

		TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT					Production Order		Date	
Plant: P002		Equipment No:					101899704		10.11.2020	
Type		WBS Element		Customer					Part No	
		P-1221100001-13504		RIN VIZAG SP					13504071	
Drawing No.-Var		E.Rev.	T.Rev	Material No.		Name Of The Part				
21350431025		01		21350431025-00		RING ASSY.				
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks				MDCC
0001	3.000	3.000	EA	IS02	556.000	RING ASSY				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	L	41350431062-00			13504002					
			6.000	EA	0.000	0.000	0.000		0.000	IS02
Material Description : HALF RING					Reservation : 0013608805		Item : 0001		Picklist:	

0002	R	AA1011819198			13504004					
AA10119			37.680	KG	100.000	200.000	0.000	F1	6.000	ST12
Material Description : PLATE 40 IS2062 GRE250(FE410W) QLTY-B					Reservation : 0013608805		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								
0070	FD4241	P051	ZP99	60.000	200.000	200.000	660.000	
Load the job such that pos 2 comes bottom side. Align the job w.r.t marking and clamp. Turn ID to dia 2243.5+0.5 & OD to dia 2540+/-0.5. up to jaws. Face the ring by maintaining thk. 63 .& chamfer 3x45deg as per sec AA. Reverse , align w.r.t. turned dia & clamp. Turn remaining OD to dia 2540+/-0.5 and chamfer 3 x 45deg as per sec A-A.								
0100	CC4662	P002	ZP99	30.000	150.000	150.000	480.000	
1) Pre-Drill and drill 4 holes dia50 as per marking 2)Drill 4 holes dia17.5 for M20.Chamfer and tap M20. 3)Drill 8 holes dia28.								
0120	CG9421	P002	ZP99	10.000	0.000	120.000	370.000	
Remove the weld and remove the plates pos 2. Grind the seating zone to level. Clean and smoothen. Punch mark on both pcs.								

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