

		TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT			Production Order	Date
Plant: P002		Equipment No:			101973343	01.06.2022
Type		WBS Element		Customer / Project Name		Part No
		P-1021503800-13906		OMIPL 1x90MW KHGP+OSPPL 1X90MW JAMU		13906008
Drawing No.-Var		E.Rev.	T.Rev	Material No.		Name Of The Part
41390631860		00		41390631860-00		HALF RING
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks
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:			
					0014233773					

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								
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