

ANNEXURE -H2 to Enquiry no: 4601700009E dt.28.11.2017

Bearing Clamp		Horizontal Clamp		Riser Clamp	
CLAMPS		CLAMPS		CLAMPS	
	OPERATION		OPERATION		OPERATION
1	Clamp plate plasma cutting per piece	1	Clamp plate plasma cutting per piece	1	Clamp plate plasma cutting per piece
2	Straightening of plasma cut plate	2	Straightening of plasma cut plate	2	Straightening of plasma cut plate
3	Heating for forming/Pressing	3	Heating for forming/Pressing	3	Heating for forming/Pressing
4	Pressing per clamp	4	Pressing per clamp	4	Pressing per clamp
5	Normalising & Tempering	5	Normalising & Tempering	5	Normalising & Tempering
6	Skew correction of pressed clamps	6	Skew correction of pressed clamps	6	Skew correction of pressed clamps
7	Shot blasting	7	Shot blasting	5	Shot blasting
8	MARKING FOR EXTRA ST PORTION AND DRILLING	8	MARKING FOR EXTRA ST PORTION AND DRILLING	6	MARKING FOR EXTRA ST PORTION AND DRILLING
9	Extra Straight portion cutting/milling per clamp	9	Extra Straight portion cutting/milling	7	Extra Straight portion cutting/milling
10	Drilling for M24	10	Drilling for M39 and dia 63	8	Drilling for M45 and dia 51 holes
				RIB PLATES	
SIDE PLATE, BOTTOM PLATE & STIFFENER		Spacer Ring		1	Plates plasma cutting per piece
1	Plates plasma cutting	1	Saw Cut the rod	2	Straightening of plasma cut plate
2	Straightening of plasma cut plate	2	Face both ends & Through Drill	3	FOR END Milling of HAZ per piece
3	Milling of HAZ				
4	Gas cutting of bottom plate			Spacer Ring	
5	Grinding of gas cutted edges	ASSEMBLY		1	Saw Cut the rod
ASSEMBLY			OPERATION	2	Face both ends & Through Drill
	OPERATION	1	Match the clamps with stud & pins		
1	Fitup of Side plates,Bottom Plate & Stiffener plate	2	Painting & H/O	ASSEMBLY	
2	Welding of side plates, Bottom plate & Stiffener plate				OPERATION
4	Final PWHT			1	Fitup of Rib plate with clamp
5	NDE(MPI)			2	Welding of RIB Plate on clamp
6	Shot blasting			3	PWHT
7	Painting & H/O			4	NDE(MPI)
				5	Shot blasting
				6	Assy
				7	Painting & H/O