

Institute For Auto Parts and Hand Tools Technology, Ludhiana

Rate List of Institute Services

S. No.	Job Description	Charges (Rs.)	Remarks
Heat Treatment Services			
1.	Annealing, Normalizing and Tempering, M.S. Alloy Steel and other constructional / steels and sheet metal components.	9.20	Per Kg
2.	Carburizing and Air Cooling of M.S. & Alloy Steels		
	0.3 - 0.6 mm C.D. Oil Quenching	21.85	Per Kg
	0.7 - 0.9 mm C.D. Oil Quenching	24.15	Per Kg
	0.9 - 1.2 mm C.D. Oil Quenching	26.50	Per Kg
3.	Hardening & tempering up to 300 mm length		
	Up to Φ 12mm x 300mm length max. (in Rotary Furnace only)	11.50	Per Kg
	Up to Φ 12mm - 20 mm x 300mm length max.	15.00	Per Kg
	Up to Φ 12mm x (300 - 800 mm) length	16.10	Per Kg
	Up to Φ 20mm - 50mm x (300 - 800mm) length	18.40	Per Kg
4.	Hardening & Tempering of material (medium alloy steel)	18.40	Per Kg
5.	Hardening & Tempering of hand tools (Spanners, Wheel Spanners)	16.10	Per Kg
6.	Hardening and Tempering of long sheets and blades / extra-long jobs.	34.50	Per Kg
7.	Hardening & Tempering of High Carbon, High Chromium Dies, D3, EN-31, Tools and Gauges etc.	80.50	Per Kg
8.	Cryogenic Material Improvement Process	184	Per Kg
9.	Hardening & tempering in Continuous Furnace; Make San Yung Taiwan Plant (up to ϕ 20 x 250 mm with the assumption 300 kg / hr.)	16.10	Per Kg <ul style="list-style-type: none"> • Note: Extra Charges for complex configuration (shape & size). • Lot Min. charges Rs 12,000/- (Rs. Twelve thousand only).

Note:

1. Above Heat Treatment Rates are based on the assumption for a batch lot of 300 kg. in GCF.
2. In case of hardening to be done in carbon potential then Rs. 2/- will be charged extra over and above on the above-mentioned rates.
3. Complex configuration to be determined on the basis of shape, size, mass & material composition and shall be used for any extra charges of Heat Treatment.
4. Minimum billing charges for Heat Treatment process is Rs 300/- only (Rupees Three hundred only).
5. The customer who provides material lot of 20000 kg will be provided discount of rate for the material Hardening & tempering in Continuous Furnace; Make San Yung, Taiwan Plant.
6. Taxes as applicable.

