Special Process: Heat Treat System Assessment

Facility Name: ARNOLD UMFORMTECHNIK GmbH & Co. KG			
Address: Plant Ernsbach: Carl-Arnold-Straße 25, 74670 Forchtenberg-Ernsbach / Germany			
Phone Number: +49 7947 821-0		Fax Number: +49 7947 821-111	
Date of Assessment:	30.09.2026	Date of Previous Assessment:	30.09.2025
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 19637/02 TMS / IATF Z-Nr. 0612748 - valid until 2029-08-26;
IATF 16949:2016 - ZR-Nr. 12 111 19637/01 TMS / IATF Z-Nr. 0612752 - valid until 2029-08-26;

Date of Re-assessment (if necessary):

Personnel Contacted:

Name:	**Title:**	**Phone:**	**Email:**
Sautner, Christian	Head of Heat Treatment		
Lindauer, Luka	Team Leader Hardening shop Ernsbach		
Kunkel, Gebhard	FMEA Moderator		

Auditors/Assessors:

Name:	**Company:**	**Phone:**	**Email:**
Schneider Denis	ARNOLD UMFORMTECHNIK GmbH & Co. KG		

Number of "Not Satisfactory" Findings: **0**

Number of "Needs Immediate Action" Findings: **0**

Number of "Fail" Findings in the Job Audit(s): **0**

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