

Material 21350431060-00 Plant P002
 CORE BACK RING ASSY CENTER
 Group 50283571 Grp.ct 1 CORE BACK RING ASSY CENTER
 LSize From 0 LSize To 99,999,999 EA
 Use 1 Status 4 PlantP002

Sequence	0	Seq. Cat.	Std.seq.			
Operation	0010	Work Ctr	CG9421	Mark the layout for alignment of halfrin		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN		
		Labor		90 MIN		
Operation	0020	Work Ctr	CC9412	Check for machining allowances. Mark se		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0030	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0040	Work Ctr	CC4232	Load the job such that plate side comes		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN Machine	300 MIN	
		Labor		300 MIN		
Operation	0050	Work Ctr	CC9863	Inspect the dimms.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0060	Work Ctr	CC9412	Mark for opern 0070		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0070	Work Ctr	CC4662	1. Pre-Drill and Drill 4 holes dia50 as		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN Machine	120 MIN	
		Labor		120 MIN		
Operation	0080	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0090	Work Ctr	CG9421	Remove the plates(i.e tackwelded for mac		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		MIN		
		Labor		45 MIN		
Operation	0100	Work Ctr	CG9863	Inspect.		
		Ctrl Key	QFNL			
		Base Qty		1 EA		

Material	21350431061-00		Plant	P002
	CORE BACK RING ASSY END			
Group	50283526	Grp.ct	1	CORE BACK RING ASSY END
	LSize From		0	LSize To 99,999,999 EA
	Use		1	Status 4 PlantP002

Sequence	0	Seq. Cat.	Std.seq.	
Operation	0010	Work Ctr	CG9421	Mark the layout for alignment of halfrin
		Ctrl Key	ZP01	
		Base Qty		1 EA
		Setup		30 MIN
		Labor		90 MIN
Operation	0020	Work Ctr	CC9412	Check for machining allowances. Mark se
		Ctrl Key	ZP04	
		Base Qty		1 EA
Operation	0030	Work Ctr	CC9863	Inspect.
		Ctrl Key	QM01	
		Base Qty		1 EA
Operation	0040	Work Ctr	CC4232	Load the job such that plate side comes
		Ctrl Key	ZP01	
		Base Qty		1 EA
		Setup		30 MIN Machine 300 MIN
		Labor		300 MIN
Operation	0050	Work Ctr	CC9863	Inspect the dimms.
		Ctrl Key	QM01	
		Base Qty		1 EA
Operation	0060	Work Ctr	CC9412	Mark for opern 0070
		Ctrl Key	ZP04	
		Base Qty		1 EA
Operation	0070	Work Ctr	CC4662	1. Pre-Drill and Drill 4 holes dia50 as
		Ctrl Key	ZP01	
		Base Qty		1 EA
		Setup		30 MIN Machine 150 MIN
		Labor		150 MIN
Operation	0080	Work Ctr	CC9863	Inspect.
		Ctrl Key	QM01	
		Base Qty		1 EA
Operation	0090	Work Ctr	CG9421	Remove the plates(i.e tackwelded for mac
		Ctrl Key	ZP01	
		Base Qty		1 EA
		Setup		MIN
		Labor		45 MIN
Operation	0100	Work Ctr	CG9863	Inspect.
		Ctrl Key	QFNL	
		Base Qty		1 EA

Material 21350431062-00 Plant P002
 CORE BACK RING ASSY MIDDLE
 Group 50283597 Grp.ct 1 CORE BACK RING ASSY MIDDLE
 LSize From 0 LSize To 99,999,999 EA
 Use 1 Status 4 PlantP002

Sequence	0	Seq. Cat.	Std.seq.			
Operation	0010	Work Ctr	CG9421	Mark the layout for alignment of halfrin		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN		
		Labor		60 MIN		
Operation	0020	Work Ctr	CC9412	Check for machining allowances. Mark se		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0030	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0040	Work Ctr	CC4232	Load the job such that plate side comes		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN Machine	270 MIN	
		Labor		270 MIN		
Operation	0050	Work Ctr	CC9863	Inspect the dimms.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0060	Work Ctr	CC9412	Mark for opern 0070		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0070	Work Ctr	CC4662	1. Pre-Drill and Drill 4 holes dia50 as		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN Machine	120 MIN	
		Labor		120 MIN		
Operation	0080	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0090	Work Ctr	CG9421	Remove the plates(i.e tackwelded for mac		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		MIN		
		Labor		45 MIN		
Operation	0100	Work Ctr	CG9863	Inspect.		
		Ctrl Key	QFNL			
		Base Qty		1 EA		

Material 21350431080-00 Plant P002
 CORE BACK RING TYPE-2
 Group 50379282 Grp.ct 1 CORE BACK RING TYPE-2
 LSize From 0 LSize To 99,999,999 EA
 Use 1 Status 4 PlantP002

Sequence	0	Seq. Cat.	Std.seq.			
Operation	0010	Work Ctr	CG9421	Mark the layout for alignment of halfrin		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN		
		Labor		90 MIN		
Operation	0020	Work Ctr	CC9412	Check for machining allowances. Mark se		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0030	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0040	Work Ctr	KB4234	Load the job such that plate side comes		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN Machine	300 MIN	
		Labor		300 MIN		
Operation	0050	Work Ctr	KB9863	Inspect the dimms.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0060	Work Ctr	CC9412	Mark for opern 0070		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0070	Work Ctr	CC4662	1. Pre-Drill and Drill 4 holes dia50 as		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN Machine	120 MIN	
		Labor		120 MIN		
Operation	0080	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0090	Work Ctr	CG9421	Remove the plates(i.e tackwelded for mac		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		MIN		
		Labor		45 MIN		
Operation	0100	Work Ctr	CG9863	Inspect.		
		Ctrl Key	QFNL			
		Base Qty		1 EA		

Material 21350431081-00 Plant P002
 CORE BACK RING TYPE-1
 Group 50379279 Grp.ct 1 CORE BACK RING TYPE-1
 LSize From 0 LSize To 99,999,999 EA
 Use 1 Status 4 PlantP002

Sequence	0	Seq. Cat.	Std.seq.			
Operation	0010	Work Ctr	CG9421	Mark the layout for alignment of halfrin		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN		
		Labor		90 MIN		
Operation	0020	Work Ctr	CC9412	Check for machining allowances. Mark se		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0030	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0040	Work Ctr	KB4234	Load the job such that plate side comes		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN Machine	300 MIN	
		Labor		300 MIN		
Operation	0050	Work Ctr	KB9863	Inspect the dimms.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0060	Work Ctr	CC9412	Mark for opern 0070		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0070	Work Ctr	CC4662	1. Pre-Drill and Drill 4 holes dia50 as		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN Machine	150 MIN	
		Labor		150 MIN		
Operation	0080	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0090	Work Ctr	CG9421	Remove the plates(i.e tackwelded for mac		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		MIN		
		Labor		45 MIN		
Operation	0100	Work Ctr	CG9863	Inspect.		
		Ctrl Key	QFNL			
		Base Qty		1 EA		

Material 21350431082-00 Plant P002
 CORE BACK RING TYPE-3
 Group 50379286 Grp.ct 1 CORE BACK RING TYPE-3
 LSize From 0 LSize To 99,999,999 EA
 Use 1 Status 4 PlantP002

Sequence	0	Seq. Cat.	Std.seq.			
Operation	0010	Work Ctr	CG9421	Mark the layout for alignment of halfrin		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN		
		Labor		60 MIN		
Operation	0020	Work Ctr	CC9412	Check for machining allowances. Mark se		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0030	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0040	Work Ctr	KB4234	Load the job such that plate side comes		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN Machine	270 MIN	
		Labor		270 MIN		
Operation	0050	Work Ctr	KB9863	Inspect the dimms.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0060	Work Ctr	CC9412	Mark for opern 0070		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0070	Work Ctr	CC4662	1. Pre-Drill and Drill 4 holes dia50 as		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN Machine	120 MIN	
		Labor		120 MIN		
Operation	0080	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0090	Work Ctr	CG9421	Remove the plates(i.e tackwelded for mac		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		MIN		
		Labor		45 MIN		
Operation	0100	Work Ctr	CG9863	Inspect.		
		Ctrl Key	QFNL			
		Base Qty		1 EA		

Material	31350431516-00			Plant	P002
	RING ASSY				
Group	50338715	Grp.ct	1	RING ASSY	
	LSize From		1	LSize To	99,999,999 EA
	Use		1	Status	4 PlantP002

Sequence	0	Seq. Cat.	Std.seq.			
Operation	0010	Work Ctr	DD9421	Mark the layout for alignment of the hal		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN		
		Labor		60 MIN		
Operation	0011	Work Ctr	DD2852	Tack weld and Weld Pos. 2 on half rings.		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		20 MIN Machine		20 MIN
		Labor		20 MIN		
Operation	0012	Work Ctr	DD9421	Dress and straighten the rings. Punch ma		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		10 MIN		
		Labor		50 MIN		
Operation	0013	Work Ctr	DD9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0014	Work Ctr	QG9274	Anneal as per std HY 0640763		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		MIN		
		Labor		MIN		
Operation	0015	Work Ctr	QG9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0016	Work Ctr	CC9412	Check for machining allowances. Mark se		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0017	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0018	Work Ctr	CC4232	Load the job such that Pos. 2 comes bott		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		60 MIN Machine		510 MIN
		Labor		510 MIN		
Operation	0019	Work Ctr	CC9863	Inspect the dimns.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0020	Work Ctr	CC9412	Mark for Opern. 013.		
		Ctrl Key	ZP04			
		Base Qty		1 EA		
Operation	0021	Work Ctr	CC4662	I. For ring Pos.1		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		30 MIN Machine		300 MIN
		Labor		300 MIN		
Operation	0022	Work Ctr	CC9863	Inspect.		
		Ctrl Key	QM01			
		Base Qty		1 EA		
Operation	0023	Work Ctr	CG2852	Remove the weld and remove the plates Po		
		Ctrl Key	ZP01			
		Base Qty		1 EA		
		Setup		MIN Machine		90 MIN
		Labor		90 MIN		

Operation	0024	Work Ctr	QG9274	Shot/Sand blast the half rings.(6 nos.)
		Ctrl Key	ZP01	
		Base Qty		1 EA
		Setup		MIN
		Labor		MIN
Operation	0025	Work Ctr	CA9863	Inspect the shot/sand blasted rings.
		Ctrl Key	QFNL	
		Base Qty		1 EA