

Article Number	UID	Verification		Order Quantity
34340200316	91950	C	NC	3
Order Num	Order Date	Start Date	Delivery Date	Client PO
33615	31-Jul-2020	01-Aug-2020	23-Aug-2020	71249 30-Jul-2020
Status			Marking	
			644111 U-060-20-01 Ind.01 W 91950	



Pieces						
Ele.	Qty	Description		Recv.	Price	Material
Grade		Hardness	Vend.	Del. Date	Order Number	
B1	1	16 x 15 x 5.25		0		M.D.
GT55			42	15-Aug-2020	57906	
B2	1	16 x 45 x 3		0		M.D.
G45C			42	15-Aug-2020	57906	
A	1	38.5 x 61 x 15.5		0		ACERO
2344		52-54 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						