

Preface to NSQF (Level-4) Compliant Edition



Directorate General of Training (DGT) under the Ministry of Skill Development and Entrepreneurship (MSDE) is the apex body in the country as regards planning, formulating and prescribing norms, standards, procedures and guidelines in respect of various vocational training schemes of which Craftsmen Training Scheme (CTS) implemented in ITI's is the most important and wide-spread throughout the country. Prescribing well designed curriculum and putting in place appropriate assessment and certification procedure are among the vital aspects of vocational training.

Fitter (Sector: Capital Goods & Manufacturing) is one among the top couple of popular ITI designated trades and is of two-year duration. DGT in September 2022 issued latest revised version (version 2.0 of July 2022) of the syllabus, which came into force with effect from 2022 session of admission in ITI's. The main significant change has been that its NSQF level has been revised from five to four. In view of the fact that training in ITI's is primarily practical-oriented, major part of training time (70%) is devoted to practical. In consideration of this important part of training, 250 hours (125 hours each in first and second year) has now been set aside for on-the-job training / group project. However, the contents of practical training earmarked for execution within ITI's workshop has been retained the same.

As such this book fully covers the professional skill (trade practical) part of the latest 2022 syllabus. Besides incorporating relevant skill information, each practical exercise comprises of necessary information relating to material, tools, equipment and instruments required, the sequence of operations and precautions to be observed. Besides practical exercises relating to all aspects of Fitter trade, adequate number of exercises concerning allied trades like sheet metal, welding, turning etc. have also been included as prescribed in the syllabus.

An added feature is that a set of 20 most important practical jobs, as often appeared in All India Trade Tests, has been compiled for the benefit of trainees to familiarise with and practice such jobs and thus prepare well for the final trade test.

We sincerely hope that trainees will find this book very much helpful to adjust with the latest changes in syllabus related to Fitter Trade Practical. We would welcome suggestions for further improvement of this book in its subsequent editions.

— Author

Contents



NSQF (Level-4) Compliant Competency based Curriculum for Fitter Trade Practical (2022 Syllabus) ix – xii

1st Year

MODULE	PAGES
1. SKILL INFORMATION	3–49
Safety.....	3–8
Basic fitting.....	9–38
Sheet Metal.....	39–40
Welding	41–45
Turning.....	46–49
2. BASIC FITTING	50–66
Exercise 1 : Filing and Hacksawing	51
Exercise 2 : Marking and Filing.....	53
Exercise 3 : Marking and Filing.....	55
Exercise 4 : Marking and Filing.....	57
Exercise 5 : Filing and Chipping	59
Exercise 6 : Angular Filing	61
Exercise 7 : Filing, Drilling, Countersinking and Counterboring.....	63
Exercise 8 : Filing, Drilling, Tapping and External Threading.....	65
3. SHEET METAL	67–89
Exercise 1 : Marking and Cutting Straight Line.....	67
Exercise 2 : Marking of Curves and Curve Cutting.....	68
Exercise 3 : Marking and Cutting (Straight and Curve).....	70
Exercise 4 : Marking and Cutting (Straight and Curve).....	71
Exercise 5 : Marking and Cutting Different Angles and Shapes (Geometrical) on Sheet Metal	73
Exercise 6 : Marking and Cutting Different Angles, Shapes (Geometrical) on Sheet Metal	76
Exercise 7 : Marking a Hollow Square Shape.....	79
Exercise 8 : Making a Hollow Cylinder.....	81
Exercise 9 : Making Lap joint - Soldered	83
Exercise 10 : Making Butt Joint - Soldered with Single Strap	84
Exercise 11 : Marking and Profile Cutting.....	86
Exercise 12 : Rectangular Tray with Flaps – its Marking and Soldering	88
4. WELDING	90–106
Exercise 1 : Depositing Continuous Beads by Arc Welding on M.S. Plate without Weaving.....	90
Exercise 2 : Depositing continuous beads by Arc Welding on M.S. Plate using Weaving Motion	92
Exercise 3 : Welding Full Open Corner Joint by Arc Welding on M.S. Plate	93
Exercise 4 : Making Single Pass Fillet Weld by Arc Welding on M.S. Plate	94
Exercise 5 : Making Single 'V' Butt Joint by Arc Welding on M.S. Plate	95

Exercise 6	: Depositing Beads by Arc Welding in Vertical Position, Upward and Downward, on M.S. Plate.....	96
Exercise 7	: Depositing beads by Arc Welding in Overhead Position on M. S. Plate	97
Exercise 8	: Setting up of Gas Welding Plant	98
Exercise 9	: Running a Bead by Gas Welding without using Filler Wire.....	101
Exercise 10	: Running a Bead by Gas Welding using Filler Wire	102
Exercise 11	: Weld Open Square Joint by Gas Welding.....	103
Exercise 12	: Weld Fillet Joint by Gas Welding in Horizontal -Vertical Position.....	104
Exercise 13	: Oxy-acetylene Cutting of Plates.....	105
5.	DRILLING AND FITTING ASSEMBLY.....	107–144
Exercise 1	: Filing Drilling, Reaming, Countersinking, and Counterboring	107
Exercise 2	: Filing, Reaming, Tapping and Counter boring.....	109
Exercise 3	: Filing, Drilling, Tapping and Reaming.....	111
Exercise 4	: Filing, Chamfering and Tapping	113
Exercise 5	: Filing and Chamfering.....	115
Exercise 6	: Filing, Sawing, Grooving and Chamfering.....	117
Exercise 7	: Filing, Drilling and Grooving	119
Exercise 8	: Filing, Blind Hole Tapping and Grooving	121
Exercise 9	: Filing and Slotting.....	123
Exercise 10	: Filing, Drilling, Tapping, Reaming, External Threading and Location of Holes	125
Exercise 11	: Scraping Flat Surfaces using Three Plate Method.....	127
Exercise 12	: Scrapping Bearing Surface	129
Exercise 13	: Filing, Drilling, Countersinking and Riveting.....	130
Exercise 14	: Filing and Fitting.....	132
Exercise 15	: Filing, Drilling, Reaming and Fitting	134
Exercise 16	: Filing, Tapping, Countersinking and Step Fitting.....	136
Exercise 17	: Filing, Bending, Drilling, Countersinking and Riveting	138
Exercise 18	: Filing, Drilling and Fitting.....	140
Exercise 19	: Filing and Fitting.....	142
6.	TURNING.....	145–157
Exercise 1	: Facing	145
Exercise 2	: Plain Turning	146
Exercise 3	: Facing and Chamfering.....	148
Exercise 4	: Step Turning.....	149
Exercise 5	: Plain and Step Turning, Simple Taper Turning and Knurling.....	150
Exercise 6	: Plain and Taper Turning, Radius and Step Turning.....	152
Exercise 7	: Plain Turning, Chamfering, Undercutting and External Threading.....	153
Exercise 8	: Plain and Stepped Internal and External Turning and Boring	155
Exercise 9	: Boring and Scraping Cylindrical Bore	156
7.	BASIC MAINTENANCE	158–160
Exercise 1	: Dismantling and Assembling Globe Valve.....	158
Exercise 2	: Dismantling and Assembling Non-return Valve	160

2nd Year

MODULE

PAGES

1.	SKILL INFORMATION	3–12
	Pipe Fitting.....	3–9
	Material Handling	10–12

2. ASSEMBLY 1	13–86
Exercise 1 : Filing, Sawing, Drilling, Riveting and Centre Line Alignment	13
Exercise 2 : Filing and Square Fitting	15
Exercise 3 : Filing, Slotting, Tapping and Fitting	17
Exercise 4 : Filing and Angular Fitting	20
Exercise 5 : Filing and Radius Filing	22
Exercise 6 : Filing and Tongue Fitting	25
Exercise 7 : Filing and Angular Fitting	28
Exercise 8 : Filing, Fitting and Scraping Angular Surfaces	30
Exercise 9 : Filing and Radius Fitting	32
Exercise 10 : Filing, Drilling, Tapping and Fitting	35
Exercise 11 : Filing and Key Fitting	37
Exercise 12 : Filing and Fitting	39
Exercise 13 : Filing, Grooving and Fitting	42
Exercise 14 : Filing, Grooving, Tapping and Fitting	45
Exercise 15 : Filing, Tapping and Radius Fitting	48
Exercise 16 : Filing, Tapping, Radius and Angular Fitting	51
Exercise 17 : Filing, Tapping, Reaming and Fitting	54
Exercise 18 : Filing, Reaming, Tapping and Fitting	57
Exercise 19 : Filing, Drilling and Fitting	60
Exercise 20 : Filing, Drilling, Tapping and Fitting	63
Exercise 21 : Filing and Fitting	66
Exercise 22 : Filing and Fitting	69
Exercise 23 : Filing and Fitting	72
Exercise 24 : Filing, Tapping and Fitting	75
Exercise 25 : Filing, Drilling, Tapping and Fitting	78
Exercise 26 : Filing, Radius and Tongue Fitting	81
Exercise 27 : Filing and Fitting	84
3. GAUGES	87–93
Exercise 1 : Centre Gauge	87
Exercise 2 : Angle Grinding Gauge	89
Exercise 3 : Snap Gauge 'Go' and 'No Go'	90
Exercise 4 : Lapping Flat Surface and Hole	92
4. PIPE FITTING	94–101
Exercise 1 : Pipe Cutting (Using Pipe Cutter)	94
Exercise 2 : Pipe Bending (By Hot Method)	96
Exercise 3 : Pipe Bending (By Cold Method)	98
Exercise 4 : Pipe Threading (Using Die Stocks)	100
5. REPAIRING TECHNIQUES	102–205
Exercise 1 : Filing, Radius and Dovetail Fitting	102
Exercise 2 : Filing, Reaming, Tapping and Fitting	106
Exercise 3 : Filing, Reaming, Tapping and Fitting	109
Exercise 4 : Filing, Reaming and 'H' Fitting	111
Exercise 5 : Filing and Fitting	114
Exercise 6 : Filing, Reaming, Tapping and Fitting	117
Exercise 7 : Filing and Fitting	120
Exercise 8 : Filing, Reaming, Tapping and Fitting	123
Exercise 9 : Filing and Pentagon Fitting	125
Exercise 10 : Filing and Plus Fitting	127
Exercise 11 : Filing and Regular Triangle Universal Fitting	130
Exercise 12 : Filing and Diagonal Plus Fitting	132

Exercise 13 : Filing and Octagon Fitting	135
Exercise 14 : Filing and Universal Fitting.....	138
Exercise 15 : Filing and Fitting.....	140
Exercise 16 : Filing and Hexagon Fitting	144
Exercise 17 : Filing, Drilling, Tapping, Countersinking, Counterboring and Dovetail Fitting	146
Exercise 18 : Filing, Turning, Facing and Threading on Lathe (Gear Puller)	148
Exercise 19 : Filing and Fitting.....	151
Exercise 20 : Filing and Fitting.....	156
Exercise 21 : Filing and Fitting.....	160
Exercise 22 : Filing and Dovetail Fitting.....	163
Exercise 23 : Filing, Drilling, Tapping and Fitting	166
Exercise 24 : Filing and Fitting.....	170
Exercise 25 : Filing and Fitting.....	173
Exercise 26 : Filing and Fitting.....	176
Exercise 27 : Filing and Fitting.....	179
Exercise 28 : Filing and Fitting.....	183
Exercise 29 : Filing, Drilling, Tapping and Fitting	186
Exercise 30 : Filing and Fitting.....	190
Exercise 31 : Slide Fitting	194
Exercise 32 : Three Piece Fitting	197
Exercise 33 : Four Piece 'S' Fitting	200
Exercise 34 : ITI Fitting	203
6. HYDRAULICS AND PNEUMATICS	206–241
Pneumatic Controls.....	206
Hydraulic controls	225
7. ERECTION AND TESTING	242–248
Exercise 1 : Making Various Knots	242
Exercise 2 : Erection of Tripod and Lifting Load	245
Exercise 3 : Erection and Testing of Machine Tools.....	246
Appendix : Practical Jobs for Practice.....	249–272