



JOB CARD

97621

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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	AB	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	√	46	



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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						