

		TECHNOLOGICAL PROCESS					Production Order		Date	
Plant: P002		Equipment No:					101925674		24.06.2021	
Type		WBS Element		Customer / Project Name					Part No	
		P-1020104300-13504		ORISSA Alloy Steel Pvt Ltd.					13504006	
Drawing No.-Var		E.Rev.	T.Rev	Material No.		Name Of The Part				
41350432571		00	00	41350432571-00		HALF RING - CORE SUSPENSION				
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks			MDCC	
0010	6.000	6.000	EA	IS02	307.000	HALF RING - CORE SUSPENSION			NO	

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	AA1011819236		13504007					
AA10119		16,765.632	KG	2,377.000	1,188.500	0.000	F1	12.000	ST12
Material Description : PLATE 63 IS2062 GRE250(FE410W) QLTY-B				Reservation : 0013852098	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								
0001	DE9414	P006	ZP04	0.000	0.000	0.000	0.000	
Programme for gas cutting. Inner Radius = 1008.5mm. Outer Radius = 1188.5mm.								
0002	DE2818	P006	ZP04	20.000	90.000	90.000	560.000	
Flame cut 6 half rings to IR 1008.5/OR 1188.5 as per the program.								
0003	DE9421	P006	ZP01	20.000	0.000	50.000	320.000	
Dress the flame cut edges.								
0004	DE9412	P006	ZP01	0.000	0.000	0.000	0.000	
Mark the layout for checking of the half rings. Mark the bevel as per Sec D-D of drg 21350431048.								
0005	DE9284	P006	ZP01	10.000	0.000	20.000	130.000	
Flame cut the bevel (17.8 x 25°) as per marking and Sec D-D of drg 21350431048.								
0006	DE9421	P006	ZP01	10.000	0.000	30.000	190.000	
Dress the flame cut edges and straighten the pcs.								
0007	DE9863	P006	QFNL	0.000	0.000	0.000	0.000	
Inspect.								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	08.09.2021			AKS		1	1