

		TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT					Production Order	Date
Plant: P002		Equipment No:					101910329	08.02.2021
Type		WBS Element		Customer / Project Name				Part No
		P-1219700315-16000		2x80 MW HZL, DARIBA, RAJASTHAN				16000006
Drawing No.-Var		E.Rev.	T.Rev	Material No.		Name Of The Part		
33054600032		01		33054600032-00V		VALVE CHAMBER COVER		
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks		MDCC
0550	4.000	4.000	EA	IS02	95.000	VALVE CHAMBER COVER		NO

BOM Details

Pos.No	IC	Material Code	P.No	Remarks		
Matl.Spec	SPK	Qty	MU	Size 1	Size 2	Size 3
0030	L	33054600032-00R	16000025			
NA		4.000	EA	0.000	0.000	0.000
Material Description : VALVE CHAMBER COVER				Reservation :	Item : 0003	Picklist:
				0013706159		

0040	R	AA1011819074							
AA10119		0.032	KG	10.000	10.000	0.000	F1	4.000	ST12
Material Description : PLATE 10 IS2062 GRE250(FE410W) QLTY-B				Reservation :	Item : 0004	Picklist:			
				0013706159					

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								
0190	AA9421	P001	ZP99	5.000	0.000	35.000	145.000	
1) Collect the existing Valve cover having drawing no 23054600003-00 2) All the existing bushes and seal rings shall be removed from the existing valve cover packing assembly 3) All the valve cover bore diameters shall be checked, recorded and informed before proceeding any further								
0210	KB4897	P055	ZP99	40.000	300.000	300.000	1,240.000	
a) Hold the job at dia 149 and support the job at dia 370 with steady rest. b) Face, drill & ream dia 38H7 to dimension of 210mm considering dia 185d8								
0240	AC4821	P001	ZP99	40.000	90.000	90.000	400.000	
Machine the Valve Cover ID of 112H7 to dimension of max Dia 114 and report the dimension for machining of the guide bush								
0260	AA4127	P001	ZP99	20.000	25.000	25.000	120.000	
Machine the guide bush as per dimension given by the QC								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	07.06.2021					1	1