

		TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT					Production Order	Date
Plant: P002		Equipment No:					101746112	10.01.2018
Type		WBS Element		Customer				Part No
		P-1023602000-13618		SHYAM METALICS & ENERGY LTD.				13618002
Drawing No.-Var		E.Rev.	T.Rev	Material No.		Name Of The Part		
11361831018		01	001	11361831018-03		ROTOR LAMINATION SEG. (TAII 1240-17P-15)		
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks		MDCC
0000	2,175.000	2,175.000	EA	IS02	3.060	ROTOR LAMINATION SEG (TAII 1240-17P-15)		YES

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.	
0001	L	HY1091716935		13618003						
AA10916		17,034.600	KG	0.000	0.000	0.000		0.000	ST02	
Material Description : UN-INSL CRNGO STEEL SHEET 0.65X1250XCOIL				Reservation : 0012186878		Item : 0001		Picklist:		

0002	L	HW2371576018								
TG66383-00		20,000.000	M	0.000	0.000	0.000		0.000	ST02	
Material Description : SI CTD POLYPROPYLENE FILM TAPE 0.05X30				Reservation : 0012186878		Item : 0002		Picklist:1000516812		

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									
0020	CA5972	P002	ZP99	0.000	0.000	0.000	0.000		
Shear the thk 0.65 mm sheets to size 1250 x 1250 from the rolls. Also shear 4 corners as per enclosed plan.									
0030	CA9466	P002	ZP99	0.000	0.000	0.000	0.000		
Set the press 3123 (500 T-press) with blanking tool 20-44-2027 for blanking 0.65 Blank few pcs for inspection approval.									
0040	CA3123	P002	ZP99	0.000	0.000	0.000	0.000		
Blank 2180 for ID, 4 key ways and 8 holes.									
0060	CA9466	P002	ZP99	0.000	0.000	0.000	0.000		
Set the for OD trimming tool : 20-73-2207 for OD trimming on X-15. Support plate : 20-54-2153.									
0070	CA3124	P002	ZP99	0.000	0.000	0.000	0.000		
2180 pcs to be trimmed to dia 1240 + 0.1 .									
0090	CA9466	P002	ZP99	0.000	0.000	0.000	0.000		
Chkd. By		Dt.	ECR/ Rev No	Dt.	Pro.Plnr		Rate Fixr / Tool Plnr	Pg no	No.of Pgs
		23.04.2018	00		KSR		KSR	1	2

		TECHNOLOGICAL PROCESS				Production Order		Date	
Plant:P002		Equipment No:				101746112		10.01.2018	
Type		Work Order / PGMA		Customer				Part No	
		P-1023602000-13618/ 13618		SHYAM METALICS & ENERGY LTD.				13618002	
Drawing No.-Var		E.Rev.	T.Rev.	Material No.		Name Of The Part			
11361831018		01	001	11361831018-03		ROTOR LAMINATION SEG. (TAII 1240-17P-15)			
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks			
0000	2,175.000	2,175.000	EA	IS02	3.060	ROTOR LAMINATION SEG (TAII 1240-17P-15)			
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									
Set the punching tool : 20-73-2196 for damper holes punching on X-15. Support plate : 20-54-2153.									
0100	CA3124	P002	ZP99	0.000	0.000	0.000	0.000		
Punch 72 holes of dia 12.2 H7 on each of 2175 laminations. Punching tool : 20-73-2196.									
0120	CA9466	P002	ZP99	0.000	0.000	0.000	0.000		
Set the press N32 CNC for notching of slots on thk 0.65mm laminations using the Programme. Notch few pcs for inspection approval. Notching tool : 20-73-2219. Support plate : 20-54-2150.									
0130	CA3124	P002	ZP99	0.000	0.000	0.000	0.000		
Notch 2100 pcs. 48 slots (Pos.No. 001) Notching tool: 20-73-2219. Notch 80 pcs. 48 slots (Pos.No. 002 & 003) Notching tool: 20-73-2220.									
0150	CA5691	P002	ZP99	0.000	0.060	0.060	130.500		
Degrease the stampings as decided by inspection.									
0160	CA5691	P002	ZP99	10.000	0.300	0.300	662.500		
Deburr 2100 pcs 2x crossways (Pos.No. 001) & 80 pcs 4x crossways (Pos.Nos 002 & 003). Max burr allowed 5 microns as there is no further varnishing oprn, care to be taken to retain the existing coat not to damage.									

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	23.04.2018	00		KSR	KSR	2	2