

|                        |                |   |              |                                |                  |                                 |
|------------------------|----------------|---|--------------|--------------------------------|------------------|---------------------------------|
|                        |                | <b>TECHNOLOGICAL PROCESS<br/>RE-PRINT</b> |              |                                | Production Order | Date                            |
| Plant: P002            |                | Equipment No:                             |              |                                | 101933232        | 19.08.2021                      |
| <b>Type</b>            |                | <b>WBS Element</b>                        |              | <b>Customer / Project Name</b> |                  | <b>Part No</b>                  |
|                        |                | P-5022001103-13606                        |              | DMDE-S5-TA-3.5 MW MIN1056      |                  | 13606051                        |
| <b>Drawing No.-Var</b> |                | <b>E.Rev.</b>                             | <b>T.Rev</b> | <b>Material No.</b>            |                  | <b>Name Of The Part</b>         |
| 13321002002 -00        |                | 01  | 00           | 13321002002-00E                |                  | SHROUDED FAN IMPELLER-CW-DIA428 |
| <b>Pos.No</b>          | <b>BOM Qty</b> | <b>Ord Qty</b>                            | <b>MU</b>    | <b>St.</b>                     | <b>Nt. Wt.</b>   | <b>Remarks</b>                  |
| 0030                   | 1.000          | 1.000                                     | EA           | IS02                           | 26.000           | SHROUDED FAN IMPELLER-CW-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 |    |        | 13606052      |             |             |       |      |  |
|   |     | 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:   |       |      |  |
|   |     |               |    |        | 0013912067    |             |             |       |      |  |

**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 |             |             |            |              |
| <b>Sub Operation Text</b>   |         |       |         |                 |             |             |            |              |
| 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.<br>b) Mill three pockets to prove the blade machining program on this MOCK UP piece for drawing no.13321001032-00.<br><br>For detail of vane profile, refer to the solid model No.: RD-RM450-TM14-06 issued by BHEL R & D.<br><br>Tools Required:<br>1. Flat End mill - dia. 10 mm<br>2. Taper ball nose cutter - ball dia. 6 mm & taper 3 deg<br>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         |