

 WORLES		AWS/PRD/F-4/R03				<h1>JOB CARD</h1>		96054		1	47
Article Number		UID		Verification		Order Quantity		Steps (Only for Reference)			
34342500469		96054		C NC		1					
Order Num	Order Date	Start Date	Delivery Date	Client PO							
35017	28-Oct-2020	28-Oct-2020	16-Nov-2020	20201315 26-Oct-2020							
Status			Marking								
* CRITICAL			11434-370 Ind.1-20201315 W 96054								
											
Pieces											
Ele.	Qty	Description		Recv.	Price	Material					
Grade	Hardness	Vend.	Del. Date	Order Number							
B1	1	22 x 45 x 7		0							
GT55											
A	1	54.5 x 46 x 21		0		ACERO					
2344		48-50 Hrc.									
Steps (Only for Reference)											
Step No.	Element	Operations		Fin	Vend Code	Price					
1	A	CUT STEEL									
2	A	CASING MAKING									
3	A	MILLING CASING									
5	A	SLOT SURFACE									
6	A	VACUUM HEAT TREATMENT									
7	A	CHECK HARDNESS									
8	A	HONING - CASING									
9	A	INTERNAL GRINDING - CASING									
11	B	Ø EXT. GRINDING - CARBIDE									
13	B	FITTING / MOUNTING									
15	B	SURFACE GRIND - CARBIDE									
16	B	AIR VENTS									
18	A	CARBIDE SLICE									
22	B	ROUGH DRILL									
23	AB	FINISH DRILL									
25	AB	INTERNAL GRINDING									
26	AB	WIRE CUT									
31	AB	HONING RELIEF									
34	AB	HONING									
35	AB	Ø EXTERNAL GRINDING									
43	AB	DRILL CARBIDE									
45	AB	ROUGH INTERNAL									
46	AB	BLANK									
50	AB	PROFILE ROTALIN									
61	AB	(SUNNEN/POLISH) BORE MATCHING									
70	AB	VMC									
80	AB	EDM - EROSION									
90	AB	POLISHING									
92	AB	FINISH ON LATHE									
95	AB	VERIFICATION & MARKING									
97	A	COATING									
99	AB	SHIPMENT									
100	AB	OTHER OPERATIONS									
In - process Observation											
Step No.	Element	Operator Name		Qty. Checked	Output Value	Qty. Checked	Output Value	Remarks			
7	AB										
8	A										
9	A										
11	B										
13	B										
15	B										
22	B										
25	AB										
26	AB										
31	AB										
34	AB										
35	AB										
45	AB										
50	AB										
61	AB										
70	AB										
80	AB										
90	AB										
92	AB										
100	AB										