

	TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT					Production Order	Date
Plant: P002	Equipment No:					101911313	12.02.2021
Type	WBS Element		Customer / Project Name				Part No
	P-1020104100-13503		ORISSA Alloy Steel Pvt Ltd.				13503015
Drawing No.-Var	E.Rev.	T.Rev	Material No.		Name Of The Part		
41350332102	01	00	41350332102-00		GUIDE BAR WITH EARTHING SLOT		
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks	MDCC
0063	1.000	1.000	EA	IS02	34.700	GUIDE BAR WITH EARTHING SLOT	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	R	AA1011819198		13503011					
AA10119		55.696	KG	75.000	2,365.000	0.000	F1	1.000	ST12
Material Description : PLATE 40 IS2062 GRE250(FE410W) QLTY-B				Reservation : 0013711382	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	160.000	
Rough machine the guide bar to width 64, height 33(i.e1mm allowance per surface).								
0140	CC9421	P002	ZP99	10.000	0.000	30.000	40.000	
Straighten the guide bar and deburr.								
0150	CC4828	P002	ZP99	40.000	300.000	300.000	340.000	
Finish machine the guide bar to width 62 -0.19 and height 31-0.25 . Chamfer on edges to 3x45deg.								
0170	CC9421	P002	ZP99	10.000	0.000	30.000	40.000	
Straighten the guide bar and deburr.								
0200	CC4828	P002	ZP99	40.000	90.000	90.000	130.000	
Machine the groove width 4.5 and depth 3 as per drg.								
0230	CC4828	P002	ZP99	40.000	40.000	40.000	80.000	
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.								
0250	CC9421	P002	ZP99	0.000	0.000	10.000	10.000	
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