

		<b>TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT</b>			Production Order	Date
Plant: P002		Equipment No:			101973561	03.06.2022
<b>Type</b>		<b>WBS Element</b>		<b>Customer / Project Name</b>		<b>Part No</b>
		P-1024201300-14304		ORISSA Alloy Steel Pvt Ltd.		14304004
<b>Drawing No.-Var</b>		<b>E.Rev.</b>	<b>T.Rev</b>	<b>Material No.</b>		<b>Name Of The Part</b>
11430431018		02	01	11430431018-00		ARMATURE LAMINATIONS
<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>
0010	5,000.000	5,000.000	EA	IS02	0.850	ARMATURE LAMINATIONS
						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	R	HY1091716820			14304005					
AA10916		10,285.000	KG	635.000	0.000	0.000		5,000.000	ST02	
Material Description : UN-INSL CRNGO STEEL SHEET 0.65X635XCOIL					Reservation :	Item : 0001	Picklist:			
					0014235593					

**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>								
0030	CA9466	P002	ZP99	0.000	0.000	0.000	0.000	
Set the press with blanking tool 20-44-2031 for blanking of ID., keyway and Ø20 holes. Blank few pcs for inspection approval.								
0050	CA3123	P002	ZP99	0.000	0.000	0.000	0.000	
Blank the pcs of thk 0.65(inner segments) and 5 pcs of thk 0.65mm(armature vent segments). Alternative sheet to be rotated by 90° while feeding for blanking.								
0070	CA9466	P002	ZP99	0.000	0.000	0.000	0.000	
Set the press for OD trimming cum notching of slots. Punch few pcs for inspection approval. OD trimming cut notching tool: 20-73-2259 Support plate : 20-54-2176.								
0080	CA3124	P002	ZP99	0.000	0.000	0.000	0.000	
Punch the pcs of thk 0.65(inner segments) for OD trimming and notching of slots.								
0100	CA9466	P002	ZP99	0.000	0.000	0.000	0.000	
Set the press for OD trimming cum notching of slots(Armature vent laminations). OD trimming cut notching tool: 20-73-2260. Support plate : 20-54-2176.								
0110	CA3124	P002	ZP99	0.000	0.000	0.000	0.000	
Punch 5 pcs of thk 0.65(Armature vent laminations) for OD trimming and notching of slots.								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	07.06.2022			AB		1	1