

		TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET 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	MDCC
0020	1.000	1.000	EA	IS02	26.000	SHROUDED FAN IMPELLER-CCW-DIA428	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 : 0013912066		Item : 0001		Picklist:	

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 : 0013912066		Item : 0002		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								
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	
Refer the notes given on the drawing for informative details for machining.								
For detail of vane profile, refer to the solid model issued by BHEL.								
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	03.09.2021	00			MRAVI	1	1