

		TECHNOLOGICAL PROCESS RE-PRINT			Production Order	Date
Plant: P002		Equipment No:			101933231	19.08.2021
Type		WBS Element		Customer / Project Name		Part No
		P-5022001103-13606		DMDE-S5-TA-3.5 MW MIN1056		13606047
Drawing No.-Var		E.Rev.	T.Rev	Material No.		Name Of The Part
13321002001 -00		01	00	13321002001-00E		SHROUDED FAN IMPELLER-CCW-DIA428
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt. Wt.	Remarks
0020	1.000	1.000	EA	IS02	26.000	SHROUDED FAN IMPELLER-CCW-DIA428
						MDCC
						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.	
0010	L	TC32029-191FI			13606048					
		1.000	EA	0.000	0.000	0.000		0.000	IS08	
Material Description : IMPELLER FORNGING OD470 X ID175 X L165					Reservation :	Item : 0001	Picklist:			
					0013912066					

0020	L	33321000024-00E			13606049					
		1.000	EA	0.000	0.000	0.000		0.000	IS02	
Material Description : MOCK-UP PIECE-SHROUDED FAN-CCW					Reservation :	Item : 0002	Picklist:			
					0013912066					

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								
0069	CB9863	P002	ZP99	0.000	0.000	0.000	0.000	
Check the material received.								
0070	KB5392	P055	ZP99	120.000	13,140.000	26,280.000	26,400.000	
a) Refer the notes given on the drawing for informative details for machining. b) Mill three pockets to prove the blade machining program on this MOCK UP piece for drawing no.13321001032-00. For detail of vane profile, refer to the solid model No. : RD-RM450-TM14-06 issued by BHEL R & D. Tools Required: 1. Flat End mill - dia. 10 mm 2. Taper ball nose cutter - ball dia. 6 mm & taper 3 deg 3. Lollipop cutter - ball dia. 6 mm.								
0090	AB9425	P001	ZP99	20.000	0.000	850.000	870.000	
Clean the milled surfaces and de-burr the sharp edges.								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
AV	30.08.2021	00			MRAVI	1	1