		TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT			Production Order	Date	
Plant: P002	Equipment No:			101984498	14.07.2022		
Type	WBS Element	Customer / Project Name			Part No		
	P-1329900006-13901	RRVUNL RAMGARH			13901026		
Drawing No.-Var	E.Rev.	T.Rev	Material No.	Name Of The Part			
01390131116	01	00	01390131116-00	BOTTOM HALF OF BRG PEDESTAL MACHINING			
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks	MDCC
0002	2.000	2.000	EA	IS02	910.000	BOTTOM HALF OF BEARING PEDESTAL	NO

BOM Details


Pos.No	IC	Material Code	P.No	Remarks					
Matl.Spec	SPK	Qty	MU	Size 1	Size 2	Size 3	Formula Key	MPcs	St.
0001	L	01390130014-00	13901027						
AA19703		2.000	EA	0.000	0.000	0.000		0.000	IS04
Material Description : BOTTOM HALF OF BEARING PEDESTAL-M-20-338				Reservation :	Item : 0001	Picklist:			
				0014296125					

0002	L	AA7161002087	13901045						
AA7161002		2.000	EA	0.000	0.000	0.000		0.000	ST02
Material Description : WASHER MCD 17-BR				Reservation :	Item : 0002	Picklist:			
				0014296125					

Operation Details

Opr No	W.C.	Plant	Ctl. ky	Prep Time	Time/ PC(M)	Time/ PC(L)	Total Time	QC Signature
PRT Cat	PRT No.			PRT Description				
Sub Operation Text								
0030	CC4828	P002	ZP99	90.000	270.000	405.000	900.000	
BOTTOM HALF: Mill the bottom surface maintaining flange thickness 100. Reverse and mill the top surface to height 626. TOP HALF: Mill the contact surface smoothly maintaining flange thickness 50. Mill the top surface to height 370.								
0050	CB4652	P002	ZP99	40.000	300.000	300.000	640.000	
Place the top half of bottom half adjust as per profile and clamp together. Drill together 6 holes Ø26.5 for M30 middle 2 holes to depth 60 and 4 holes through 2 holes Ø25 for taper pin 25x140. Remove the top half. BOTTOM HALF: In the bottom half, chamfer and tap 6 holes M30. TOP HALF: Refer Drg 1 13901 30029/06. In top half enlarge 6 holes to Ø33 and and spot face Ø63. Spot face 2 taper pin holes Ø40. For eye bolt drill 2 holes Ø17.5 for M20 to depth 32. Chamfer and tap M20 to depth 32.								
0070	CG9528	P002	ZP99	40.000	0.000	730.000	1,500.000	
Scrape the contact surface of both halves. Assemble both halves with Pos 11 and 12. Ream 2 taper pin holes Ø25 and drive the Taper Pin Pos 14 with Nut and Washer Pos 16 & 17.								
0090	CC4232	P002	ZP99	80.000	710.000	710.000	1,500.000	
Centre the bearing pedastal as per marking and clamp on the table. Turn Ø555 straight to width 140. Face,turn Ø560 H7 and Ø650 to depth 10 and chamfer 1x45° on Ø560 H7 as per End view. Reverse, align and clamp. Face to width 460 and similarly turn the steps as per End View.								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	20.07.2022			AKM		1	3

 TECHNOLOGICAL PROCESS										Production Order	Date
Plant:P002		Equipment No:					101984498		14.07.2022		
Type		Work Order / PGMA			Customer				Part No		
		P-1329900006-13901/ 13901			RRVUNL RAMGARH				13901026		
Drawing No.-Var		E.Rev.	T.Rev.	Material No.		Name Of The Part					
01390131116		01	00	01390131116-00		BOTTOM HALF OF BRG PEDESTAL MACHINING					
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks					
0002	2.000	2.000	EA	IS02	910.000	BOTTOM HALF OF BEARING PEDESTAL					
Operation Details											
Opr No	W.C.	Plant	Ctl. ky	Prep Time	Time/ PC(M)	Time/ PC(L)	Total Time	QC Signature			
PRT Cat	PRT No.			PRT Description							
Sub Operation Text											
0091	CC4232	P002	ZP99	120.000	250.000	250.000	620.000				
Accurately align, exactly centre the fixture and turn the spherical Ø570 +0.05 / -0.00 to width 130. 20-61-2005 : Spherical turning fixture.											
0120	CG9421	P002	ZP99	15.000	0.000	30.000	75.000				
Dismantle both halves.											
0130	CC4828	P002	ZP99	120.000	450.000	675.000	1,470.000				
Keep both halves on rotary table. BOTTOM HALF: Face the oil outlet boss maintaining dimn 25 & 735 to C/L. Drill 8 holes Ø14 for M16 on PCD 190.5 depth 25, chamfer and tap M16 to depth 25. Face the oil inlet boss maintaining dimn 540. Drill oil inlet hole Ø36 to depth 210. Drill 4 holes Ø10.2 for M12 on PCD 98.4 to depth 35. Face the boss Ø100 maintaining dimn 515. On boss Ø100, drill 4 holes Ø6.8 for M8 on PCD 60 to depth 20 & chamfer as per End view. On other side face the rectangular boss 150x250 maintaining dimn 535 and drill 6 holes Ø6.8 for M8 to depth 20 and chamfer the holes. On both faces drill 6 holes Ø10.2 for M12 and 2 holes Ø11 for cyl pin Ø12 m6 on PCD:610 and chamfer the holes. Set for drilling inclined bole Ø32 at 45°. Drill 1 hole Ø32 to open into the horizontal hole Ø36. Set for drilling R1# thread holes as per Detail-X and View-R. Pre-drill and drill 2 holes Ø30.75 for R1# and spot face Ø70 to depth 2. Bore the recess 2.7x1.5 as per detail-X. Chamfer and tap R1# threads. Set for drilling M18x1 and Ø40 holes. Pre-drill & drill 1 hole Ø40 : counter bore Ø70, depth 10. Drill 4 holes Ø4.2 for M5 on PCD:55 to depth 15. Drill 1 hole Ø17 for M18x1 & spot face Ø40. Chamfer and tap M18x1. Set for milling the groove on parting plane, mill 2 grooves R5 maintaining dimn 160 and 210 at 45° on both ends as per plan and drill 6+6 holes Ø10 through as per elevation. In the bottom pre-drill and drill 4 holes Ø60 , couter bore Ø80 to depth 10 and spot face Ø115. Drill 2 taper pin holes Ø25 and spot face Ø40 as per plan. TOP HALF: 1. On both faces drill 6+6 holes Ø10.2 for M10 on PCD:610 and chamfer. 2. Drill 4 holes Ø22.8 for 3/4# NPT threads at 45°. Chamfer and tap 3/4# NPT threads.											
0150	CG9528	P002	ZP99	20.000	0.000	285.000	590.000				
Deburr the sharp edges on both halves. i. Tap 6 holes M8 to depth 20 on rectangular boss 150x250. ii. Tap 4 holes M5 on PCD:55.											

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	20.07.2022			AKM		2	3

		TECHNOLOGICAL PROCESS				Production Order	Date
Plant:P002		Equipment No:				101984498	14.07.2022
Type	Work Order / PGMA		Customer			Part No	
	P-1329900006-13901/ 13901		RRVUNL RAMGARH			13901026	
Drawing No.-Var	E.Rev.	T.Rev.	Material No.		Name Of The Part		
01390131116	01	00	01390131116-00		BOTTOM HALF OF BRG PEDESTAL MACHINING		
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks	
0002	2.000	2.000	EA	IS02	910.000	BOTTOM HALF OF BEARING PEDESTAL	
Operation Details							
Opr No	W.C.	Plant	Ctl. ky	Prep Time	Time/ PC(M)	Time/ PC(L)	QC Signature
PRT Cat	PRT No.			PRT Description			
Sub Operation Text							
iii.Tap 12+12 holes M12 on both faces of both halves. iv. Tap 4 holes M12 on PCD:98.4 oil inlet hole. v. On boss Ø100 tap 4 holes M8 on PCD 60 as per End view.							
0170	CG9528	P002	ZP99	0.000	0.000	960.000	1,920.000
Blue match the Brg pedestal bottom surface with Surface Plate.							

SAP PRINT

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	20.07.2022			AKM		3	3