

CRAFTSMEN TRAINING SCHEME (CTS 2.0 / NSQF LEVEL-4)

**ANNUAL INSTRUCTIONAL PLAN — FITTER (1ST YEAR)**

|                               |                                                  |
|-------------------------------|--------------------------------------------------|
| Trade Name                    | FITTER (Mechanical / Fitting Trade)              |
| NSQF Level & Duration         | NSQF Level-4   Two Years (First Year — 42 Weeks) |
| Academic Session              | 20____ - 20____                                  |
| Institute Name & Address      | Industrial Training Institute, _____             |
| Instructor Name & Designation | _____                                            |
| Group Instructor (GI) Name    | _____                                            |
| Principal / Supt. Name        | _____                                            |

*Curriculum aligned with DGT / CSTARI Guidelines for Fitter Trade*

## WEEKLY INSTRUCTIONAL PLAN — FITTER 1ST YEAR (WEEK 01 TO 42)

| Week No.       | Professional Skills (Trade Practical)                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Professional Knowledge (Trade Theory)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |
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| <b>WEEK 01</b> | <p>Safety &amp; Workshop Induction:</p> <ol style="list-style-type: none"> <li>1. Importance of trade training, List of tools &amp; Machinery used in the trade.</li> <li>2. Safety attitude development of trainee, education on Personal Protective Equipment (PPE).</li> <li>3. First Aid Method and basic training.</li> <li>4. Safe disposal of waste materials like cotton waste, metal chips/burrs etc.</li> <li>5. Hazard identification and avoidance.</li> </ol>                                  | <p>Safety &amp; Housekeeping Concepts:</p> <ol style="list-style-type: none"> <li>1. Guidance on ITI system and store procedures.</li> <li>2. Soft Skills, its importance and Job areas.</li> <li>3. General safety precautions in industry/shop floor.</li> <li>4. First aid, electrical mains operation and safety.</li> <li>5. Introduction to PPEs, 5S concept, Occupational Safety &amp; Health legislations, hot work and confined spaces.</li> </ol>                                                          |
| <b>WEEK 02</b> | <p>Safety Signs &amp; Basic Marking Aids:</p> <ol style="list-style-type: none"> <li>6. Safety signs for Danger, Warning, caution &amp; personal safety messages.</li> <li>7. Preventive measures for electrical accidents &amp; steps to be taken in accidents.</li> <li>8. Use of Fire extinguishers.</li> <li>9. Precautions to be followed while working in fitting jobs.</li> <li>10. Safe use of tools and equipments used in the trade.</li> </ol>                                                   | <p>Linear Measurement &amp; Marking Tools:</p> <ol style="list-style-type: none"> <li>6. Response to emergencies: power failure, fire, and system failure.</li> <li>7. Linear measurements: units and measuring standards (English, Metric Units), angular measurements.</li> <li>8. Dividers, calipers, hermaphrodite caliper, description and uses.</li> <li>9. Centre punch, dot punch, prick punch, and types of hammers.</li> <li>10. Description, use and care of 'V' Blocks and marking off table.</li> </ol> |
| <b>WEEK 03</b> | <p>Basic Sawing &amp; Bench Vice:</p> <ol style="list-style-type: none"> <li>11. Identification of tools &amp; equipment as per desired specifications for marking &amp; sawing.</li> <li>12. Selection of material as per application.</li> <li>13. Visual inspection of raw material for rusting, scaling, corrosion etc.</li> <li>14. Marking out lines, gripping suitably in vice jaws, hacksawing to given dimensions.</li> <li>15. Sawing different types of metals of different sections.</li> </ol> | <p>Bench Vice &amp; Hacksaws:</p> <ol style="list-style-type: none"> <li>11. Bench vice: construction, types, uses, care &amp; maintenance, vice clamps.</li> <li>12. Hacksaw frames and blades: specification, description, types and their uses.</li> <li>13. Method of using hacksaws.</li> </ol>                                                                                                                                                                                                                 |
| <b>WEEK 04</b> | <p>Filing Flat &amp; Square Surfaces:</p> <ol style="list-style-type: none"> <li>16. Filing Channel, Parallel.</li> <li>17. Filing - Flat and square (Rough finish).</li> <li>18. Filing practice, surface filing, marking of straight and parallel lines with odd leg calipers and steel rule.</li> </ol>                                                                                                                                                                                                  | <p>Files &amp; Filing Theory:</p> <ol style="list-style-type: none"> <li>14. Files: specifications, description, materials, grades, cuts, file elements, uses.</li> <li>15. Types of files, care and maintenance of files.</li> <li>16. Methods of filing (cross, draw, straight filing).</li> </ol>                                                                                                                                                                                                                 |
| <b>WEEK 05</b> | <p>Layout Marking &amp; Chipping:</p> <ol style="list-style-type: none"> <li>19. Marking practice with dividers, odd leg calipers and steel rule (circles, arcs, parallel lines).</li> <li>20. Marking off straight lines and arcs using scribing block and dividers.</li> <li>21. Chipping flat surfaces along a marked line.</li> <li>22. Marking, filing, filing square and check using try square.</li> </ol>                                                                                           | <p>Marking Off Tools &amp; Chisels:</p> <ol style="list-style-type: none"> <li>17. Marking off and layout tools: dividers, scribing block (classification, material, care).</li> <li>18. Try square, ordinary depth gauge, protractor: description, uses and care.</li> <li>19. Cold chisels: materials, types, cutting angles, uses, care &amp; maintenance.</li> </ol>                                                                                                                                             |
| <b>WEEK 06</b> | <p>Auxiliary Marking &amp; Blueprint Reading:</p> <ol style="list-style-type: none"> <li>23. Marking according to simple blueprints for locating hole positions, scribing on chalked surfaces.</li> <li>24. Finding centre of round bar with the help of 'V' block and marking block.</li> <li>25. Joining straight line to an arc.</li> </ol>                                                                                                                                                              | <p>Marking Media &amp; Surface Plates:</p> <ol style="list-style-type: none"> <li>20. Marking media: marking blue, Prussian blue, red lead, chalk and special applications.</li> <li>21. Use, care and maintenance of scribing block.</li> <li>22. Surface plate and auxiliary marking equipment: 'V' block, angle plates, parallel blocks.</li> </ol>                                                                                                                                                               |
| <b>WEEK 07</b> | <p>Precision Filing &amp; Grooving:</p> <ol style="list-style-type: none"> <li>26. Chipping, Chamfering, Chip slots &amp; oil grooves (Straight).</li> <li>27. Filing flat, square, and parallel to an accuracy of 0.5mm.</li> <li>28. Chip curve along a line, mark out, cut keyways at various angles &amp; keyways.</li> <li>29. Sharpening of Chisel.</li> </ol>                                                                                                                                        | <p>Engineering Metals:</p> <ol style="list-style-type: none"> <li>23. Physical properties of engineering metals: colour, weight, structure, conductivity, magnetic, fusibility, specific gravity.</li> <li>24. Mechanical properties: ductility, malleability, hardness, brittleness, toughness, tenacity, elasticity.</li> </ol>                                                                                                                                                                                    |

| Week No.       | Professional Skills (Trade Practical)                                                                                                                                                                                                                                                                                                            | Professional Knowledge (Trade Theory)                                                                                                                                                                                                                                                                                           |
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| <b>WEEK 08</b> | Power Sawing & Step Filing:<br>30. File thin metal to an accuracy of 0.5 mm.<br>31. Saw along a straight line, curved line, on different sections of metal.<br>32. Straight saw on thick section, M.S. angle and pipes.<br>33. File steps and finish with smooth file to accuracy of $\pm 0.25$ mm.<br>34. File and saw on M.S. Square and pipe. | Power Saws & Micrometers:<br>25. Power Saw, band saw, Circular saw machines used for metal cutting.<br>26. Micrometer (outside and inside): principle, construction, graduation, reading, use and care.<br>27. Micrometer depth gauge and digital micrometer.                                                                   |
| <b>WEEK 09</b> | Radius Filing & Precision Instruments:<br>35. File radius along a marked line (Convex & concave) & match.<br>36. Chip sheet metal (shearing).<br>37. Chip step and file.                                                                                                                                                                         | Vernier Instruments:<br>28. Vernier calipers: principle, construction, graduations, reading, use and care, dial and digital Vernier calipers.<br>29. Vernier bevel protractor: construction, graduations, reading, use and care.<br>30. Vernier height gauge: material, construction, parts, graduations, care and maintenance. |
| <b>WEEK 10</b> | Basic Drilling & Tapping:<br>38. Mark off and drill through holes.<br>39. Drill and tap on M.S. flat.<br>40. Punch letter and number (letter punch and number punch).<br>41. Practice use of different punches.                                                                                                                                  | Drilling Machines & Tap Drill Size:<br>31. Drilling processes: bench type, pillar type, radial type, gang and multiple drilling machines.<br>32. Determination of tap drill size for metric and inch threads.                                                                                                                   |
| <b>WEEK 11</b> | Sheet Metal Marking & Shearing:<br>42. Marking of straight lines, circles, profiles and various geometrical shapes, cutting sheets with snips.<br>43. Marking out of simple development.<br>44. Marking out for flaps for soldering and sweating.                                                                                                | Sheet Metal Tools & Materials:<br>33. Safety precautions in sheet metal workshop.<br>34. Commercial sizes and types of metal sheets, coated sheets (BIS specifications).<br>35. Shearing machine: description, parts and uses.<br>36. Snips, wing compass, tin man's square, trammel, and sheet metal hammers/mallets.          |
| <b>WEEK 12</b> | Sheet Metal Joints & Seams:<br>45. Make various joints: wiring, hemming, form locked, grooved and knocked up single/double hem straight and curved edges.<br>46. Punch holes using hollow and solid punches.<br>47. Do lap and butt joints.                                                                                                      | Stakes & Sheet Metal Joints:<br>37. Hand groovers, sheet and wire gauge.<br>38. Stakes: bench types, parts and their uses.<br>39. Various types of metal joints: selection, application, and joint allowances.<br>40. Wired edges construction and allowances.                                                                  |
| <b>WEEK 13</b> | Sheet Metal Containers & Soldering:<br>48. Bend sheet metal into various curvatures, form wired edges, fold at angle using stakes.<br>49. Make simple Square container with wired edge and fix handle.<br>50. Make square tray with square soldered corner.<br>51. Practice in soft soldering and silver soldering.                              | Soldering & Brazing Theory:<br>41. Solder and soldering: types of solder and flux, composition of solders.<br>42. Heating media and soldering iron.<br>43. Method of soldering, selection and application of joints.<br>44. Hard solder and brazing techniques.                                                                 |
| <b>WEEK 14</b> | Riveting Operations:<br>52. Make riveted lap and butt joint.<br>53. Make funnel as per development and solder joints.<br>54. Drill for riveting.<br>55. Riveting with as many types of rivets as available, use of counter sunk head rivets.                                                                                                     | Riveting Theory:<br>45. Rivets: shapes, form of heads, tin man's rivets types and sizes.<br>46. Riveting tools: dolly, snaps, rivet set.<br>47. Spacing of rivets, pitch, flash riveting, comparison of hot and cold riveting.                                                                                                  |
| <b>WEEK 15</b> | Shielded Metal Arc Welding (SMAW):<br>56. Welding: striking and maintaining arc, laying straight-line bead.                                                                                                                                                                                                                                      | Arc Welding Principles:<br>48. Importance of safety and precautions in welding shop.<br>49. Precautions in electric welding (before, during, after) and safety gear.<br>50. Machines and accessories: welding transformer, welding generators, welding inverters.                                                               |
| <b>WEEK 16</b> | Gas Welding & Oxy-Acetylene Flame:<br>57. Making butt joint and corner joint with gas and arc.<br>58. Setting up of flames, fusion runs with and without filler rod.                                                                                                                                                                             | Oxy-Acetylene Welding Theory:<br>51. Welding hand tools: chipping hammer, wire brush, tongs.<br>52. HP and LP oxy-acetylene welding equipment.<br>53. Types of joints (Butt, Fillet as per BIS SP: 46-1988), gases and gas cylinders (DA, Oxygen).                                                                              |

| Week No.       | Professional Skills (Trade Practical)                                                                                                                                                                                                                                 | Professional Knowledge (Trade Theory)                                                                                                                                                                                                                                                                                                        |
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| <b>WEEK 17</b> | Arc Welded Joints & Gas Cutting:<br>59. Make butt weld, corner and fillet joints in arc welding.<br>60. Gas cutting of MS plates.                                                                                                                                     | Electrodes & Gas Cutting:<br>54. Setting parameters for arc welding, selection and storage of electrodes.<br>55. Oxygen acetylene cutting: machine description, cutting torch, parts, function and nozzle selection.                                                                                                                         |
| <b>WEEK 18</b> | Drill Geometry & Hole Finishing:<br>61. Mark off and drill through holes.<br>62. Drill on M.S. flat.<br>63. File radius and profile to suit gauge.<br>64. Sharpening of Drills.<br>65. Practice use of angular measuring instruments.                                 | Twist Drills & Drill Angles:<br>56. Drills: materials, types (taper shank, straight shank), parts and sizes.<br>57. Drill angles: cutting angle for materials, cutting speed, feed, RPM calculation.<br>58. Drill holding devices: sleeves, sockets, drill chucks.                                                                           |
| <b>WEEK 19</b> | Counter Sinking, Counter Boring & Reaming:<br>66. Counter sink, counter bore and ream split fit (three piece fitting).<br>67. Drill through hole and blind holes.                                                                                                     | Counter Sinking & Reamers:<br>59. Counter sink, counter bore and spot facing: nomenclature and tools.<br>60. Reamers: materials, types (hand and machine), hole size determination, reaming procedure.                                                                                                                                       |
| <b>WEEK 20</b> | Internal & External Threading:<br>68. Form internal threads with taps to standard size (through and blind holes).<br>69. Prepare studs and bolts.<br>70. Form external threads with dies to standard size.<br>71. Prepare nuts and match with bolts.                  | Screw Threads, Taps & Dies:<br>61. Screw threads: terminology, parts, types (BSW, BSF, BA, BSP, Metric).<br>62. Tap wrenches, extraction of broken taps and studs.<br>63. Dies and die stocks: types, materials, method of thread cutting.                                                                                                   |
| <b>WEEK 21</b> | Fitting Assembly & Grinding Operations:<br>72. File and make Step fit, angular fit, surfaces (Bevel gauge accuracy 1 degree).<br>73. Make simple open and sliding fits.<br>74. Enlarge hole and increase internal dia.<br>75. File cylindrical surfaces.              | Drill Troubles & Grinding Wheels:<br>64. Drill troubles: causes, remedies, equality of lips, lip clearance, grinding.<br>65. Grinding wheels: abrasives, grain, grade, structure, bond, mounting and dressing.<br>66. Bench grinder parts and safety.                                                                                        |
| <b>WEEK 22</b> | Profile Fitting & Inspection Gauges:<br>76. Make open fitting of curved profiles.<br>77. Correction of drill location by binding previously drilled hole.<br>78. Make inside square fit.                                                                              | Limit Gauges:<br>67. Gauges: introduction, necessity and types.<br>68. Limit gauges: Ring gauge, Snap gauge, Plug gauge (description and uses).<br>69. Feeler gauge, screw pitch gauge, radius gauge, wire gauge.                                                                                                                            |
| <b>WEEK 23</b> | Interchangeability & Sliding 'T' Fit:<br>79. Make sliding 'T' fit.<br>80. File fit combined, open angular and sliding sides.                                                                                                                                          | Limits, Fits & Tolerances:<br>70. Interchangeability: necessity, definition, BIS system.<br>71. Limits and fits terminology: basic size, actual size, deviation, tolerances, zero line.<br>72. Standard systems of fits: British standard, BIS system, types of fits (Clearance, Transition, Interference).                                  |
| <b>WEEK 24</b> | Angular Fit & Height Gauges:<br>81. File internal angles (30 minutes accuracy) open, angular fit.<br>82. Make sliding fit with angles other than 90°.                                                                                                                 | Ferrous & Non-Ferrous Metals:<br>73. Method of expressing tolerance as per BIS, description of fits with sketches.<br>74. Vernier height gauge: parts, graduations, care and maintenance.<br>75. Pig iron, Cast iron, Wrought iron, and Plain carbon steels.<br>76. Non-ferrous metals: copper, aluminium, tin, lead, zinc.                  |
| <b>WEEK 25</b> | Scraping & Bearing Surface Matching:<br>83. Scrap on flat surfaces, curved surfaces and parallel surfaces and test.<br>84. Make & assemble sliding flats, plain surfaces.<br>85. Check for blue match of bearing surfaces (both flat and curved) by Whitworth method. | Scrapers & Precision Measurement:<br>77. Scrapers: flat, half round, triangular, hook scraper and their uses.<br>78. Blue matching of scraped surfaces and testing without master plate.<br>79. Vernier micrometer and Screw thread micrometer: construction and calibration.<br>80. Mechanical fasteners: screws, bolts, collars and studs. |

| Week No.       | Professional Skills (Trade Practical)                                                                                                                                                                                                                                                                                                                                | Professional Knowledge (Trade Theory)                                                                                                                                                                                                                                                         |
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| <b>WEEK 26</b> | Precision Sliding Assembly & Dial Indicators:<br>86. File and fit combined radius and angular surface (accuracy $\pm 0.05$ mm).<br>87. Locate accurate holes & make accurate hole for stud fit.<br>88. Fasten sub-assemblies together using screws, bolts and collars.<br>89. Make sliding fits assembly with parallel and angular mating surfaces ( $\pm 0.04$ mm). | Dial Indicators & Comparators:<br>81. Dial test indicator: construction, parts, graduation, method of use and care.<br>82. Digital dial indicator and mechanical comparators.<br>83. Bore gauges for checking cylinder bore quality.                                                          |
| <b>WEEK 27</b> | Lathe Setup & Chuck Mounting:<br>90. Lathe operations induction.<br>91. True job on four-jaw chuck using knife tool.<br>92. Face both ends for holding between centres.                                                                                                                                                                                              | Lathe Fundamentals:<br>84. Safety precautions while working on lathe machine.<br>85. Lathe specifications and main parts: bed, headstock, carriage, tailstock, feed mechanism.<br>86. Holding jobs between centres, catch plates, carriers/dogs, facing and roughing tools.                   |
| <b>WEEK 28</b> | Plain & Step Turning on Lathe:<br>93. Using roughing tool, parallel turn $\pm 0.1$ mm.<br>94. Measure diameter using outside caliper and steel rule.<br>95. Holding job in three-jaw chuck.<br>96. Perform facing, plain turn, step turn, parting, deburring, chamfering.                                                                                            | Lathe Cutting Tools & Speeds:<br>87. Nomenclature of single point cutting tools, rake angles, clearance angles.<br>88. Solid, brazed tipped and indexable throw-away carbide tools.<br>89. Cutting speed, feed, depth of cut calculations for HSS and carbide tools, coolants and lubricants. |
| <b>WEEK 29</b> | Shoulder Turning & Grooving:<br>97. Shoulder turn: square, filleted, bevelled, undercut shoulder turning.<br>98. Sharpening of single-point tools.<br>99. Cut grooves: square, round, 'V' groove.                                                                                                                                                                    | Chucks, Face Plates & Grooving Tools:<br>90. Three-jaw and four-jaw chucks: mounting/dismounting and jaw reversal.<br>91. Face plates, angle plates, and lathe mandrels.<br>92. Under-cutting and grooving tools geometry.                                                                    |
| <b>WEEK 30</b> | Knurling & Boring Operations:<br>100. Knurl the job.<br>101. Bore holes: spot face, pilot drill, enlarge hole using boring tools.                                                                                                                                                                                                                                    | Knurling & Boring Principles:<br>93. Knurling: types of knurling tools, grades, speeds, feeds, and applications.<br>94. Drilling on lathe and boring tools for enlargement of internal holes.                                                                                                 |
| <b>WEEK 31</b> | Taper Turning:<br>102. Turn taper (internal and external).<br>103. Turn taper pins.<br>104. Turn standard tapers to suit gauge.                                                                                                                                                                                                                                      | Taper Calculations:<br>95. Taper: definition, methods of expressing tapers, Morse tapers.<br>96. Taper turning methods: form tool, compound rest swivelling, tailstock offset, and taper attachment.<br>97. Calculations for compound rest swivelling angle and tailstock offset.             |
| <b>WEEK 32</b> | Lathe Screw Cutting:<br>105. Practice threading using taps and dies on lathe by hand.<br>106. Make external 'V' thread on lathe.<br>107. Prepare a nut and match with bolt.                                                                                                                                                                                          | Screw Cutting Mechanisms:<br>98. Screw thread profiles: V-thread, Acme, Buttress, Square, Worm.<br>99. Principle of screw cutting on lathe, lead screw and half-nut mechanism.<br>100. Gear train calculations for metric and English pitch, tool setting with centre gauge.                  |
| <b>WEEK 33</b> | Machine Maintenance & Fault Rectification:<br>108. Simple assembly of machine parts from blueprints.<br>109. Rectify possible assembly faults during assembly.                                                                                                                                                                                                       | Preventive & Routine Maintenance:<br>101. Total Productive Maintenance (TPM) and Autonomous maintenance.<br>102. Routine maintenance checklists and maintenance schedules.<br>103. Preventive maintenance: objectives, inspection procedures, and lubrication surveys.                        |
| <b>WEEK 34</b> | Pneumatic Pressure & Monitoring:<br>110. Perform routine maintenance with check list.<br>111. Monitor machine as per routine checklist.<br>112. Read pressure gauge, temperature gauge, oil level.<br>113. Set pressure in pneumatic system.                                                                                                                         | Lubrication & Industrial Equipment:<br>104. Lubrication systems, symbols, colour coding, and lubricants classification.<br>105. Use of engineering handbooks and reference tables for assembly fits.<br>106. Assembly failures: causes, diagnostics, and remedies.                            |

| Week No.       | Professional Skills (Trade Practical)                                                                                                                                            | Professional Knowledge (Trade Theory)                                                                                                                                                     |
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| <b>WEEK 35</b> | Dowel Pins & Precision Fastening:<br>114. Assemble simple fitting using dowel pins and tap screw assembly using torque wrench.                                                   | Assembly Techniques:<br>107. Assembling techniques: aligning, mechanical jointing, sealing, torquing.<br>108. Dowel pins: materials, construction, types, accuracy, extraction, and uses. |
| <b>WEEK 36</b> | Overhauling Drilling Machines & Power Saws:<br>115. Routine overhauling, belt tension adjustment, spindle alignment, and lubrication of sensitive drill machines and power saws. | Machine Overhauling Principles:<br>109. Constructional layout, maintenance points, and breakdown repair of pillar drill and power saw machines.                                           |
| <b>WEEK 37</b> | Overhauling Bench Grinder & Lathe:<br>116. Inspect lathe headstock, carriage gibs, lead screw alignment, bench grinder wheel flanges, and tool rest adjustments.                 | Machine Alignment & Safety:<br>110. Alignment tests of lathe machines (leveling, spindle run-out), gib adjustment, and bench grinder safety regulations.                                  |
| <b>WEEK 38</b> | Comprehensive Mechanical Inspection:<br>117. Inspection of assembled sub-units, measuring dimensional accuracy with vernier, micrometer, dial test indicators, and limit gauges. | Quality Control & Inspection:<br>111. Total quality control, inspection techniques, tolerance compliance, and rejection analysis in machine shop assemblies.                              |
| <b>WEEK 39</b> | On the Job Training (OJT) / Group Project Work                                                                                                                                   | On the Job Training (OJT) / Group Project Work                                                                                                                                            |
| <b>WEEK 40</b> | On the Job Training (OJT) / Group Project Work                                                                                                                                   | On the Job Training (OJT) / Group Project Work                                                                                                                                            |
| <b>WEEK 41</b> | On the Job Training (OJT) / Group Project Work                                                                                                                                   | On the Job Training (OJT) / Group Project Work                                                                                                                                            |
| <b>WEEK 42</b> | On the Job Training (OJT) / Group Project Work                                                                                                                                   | On the Job Training (OJT) / Group Project Work                                                                                                                                            |

#### APPROVAL & SIGNATURES

|                                              |                                                                         |                                                                  |
|----------------------------------------------|-------------------------------------------------------------------------|------------------------------------------------------------------|
| _____                                        | _____                                                                   | _____                                                            |
| <b>Sign of Instructor<br/>(Fitter Trade)</b> | <b>Sign of Group Instructor (GI)<br/>(Mechanical / Fitting Section)</b> | <b>Sign of Superintendent / Principal<br/>(Govt. / Pvt. ITI)</b> |