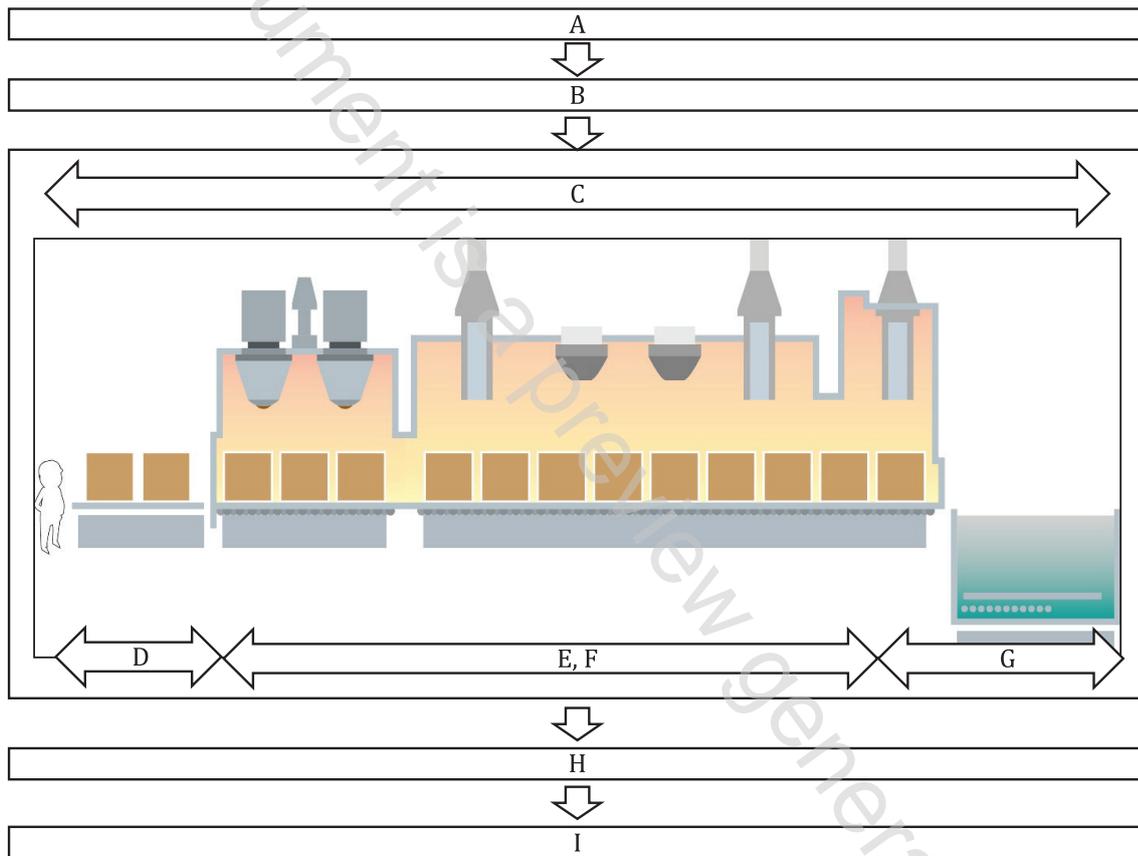
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Introduction

This document draws a list of best practices in order to ensure quality control in the application of heat treatment. This document is for use with equipment constructed in accordance with International Standards for thermoprocessing equipment. These concepts are also suitable for application with other heat-treatment processes.

This document is a reference for assessment and continuous improvement which is part of the quality management system of a heat-treatment facility.

Figure 1 shows the typical flowchart for a heat-treatment process. The main steps are subject to requirements and recommendations in this document.



Key

- | | | | |
|---|---|---|--|
| A | general organisation of a heat-treatment facility (see 5.1) | F | control of the heat-treatment medium (see 5.5) |
| B | contract review and heat-treatment conception (see 5.2) | G | control of cooling (see 5.6) |
| C | carrying out the heat treatment | H | control of product testing (see 5.7) |
| D | preparation (see 5.3) | I | finishing (see 5.8) |
| E | control of the thermal cycle (see 5.4) | | |

Figure 1 — Heat-treatment process

Heat treatment — Control of quality

1 Scope

This document defines the quality requirements and recommendations applicable to heat treatment on mechanical parts intended to be used in the industry (e.g. car manufacturing, aerospace, pipeline systems, civil engineering equipment, earth moving machinery, agricultural equipment, naval industry, energy equipment, tooling, fasteners).

This document provides a reference for quality audit and for the inspection of heat-treatment facilities, whether these are integrated or belonging to subprime contractors. This document can also be used as a basis for discussion and development of specifications.

A description of the equipment calibration and the frequency of the controls is given in [Annex A](#). An example of scoring table is given in [Annex B](#). An example of audit report is given in [Annex C](#). The different measuring chain testing methods (SAT) are presented in [Annex D](#).

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 4885, *Ferrous materials — Heat treatments — Vocabulary*

ISO 6506 (all parts), *Metallic materials — Brinell hardness test*

ISO 6507 (all parts), *Metallic materials — Vickers hardness test*

ISO 6508 (all parts), *Metallic materials — Rockwell hardness test*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 4885 and the following apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

3.1

heat-treatment facility

set of equipment implementing processes associated with each other used to modify, through a thermal cycle, the physical, mechanical and/or chemical properties of a metallic material

3.2

recommendation

preferred advice and criterion (criteria) providing guidance, but not required to be in accordance with this document