

Special Process: Heat Treat System Assessment			
Facility Name: ARNOLD UMFORMTECHNIK GmbH & Co. KG			
Address: Carl-Arnold-Straße 25, 74670 Forchtenberg-Ernstbach / Germany			
Phone Number: +49 7947 821-0		Fax Number: +49 7947 821-111	
Date of Assessment:	30.09.2024	Date of Previous Assessment:	30.09.2023
Internal (Captive) Heat Treater (Y/N):	Yes	Commercial Heat Treater (Y/N):	No
Type(s) of Thermal Processing at this Facility:			
Process Table A		Process Table D	
Carburizing (case hardening) in a continuous furnace under adjusted C-level (N2, methanol, propane) with oil bath quenching and connected tempering process in a continuous furnace under air	X	Induction Heat Treating	
Carbonitriding		Process Table E	
Carbon Restoration		Annealing	
Neutral Hardening (Quench and Temper) in a continuous furnace under adjusted C-level (N2, methanol, natural gas) with oil bath quenching and connected tempering process in a continuous furnace under air	X	Normalizing	
Austempering / Martempering		Stress-Relieving	
Tempering in a continuous furnace under air	X	Process Table F	
Precipitation Hardening / Aging		Low Pressure Processing (Carburizing / Carbonitriding / Neutral Hardening)	
Process Table B		Process Table G	
Nitriding (Gas)		Sinter Hardening	
Ferritic-Nitrocarburizing (Gas or Salt)		Process Table H	
Process Table C		Ion Nitriding	
Aluminum Heat Treatment		Process Table I	
		Hot Stamping	
Current Quality Certification(s): IATF 16949:2016 - ZR-Nr. 12 111 19637/01 TMS / IATF Z-Nr. 0482461 - valid until 2026-09-06 ISO 9001:2015 - valid until 2026-09-06			
Date of Re-assessment (if necessary):			
Personnel Contacted:			
Name:	Title:	Phone:	Email:
Sautner, Christian	Head of Heat Treatment	0049 7947-821-517	christian.sautner@arnold-fastening.com
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Auditors/Assessors:			
Name:	Company:	Phone:	Email:
Milde, Markus	m. milde consulting GmbH & Co.KG	0049 172-2022228	info@mmilde.com
Number of "Not Satisfactory" Findings: 0			
Number of "Needs Immediate Action" Findings: 0			
Number of "Fail" Findings in the Job Audit(s): 0			