

NIT 2023OSB020

SECTION I D - Operation list for various types of clamps

Bearing Clamp		
ITEM	OPERATION	
CLAMP	1	Clamp plate plasma cutting/water jet cutting per piece
	2	Straightening of plasma cut plate
	3	Heating for forming/Pressing
	4	Pressing per clamp
	5	Normalising & Tempering
	6	Skew correction of pressed clamps
	7	Shot blasting
	8	MARKING FOR EXTRA ST PORTION AND DRILL
	9	Extra Straight portion cutting/milling per clamp
	10	Drilling as per drawing
SIDE PLATE, BOTTOM PLATE & STIFFENERS	1	Plates plasma cutting/water jet cutting
	2	Straightening of plasma cut plate
	3	Milling of HAZ
	4	Gas cutting of bottom plate
	5	Grinding of gas cut edges
ASSEMBLY	1	Fitup of Side plates,Bottom Plate & Stiffener plate
	2	Welding of side plates, Bottom plate & Stiffener plate
	3	Final PWHT
	4	NDE(MPI)
	5	Shot blasting
	6	Painting & H/O

Horizontal Clamp		
ITEM	OPERATION	
CLAMP	1	Clamp plate plasma cutting/water jet cutting per piece
	2	Straightening of plasma cut plate
	3	Heating for forming/Pressing
	4	Pressing per clamp
	5	Normalising & Tempering
	6	Skew correction of pressed clamps
	7	Shot blasting
	8	MARKING FOR EXTRA ST PORTION AND DRILL
	9	Extra Straight portion cutting/milling
	10	Drilling as per drawing
Spacer Ring	1	Saw Cut the rod
	2	Face both ends & Through Drill
ASSEMBLY	1	Match the clamps with stud & pins
	2	Painting & H/O

Riser Clamp		
ITEM	OPERATION	
CLAMP	1	Clamp plate plasma cutting/water jet cutting
	2	Straightening of plasma cut plate
	3	Heating for forming/Pressing
	4	Pressing per clamp
	5	Normalising & Tempering
	6	Skew correction of pressed clamps
	7	Shot blasting
	8	MARKING FOR EXTRA ST PORTION AND DRILLING
	9	Extra Straight portion cutting/milling
	10	Drilling as per drawing
RIB PLATES	1	Plates plasma cutting/water jet cutting/water jet cutting per piece
	2	Straightening of plasma cut plate
	3	FOR END Milling of HAZ per piece
Spacer Ring	1	Saw Cut the rod
	2	Face both ends & Through Drill
ASSEMBLY	1	Fitup of Rib plate with clamp
	2	Welding of RIB Plate on clamp
	3	PWHT
	4	NDE(MPI)
	5	Shot blasting
	6	Assy

Trunnion Clamp		
ITEM	OPERATION	
CLAMP	1	Plates plasma cutting/water jet cutting per piece including the oblong holes
	2	Straightening of plasma cut plate
	3	Milling of edges per piece
Box Plates	1	Gas cutting of all 8 box plates
	2	Straightening of plasma cut plate
	3	Milling of HAZ per piece
	4	Stopper plate cutting (all 8 pieces)including 150x189 oblong hole
	5	Grinding
ASSEMBLY	1	Fitup of Box Plates (per box)
	2	Welding of box plates (per box)
	3	FLUSH GRINING OF WELDMENT AND BOW CORRECTION /BOX
	4	Welding of Stopper plate on clamps
	5	PWHT of Clamp & Stopper Assy
	6	Shot blasting
	7	NDE
	8	Assy with Box plates & Tacking
	9	Painting & H/O

