



TECHNOLOGICAL PROCESS

Production Order Date

Plant:P001 Equipment No: 102020669 14.03.2023

Type	Work Order / PGMA	Customer	Part No
	P-1019310100-30102/ 30102	ORISSA METALLURGICAL IND. PVT LTD	

Drawing No.-Var	E.Rev.	T.Rev.	Material No.	Name Of The Part
03010200049-15	18	16	03010200049-15	H63 INNER CASING ASSEMBLY

Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks
	1.000	1.000	EA	IS01	2,900.000	H63 INNER CASING ASSEMBLY

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

- a) Align and clamp the inner casing in assembled condition.
- b) Get the setting of the job inspected.
- c) Refer detail of blading plan Drg.No.93030100702 00 Sheet No.1&2
- d) Finish machine the shroud dias and lengths as per assembly requirement.
- e) Finish machine the locating groove to dia 992h11/dimn.50H9 as per assembly requirement as per detail-X.
- f) Also finish mill 1x30deg chamfers and R2 at corner as per Detail-X.

0720	AC9421	P001	ZP01				
------	--------	------	------	--	--	--	--

- a) Dismantle both the halves.
- b) Deburr the sharp edges at sealing fins and shrouds.

0730	AC9863	P001	QM01				
------	--------	------	------	--	--	--	--

Inspection for both the parts and record the dimns. in the log sheet.

0740	AC4809	P001	ZP01				
------	--------	------	------	--	--	--	--

UPPER PART

- a) Align & clamp the job on right end face such that left end face faces to machine spindle.
- b) Finish machine the sealing fin dias 968 H7 & 965 H7 at Nozzle area as per blading plan drg.No.93030100702-00 sheet No.1
- c) Finish machine nozzle portion to dia 890x8 with R2 for A wheel and as per blading plan drg. No.93030100702-00 sheet No.1

0741	AC9863	P001	ZP01				
------	--------	------	------	--	--	--	--

Inspection.

0742	AG9421	P001	ZP99				
------	--------	------	------	--	--	--	--

- a) Collect upper and lower halves of Inner casing.
- b) Carry out Grit blasting on BP gland area of Inner casing for

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
LR	18.03.2023	00		MG	MRAVI	25	26

		TECHNOLOGICAL PROCESS				Production Order	Date
Plant:P001		Equipment No:				102020669	14.03.2023
Type		Work Order / PGMA		Customer		Part No	
		P-1019310100-30102/ 30102		ORISSA METALLURGICAL IND. PVT LTD			
Drawing No.-Var		E.Rev.	T.Rev.	Material No.		Name Of The Part	
03010200049-15		18	16	03010200049-15		H63 INNER CASING ASSEMBLY	
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks	
	1.000	1.000	EA	IS01	2,900.000	H63 INNER CASING ASSEMBLY	
Operation Details							
Opr No	W.C.	Plant	Ctl. ky	Prep Time	Time/ PC(M)	Time/ PC(L)	QC Signature
PRT Cat	PRT No.		PRT Description				
Sub Operation Text							
getting required surface roughness for Abradable coating.							
c) Carry out thermal spray coating on BP gland area as shown in the drg No. 33010200030-00 and Follow Spec. TC41002-00.							
0743	AG9863	P001	QM01				
Inspection at above operation as per spec.TC41002-00.							
0745	AC9863	P001	ZQ01				
0750	AC9863	P001	QFNL				
Final Inspection.							
Send to W.C. AG							
Further process at main assembly.							

SAP PRINT

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
LR	18.03.2023	00		MG	MRAVI	26	26