

		<b>TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT</b>			Production Order	Date
Plant: P002		Equipment No:			101971817	01.06.2022
<b>Type</b>		<b>WBS Element</b>		<b>Customer / Project Name</b>		<b>Part No</b>
		P-1029910300-13906		Shree Cement Ltd., Jhunjhunu		13906009
<b>Drawing No.-Var</b>		<b>E.Rev.</b>	<b>T.Rev</b>	<b>Material No.</b>		<b>Name Of The Part</b>
41390631678		04	03	41390631678-00A		HALF RING
<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>
0013	4.000	4.000	EA	IS02	22.400	HALF RING
						<b>MDCC</b>
						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	41390631678-00			13906010					
		4.000	EA	0.000	0.000	0.000		0.000	IS02	
Material Description : HALF RING					Reservation :	Item : 0001	Picklist:			
					0014234467					

**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>								
0060	CB5165	P002	ZP99	25.000	10.000	10.000	65.000	
Mill the parting planes as per marking.								
0080	CG9421	P002	ZP99	0.000	0.000	8.000	32.000	
Deburr the pcs. keep both halves together to form one ring and tack-weld on face & ID								
0100	CC4232	P002	ZP99	50.000	60.000	60.000	290.000	
Keep both halves together align & clamp. Face and turn out side Ø1250±0.2. Clamp from outside. Turn ID to Ø1080±0.2. Concentricity of 0.2 between ID & OD to be maintained. Reverse & face to thik. 20.								
0130	CB4645	P002	ZP99	20.000	40.000	40.000	180.000	
Drill 6+6 holes Ø14 for M16, chamfer & tap M16 as per marking. Drill 2+2 holes Ø8 for Taper Pin Ø8.								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	06.06.2022	00		AKM	KSR	1	1