	TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT	Production Order	Date
Plant: P002	Equipment No:	101909019	02.02.2021

Type	WBS Element	Customer	Part No
	P-1020104100-13901	ORISSA ALLOY STEEL PVT. LTD.	13901035

Drawing No.-Var	E.Rev.	T.Rev	Material No.	Name Of The Part
01390131139-00	00	00	01390131139-00	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	953.000	BOTTOM HALF OF BRG PEDESTAL MACHINING	YES

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		13901036					
AA19703		2.000	EA	0.000	0.000	0.000		0.000	IS04

Material Description : BOTTOM HALF OF BEARING PEDESTAL-M-20-338	Reservation : 0013697912	Item : 0001	Picklist:

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 80. Reverse and mill the top surface to height 606. 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.								
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.								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	12.02.2021			AKS		1	2

	TECHNOLOGICAL PROCESS	Production Order	Date
Plant:P002	Equipment No:	101909019	02.02.2021

Type	Work Order / PGMA	Customer	Part No
	P-1020104100-13901/ 13901	ORISSA ALLOY STEEL PVT. LTD.	13901035

Drawing No.-Var	E.Rev.	T.Rev.	Material No.	Name Of The Part
01390131139-00	00	00	01390131139-00	BOTTOM HALF OF BRG PEDESTAL MACHINING

Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks
0002	2.000	2.000	EA	IS02	953.000	BOTTOM HALF OF BRG PEDESTAL MACHINING

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								
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 178 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 98.5 to depth 30. 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.
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.

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	12.02.2021			AKS		2	2