

AWS/PRD/F-4/R03

JOB CARD

94439

1

43

Article Number			UID		Verification		Order Quantity
34340401	336 94		4439	С	C NC		1
Order Num	Order Date		Start Date		Delivery Date		Client PO
34521	05-0 20		10-Jun	-2020	21	-Oct-2020	151156 Be 01- Oct-2020
Status				Marking			

8575126.151S Ind.II W 94439





	Pieces						
Ele.	Qty	Description		Recv.	Price	Material	
Grade		Hardness	Vend.	Del. Date	Order Number		
A 1	1	22.5 x 60 x 0)	0		ACERO	
2344		48-50 Hrc.					
B1 1	1	12 x 3.1 x 12	2	0		M.D.	
GT55							

		Steps (Only for Reference	:)		
Step No.	Element	Operations	Fin	Vend Code	Price
1	Α	CUT STEEL			
2	Α	CASING MAKING			
3	Α	MILLING CASING			
5	Α	SLOT SURFACE			
6	Α	VACUUM HEAT TREATMENT			
7	Α	CHECK HARDNESS			
8	Α	HONING - CASING			
9	Α	INTERNAL GRINDING - CASING			
11	В	Ø EXT. GRINDING - CARBIDE			
13	В	FITTING / MOUNTING			
15	В	SURFACE GRIND - CARBIDE			
16	В	AIR VENTS			
18	Α	CARBIDE SLICE			
22	В	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	Α	COATING			
99	AB	SHIPMENT			
100	AB	OTHER OPERATIONS			

Step No. Element No. Operator Name Qty. Checked Output Value Qty. Checked Output Value Remarks 7 AB			Observation	In - process				
8 A 9 A 111 B 131 B 151 B 151 B 152 B 152 B 153 B 154 B 155	Remarks	Output Value	Qty. Checked	Output Value	Qty. Checked	Operator Name	Element	Step No.
9 A 11 B 13 B 15 B 16 B 17 B 18							AB	7
11 B							A	8
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							A	9
15 B 22 B 25 AB 26 AB 26 AB 27 AB 28 AB 29							В	11
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							В	13
25 AB 26 AB 31 AB 31 AB 32 AB 33 AB 35 AB 36 AB 36 AB 36 AB 37 AB 38 AB 38 AB 39 AB							В	15
26 AB 31 AB 34 AB 35 AB 35 AB 45 AB 50 AB 61 AB 70 AB 80 AB 90 AB							В	22
31 AB 34 AB 35 AB 36 AB 36 AB 36 AB 37 AB 38 AB 39 AB 30 AB							AB	25
34 AB 35 AB 45 AB 50 AB 61 AB 70 AB 80 AB 90 AB 92 AB							AB	26
35 AB							AB	31
45 AB 50 AB 61 AB 70 AB 80 AB 90 AB 92 AB							AB	34
50 AB 61 AB 70 AB 80 AB 90 AB 92 AB							AB	35
61 AB 70 AB 80 AB 90 AB 92 AB							AB	45
70 AB 80 AB 90 AB 92 AB							AB	50
80 AB 90 AB 92 AB							AB	61
90 AB 92 AB							AB	70
92 AB							AB	80
							AB	90
							AB	92
100 AB							AB	100