

NOTING

No-107/058/02/MS/25
QC/FP Section
Date-23-11-2017

SUB: IDENTIFICATION OF ESSENTIAL PLANT & MACHINERIES

The Multi Functional Team has discussed about the essential Plant & Machineries of following item and came in decision that the following essential Plant & Machineries are required for evaluation of the item.

Sl.No.	Items	Essential P & M Reqd.
1	Bin for AK-630M Assy.03	i) Sheet Metal Rolling M/c, (Bed width 1850 mm) ii) Forming M/c iii) Press M/c iv) Die & Punch v) Spot welding vi) Tig welding vii) Riveting M/c viii) Turning M/c ix) Milling M/c, x) Structural Machining (welded & Riveted Assy.
2	Machining of 1 Set of Race Ring Consist of AK-630 119-1, Upper ring to drg.AK-630 AA	i) Vertical Turning, Boring & Drilling M/c with bed indexing facility (Bed Dia. 1350mm) ii) Internal Gear Hobbing/Broaching M/c (Bed Dia 1350mm) iii) Gear Grinding M/c (To Maintain Backlash within 0.17mm to 0.34mm) (Bed dia 1350mm)
3	Belleville Spring drg. No. AK-630 120-4	i) Press M/c ii) Punch & Die /Machining set up (JOB Dia 45mm) iii) Heat Treatment.