

	TECHNOLOGICAL PROCESS					Production Order	Date
Plant: P004	Equipment No:					101985197	16.07.2022
Type	WBS Element		Customer / Project Name				Part No
Drawing No.-Var	E.Rev.	T.Rev	Material No.		Name Of The Part		
33312810008-00	00		13999800807-00CI		SPACER CASTING FOR KLIP		
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks	MDCC
	6.000	6.000	EA	IS04	5,000.000	SPACER CASTING FOR KLIP (OP-807)	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	HYN111000001								
		24,864.000	KG	0.000	0.000	0.000		0.000	ST04	
Material Description : MS. SCRAP					Reservation : 0014299498		Item : 0001		Picklist:	

0002	L	AA1135104018								
AA11304		0.168	TO	0.000	0.000	0.000		0.000	ST04	
Material Description : FERRO SILICON IN LUMPS					Reservation : 0014299498		Item : 0002		Picklist:	

0003	L	AA1135108013								
AA11308		0.576	TO	0.000	0.000	0.000		0.000	ST04	
Material Description : HIGH CARBON FERRO-MANGANESE					Reservation : 0014299498		Item : 0003		Picklist:	

0004	L	HY5365999045								
HY53699		126.000	TO	0.000	0.000	0.000		0.000	ST04	
Material Description : HIGH SILICA SAND FOR STEEL CATINGS					Reservation : 0014299498		Item : 0004		Picklist:	

0005	L	HY7730099047								
AA53616		0.738	TO	0.000	0.000	0.000		0.000	ST04	
Material Description : TWO PART SYSTEM CATALYST LIQUID					Reservation : 0014299498		Item : 0005		Picklist:	

0006	L	HY7730099004								
AA53616		1.938	TO	0.000	0.000	0.000		0.000	ST04	
Material Description : TWO PART SYSTEM PHYNOL BASED RESIN					Reservation : 0014299498		Item : 0006		Picklist:	

0007	L	HY7730099039								
AA53615-01		168.000	KG	0.000	0.000	0.000		0.000	ST04	
Material Description : THREE PART SYSTEM ALKYD RESING PART - A					Reservation : 0014299498		Item : 0007		Picklist:	

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
PSN	16.07.2022	00		USR1	NZR	1	3

	TECHNOLOGICAL PROCESS					Production Order	Date
Plant: P004		Equipment No:				101985197	16.07.2022
Type		WBS Element		Customer / Project Name			Part No
Drawing No.-Var		E.Rev.	T.Rev	Material No.		Name Of The Part	
33312810008-00		00		13999800807-00CI		SPACER CASTING FOR KLIP	
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks	MDCC
	6.000	6.000	EA	IS04	5,000.000	SPACER CASTING FOR KLIP (OP-807)	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.
0008	L	HY7730099187								
AA53615-01			54.000	KG	0.000	0.000	0.000		0.000	ST04
Material Description : THREE PART SYSTEM ALKYD RESING PART - B					Reservation : 0014299498		Item : 0008		Picklist:	

0120	L	HY7730099179								
AA53615-01			972.000	KG	0.000	0.000	0.000		0.000	ST04
Material Description : THREE PART SYSTEM ALKYD RESING PART - C					Reservation : 0014299498		Item : 0009		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								
0010	NC9821	P004	ZP05	0.000	0.000	0.000	0.000	
PATTERN / DIE MAKING								
0030	IE9371	P004	ZP05	1.000	60.000	768.000	4,609.000	
MOULD OR DIE PREPARATION								
0040	IE9261	P004	ZP05	1.000	120.000	3,072.000	18,433.000	
CORE MAKING								
0070	IE9555	P004	ZP05	1.000	0.000	3,840.000	23,041.000	
MOULD ASSEMBLY								
0090	IB9136	P004	ZP05	1.000	376.000	1,136.000	6,817.000	
MELTING & POURING ACTIVITY								
0100	IB9863	P004	QM02	0.000	0.000	0.000	0.000	
CHEMICAL ANALYSIS & INSPECTION								
0110	QG9271	P004	ZP05	1.000	0.000	1,800.000	10,801.000	
KNOCK OUT FETLING AND GRINDING ACTIVITY								
0130	QG9348	P004	ZP99	1.000	0.000	1,440.000	8,641.000	
HEAT TREATMENT								
Heating Upto 920 deg C (Rate of heating 100 deg C max), Holding for 12 hrs then forced Air cooling								
Furnace calibration report (not more than one year)								
Vendor shall quote Normalizing Cost/ Kg of the Job to be Heat Treated.								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
PSN	16.07.2022	00		USR1	NZR	2	3

		TECHNOLOGICAL PROCESS				Production Order		Date	
Plant:P004		Equipment No:				101985197		16.07.2022	
Type		Work Order / PGMA		Customer				Part No	
Drawing No.-Var		E.Rev.	T.Rev.	Material No.		Name Of The Part			
33312810008-00		00		13999800807-00CI		SPACER CASTING FOR KLIP			
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks			
	6.000	6.000	EA	IS04	5,000.000	SPACER CASTING FOR KLIP (OP-807)			
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									
0140	QG9414	P004	ZP05	0.000	0.000	0.000	0.000		
MACHINING ACTIVITY									
0150	QG9863	P004	QFNL	0.000	0.000	0.000	0.000		
MARKING & FINAL INSPECTION									

SAP PRINT

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
PSN	16.07.2022	00		USR1	NZR	3	3