Job Card No.:	000815	Date :	11/07/20	011		ASB Lo	с :	: IN	И			
Order Quantity.:	25	UOM :	Nos	Nos		Revision Level :						
Drawing No. :	57071 SHEET-3	Thread :				Revisio	n Date	:				
Workorder No. :	: (SSIPL)											
Item Name & B57071-12-AL :12" ALUMINIUM BASE BSPT Description :												
No. c	Work Operation Description	cription O	peration No	Machine No	Date	Shift	Empl ID	Good	I Scrap Qty	Start Time	End Time	
□OPRN-1 IN	250 PROFILING											
Setup Time:60.00	Actual Setup Time:											
cycle Time:70.00	Actual cycle Time:											
—												
OPRN-2 IN	250 R.SIDE THREAD , TOTAL	LENGTH										
Setup Time:30.00	Actual Setup Time:											
cycle Time:30.00	Actual cycle Time:											
□OPRN-3 IN	1250 HORIZONTAL THREADIN	IC										
DOPKIN-3	230 HORIZONIAL MIKLADII											
Setup Time:30.00	Actual Setup Time:											
cycle Time:20.00	Actual cycle Time:											
Поррии	WEDTICAL TUREARING											
OPRN-4 IN	1180 VERTICAL THREADING											
Setup Time:30.00	Actual Setup Time:											
cycle Time:12.00	Actual cycle Time:											
Material Item	Material des	scription	UO	M Material C		Qty N		Ma	laterial Indent No			
ZRDMV0028	DIA 28MM MS ROUND ROD Mts					0.03 001384						

Date

000815

Job Card No.:

: 11/07/2011

ASB Loc

: IM

Order Quantity.:	25	UOM :	Nos	Nos			Revision Level :					
Drawing No. :	57071 SHEET-3 Thread					Revision Date :						
Workorder No. :	: (SSIPL)											
Item Name & Description :	B57071-12-AL :12" ALUMINIUM BASE BSPT											
•	/ork Operation Description nter		Operation No	Machine No	Date	Shift	Empl ID	Good Qty	Scrap Qty	Start Time	End Time	
OPRN-5 IN2	200 SURFACE GRINDING											
Setup Time:30.00 cycle Time:30.00	Actual Setup Time: Actual cycle Time:	_										
		-										
OPRN-6 IN2	260 DEBURR											
Setup Time:0.00	Actual Setup Time:											
cycle Time:5.00	Actual cycle Time:											
OPRN-7 INA	ASB ASSLY											
Setup Time:10.00 Actual Setup Time:												
Codap Timo. 10.00	/iddal Gotap Fillio											
cycle Time:5.00	Actual cycle Time:											
		_										
Special Instruction	:			<u> </u>								
Material Item	Material des	scription	UO		Waterial Qty			Mat	Material Indent No			
ZRDMV0028	DIA 28MM MS ROUND ROD		Mts		,	0.03			0013	384		