

		TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT					Production Order		Date	
Plant: P002		Equipment No:					101899918		11.11.2020	
Type		WBS Element		Customer					Part No	
		P-1221100001-13502		RIN VIZAG SP					13502026	
Drawing No.-Var		E.Rev.	T.Rev	Material No.		Name Of The Part				
11350231078		01		11350231078-00		CLAMPING PLATE				
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks			MDCC	
0001	2.000	2.000	EA	IS02	930.000	CLAMPING PLATE			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	R	AA1011819244		13502003						
AA10119		5,663.038	KG	2,270.000	2,270.000	0.000	F1	2.000	ST12	
Material Description : PLATE 70 IS2062 GRE250(FE410W) QLTY-B				Reservation : 0013610665	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								
0080	CC4232	P002	ZP99	60.000	1,000.000	1,000.000	2,060.000	
Clamp the plate on the table, clamp from inside. Face and turn outside Ø 2243. Reverse, clamp from outside. Face to thickness 57. Turn inside Ø 1500 and chamfer 20x30deg as per Sec.A-A.								
0100	AC4232	P001	ZP99	90.000	400.000	400.000	890.000	
Attach the electro copying attachment. Turn the taper with electro copying attachment on non-chamfer side as per Sec.A-A maintaining thickness 51/55. 20-91-2036 : Copying template.								
0130	CC4662	P002	ZP99	40.000	160.000	160.000	360.000	
Pre-drill and drill 12 holes Ø 42.5 on PCD: 1610. Drill 4 holes Ø 21 for M24 depth 43.5, chamfer and tap M24 as per Sec.A-A.								
0150	CG9421	P002	ZP99	10.000	0.000	120.000	250.000	
Deburr the plates.								
0170	CG9528	P002	ZP99	0.000	0.000	960.000	1,920.000	
Refer clamping device drg 1 13502 31077/00. Collect the Fingers pos 2 to 5, 17 & 18. Adapt & keep the fingers pos 2 to 5, 17 & 18 in position as per layout. Remove the fingers after inspection.								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	12.11.2020	00		AB	KSR	1	1