

		TECHNOLOGICAL PROCESS NOT FOR PROCESS SHEET PRINT					Production Order	Date
Plant: P002		Equipment No:					101900148	12.11.2020
Type		WBS Element		Customer				Part No
		P-1221100001-13503		RIN VIZAG SP				13503020
Drawing No.-Var		E.Rev.	T.Rev	Material No.		Name Of The Part		
41350331331		00	00	41350331332-00		GUIDE BAR		
Pos.No	BOM Qty	Ord Qty	MU	St.	Nt.Wt.	Remarks		MDCC
0066	1.000	1.000	EA	IS02	60.000	GUIDE BAR		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	R	AA1011819198		13503011						
AA10119		92.081	KG	75.000	3,910.000	0.000	F1	1.000	ST12	
Material Description : PLATE 40 IS2062 GRE250(FE410W) QLTY-B				Reservation : 0013611943	Item : 0001	Picklist:1000594667				

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								
0120	DG5288	P006	ZP99	40.000	175.000	175.000	215.000	
Rough machine the guide bars to width 63, height 33, i.e., 1mm allowance per surface. Chamfer on edges to 3x45° as per drg. Planning fixture : 20-62-2036								
0130	DG9421	P006	ZP99	10.000	0.000	30.000	40.000	
Straighten the guide bars and deburr.								
0140	DG5288	P006	ZP99	40.000	485.000	485.000	525.000	
Finish machine the guide bars to width 61.0 -0.19 and height 31.0 #0.25 . Chamfer on edges to 3x45deg. Planning fixture : 20-62-2036 ” Checking gauges Width : 20-88-2657 Height : 20-08-2656								
0160	DG9421	P006	ZP99	10.000	0.000	30.000	40.000	
Straighten the guide bars and deburr.								
0230	DG4821	P006	ZP99	40.000	40.000	40.000	80.000	
Mill the ends maintaining length 3880. Drill 1 hole 14 to depth 23 on one end. Chamfer and tap M16 to depth 17 as per Sec.								
0250	CA9421	P002	ZP99	0.000	0.000	20.000	20.000	
Deburr all sharp edges.								

Chkd. By	Dt.	ECR/ Rev No	Dt.	Pro.Plnr	Rate Fixr / Tool Plnr	Pg no	No.of Pgs
	16.11.2020			AB		1	1