

JOB CARD

PRODN/F/02/06

Job Card No.:	000815	Date :	11/07/2011	ASB Loc :	IM
Order Quantity.:	25	UOM :	Nos	Revision Level :	
Drawing No. :	57071 SHEET-3	Thread :		Revision Date :	
Workorder No. :	: (SS IPL)				
Item Name & Description :	B57071-12-AL :12" ALUMINIUM BASE BSPT				

Operation No.	Work center	Operation Description	Operation No	Machine No	Date	Shift	Empl ID	Good Qty	Scrap Qty	Start Time	End Time
<input type="checkbox"/> OPRN-1	IN250	PROFILING									
Setup Time:60.00 Actual Setup Time:_____											
cycle Time:70.00 Actual cycle Time:_____											
<input type="checkbox"/> OPRN-2	IN250	R.SIDE THREAD , TOTAL LENGTH									
Setup Time:30.00 Actual Setup Time:_____											
cycle Time:30.00 Actual cycle Time:_____											
<input type="checkbox"/> OPRN-3	IN250	HORIZONTAL THREADING									
Setup Time:30.00 Actual Setup Time:_____											
cycle Time:20.00 Actual cycle Time:_____											
<input type="checkbox"/> OPRN-4	IN180	VERTICAL THREADING									
Setup Time:30.00 Actual Setup Time:_____											
cycle Time:12.00 Actual cycle Time:_____											

Material Item	Material description	UOM	Material Qty	Material Indent No
ZRDMV0028	DIA 28MM MS ROUND ROD	Mts	0.03	001384

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<input type="checkbox"/> OPRN-5	IN200	SURFACE GRINDING									
Setup Time:30.00											
Actual Setup Time:_____											
cycle Time:30.00											
Actual cycle Time:_____											
<input type="checkbox"/> OPRN-6	IN260	DEBURR									
Setup Time:0.00											
Actual Setup Time:_____											
cycle Time:5.00											
Actual cycle Time:_____											
<input type="checkbox"/> OPRN-7	INASB	ASSLY									
Setup Time:10.00											
Actual Setup Time:_____											
cycle Time:5.00											
Actual cycle Time:_____											

Special Instruction:

Material Item	Material description	UOM	Material Qty	Material Indent No
ZRDMV0028	DIA 28MM MS ROUND ROD	Mts	0.03	001384