

		<b>TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT</b>			Production Order	Date
Plant: P002		Equipment No:			101964965	25.03.2022
<b>Type</b>		<b>WBS Element</b>		<b>Customer / Project Name</b>		<b>Part No</b>
		P-1021503900-13906		Shyam Sel and Power Ltd		13906008
<b>Drawing No.-Var</b>		<b>E.Rev.</b>	<b>T.Rev</b>	<b>Material No.</b>		<b>Name Of The Part</b>
41390631860		00		41390631860-00		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>
0060	4.000	4.000	EA	IS02	31.700	HALF RING
						MDCC
						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	41390631861-00			13906009					
		4.000	EA	0.000	0.000	0.000		0.000	IS02	
Material Description : HALF RING					Reservation :	Item : 0001	Picklist:			
					0014160069					

**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>								
0080	CB5164	P002	ZP99	13.000	15.000	15.000	73.000	
Mill the parting planes as per marking.								
0100	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.								
0120	CC4232	P002	ZP99	30.000	95.000	95.000	410.000	
Keep both halves together align and clamp. Face and turn out side Ø 1520+/-0.2. Clamp from outside. Turn ID to Ø 1340+/-0.2. Concentricity of 0.2 between ID & OD to be maintained. Reverse & face to thik. 20.								
0130	CB9412	P002	ZP99	0.000	0.000	0.000	0.000	
Mark 6+6 holes M16 & 2+2 holes Ø 8 on half ring on PCR 720.								
0140	CB4645	P002	ZP99	15.000	40.000	40.000	175.000	
Drill 6+6 holes Ø14 for M16, chamfer & tap M16 as per marking. Drill 2+2 holes Ø8 for Taper Pin Ø8 as per marking.								

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