

		TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT					Production Order		Date	
Plant: P002		Equipment No:					101911312		12.02.2021	
Type		WBS Element		Customer / Project Name					Part No	
		P-1020104100-13503		ORISSA Alloy Steel Pvt Ltd.					13503013	
Drawing No.-Var		E.Rev.	T.Rev	Material No.		Name Of The Part				
41350332101		00	00	41350332101-00		GUIDE BAR				
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks			MDCC	
0062	11.000	11.000	EA	IS02	35.000	GUIDE BAR			YES	

BOM Details

Pos.No	IC	Material Code	P.No	Remarks		
Matl.Spec	SPK	Qty	MU	Size 1	Size 2	Size 3
0010	R	AA1011819198	13503010			
AA10119		612.656	KG	75.000	2,365.000	0.000
Material Description : PLATE 40 IS2062 GRE250(FE410W) QLTY-B			Reservation : 0013711381	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								
0130	CC4828	P002	ZP99	40.000	120.000	120.000	1,360.000	
Rough machine the guide bars to width 64, height 33 i.e (1mm allowance per surface).								
0140	DG9421	P006	ZP99	10.000	0.000	30.000	340.000	
Straighten the guide bars and deburr.								
0150	CC4828	P002	ZP99	40.000	300.000	300.000	3,340.000	
Finish machine the guide bars to width 62 -0.19 and height 31-0.25 . Chamfer on edges to 3x45deg.								
0170	DG9421	P006	ZP99	10.000	0.000	30.000	340.000	
Straighten the guide bars and deburr.								
0200	DG4821	P006	ZP99	40.000	40.000	40.000	480.000	
Mill the ends maintaining length 2332. Drill 1 hole dia14 to depth 23 on one end. Chamfer and tap M16 to depth 17 as per Sec.								
0220	CG9421	P002	ZP99	0.000	0.000	10.000	110.000	
Deburr sharp edges.								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	18.02.2021	00		AKS	KSR	1	1