

		TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT					Production Order	Date
Plant: P002		Equipment No:					101909013	02.02.2021
Type		WBS Element		Customer				Part No
		P-1020104100-13504		ORISSA ALLOY STEEL PVT. LTD.				13504002
Drawing No.-Var		E.Rev.	T.Rev	Material No.		Name Of The Part		
21350431049		02	02	21350431049-00		CORE BACK RING ASSY END		
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks		MDCC
0010	2.000	2.000	EA	IS02	462.000	CORE BACK RING ASSY END		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.
0010		L	41350432571-00			13504003					
			4.000	EA	0.000		0.000	0.000		0.000	IS02
Material Description : HALF RING - CORE SUSPENSION					Reservation : 0013697232		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								
0040	CC4232	P002	ZP99	30.000	240.000	240.000	510.000	
Load the job such that plate side comes to bottomside. Align the job w.r.t marking and clamp. Turn ID to dia 2047.1+1 and chamfer the ID as per sec C-C. Turn OD to dia 2347 upto jaws. Face the ring by maintaining min THK 58 as per marking and chamfer 3 x 45 deg. Reverse set w.r.t turned dia and finish the balance portion of OD dia2347 and chamfer 3 x 45deg.								
0070	CC4662	P002	ZP99	30.000	140.000	140.000	310.000	
1. Pre-Drill and Drill 4 holes dia50 as per marking. 2. Drill 8 holes dia28 as per marking. 3. Drill 4 holes dia 14 for M16. Chamfer and tap M16.								
0090	CG9421	P002	ZP99	0.000	0.000	60.000	120.000	
Remove the plates(i.e tackwelded for machining purpose). Grind the seating zone to level clean and smoothen. Punch mark the relevant ring halves for identification.								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	10.02.2021	00		AKS	KSR	1	1