

Workorder 64880/3.0	Part ID	Qty 1	Drawing ID / Rev /	Engineer BLUE/DOUG MCCORKLE
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Manufacturing Tooling / Non-Recurring

Sub ID 0	Part ID Manufacturing Tooling / Non-Recurring	Qty 1	Drawing ID / Rev /
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Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev				
Sub: 0 / Seq: 10 (R)	700-BLUE TEAM, ENGINEERING ENGINEERING	1.00	1.00	1.00					
	IDC Count : 0		Dwg Count: 0		Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0	
Piece #	Part ID		Qty	Drawing ID / Rev	Vendor	Dimensions			
50	E71T-1_045_FCAW-WELD WIRE,FCAW .045 DIA Vendor Part ID: E71T-1_045_FCAW		0.0						
(C)							QAP Count: 0		
Piece #	Part ID		Qty	Drawing ID / Rev	Vendor	Dimensions			
60	ER308L_093_GTAW-WELD WIRE,GTAW .093 DIA Vendor Part ID: ER308L_093_GTAW Mfg Part ID: ER308L		0.0						
(C)							QAP Count: 0		
Piece #	Part ID		Qty	Drawing ID / Rev	Vendor	Dimensions			
70	3M Scotch Weld two part epoxy McMaster-Carr 75045A67 (4 one quart kits) MTM Receiving note: deliver to Doug McCorkle		4.0						
(C)							QAP Count: 0		
Piece #	Part ID		Qty	Drawing ID / Rev	Vendor	Dimensions			
80	E308LT1-1_045_FCAW-WELD WIRE, FCAW, .045 DIA Vendor Part ID: E308LT1-1_045_FCAW Mfg Part ID: E308LT1-1 FLUX CORE		0.0						
(C)							QAP Count: 0		

Sub ID 1	Part ID MAGNETIC PROPERTIES MEASUREMEN	Qty 1	Drawing ID / Rev /
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Workorder 64880/3.0	Part ID	Qty 1	Drawing ID / Rev /	Engineer BLUE/DOUG MCCORKLE
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Parent Sub:0 Op:10

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev				
Sub: 1 / Seq: 10 (C)	820-RECEIVING INSPECTION RECEIVE AND INSPECT PERMEABILITY MEASURING GAGE PER MTM PURCHASE ORDER. NOTIFY ENGINEERING (DOUG McCORKLE) UPON ARIVAL.	1.00	1.00	1.00					
	Drw N/A	IDC N/A	IDC Count : 0	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0	
Piece # 10 (C)	Part ID PERMEABILITY METER FERROMASTER WITH CALIBRATION CHECK SAMPLE AND LEATHER CASE STEFAN MAYER INSTRUMENTS DIPL. PHYS. DR. STEFAN MAYER GARTENSTR. 2 D-46535 DINSLAKEN GERMANY PHONE: / FAX +49 2064 479762/3 EMAIL: MAIL@STEFAN-MAYER.COM WEBSITE: WWW.STEFAN-MAYER.COM	Qty 1.0	Drawing ID / Rev	Vendor	Dimensions				

QAP Count: 0

Sub ID 2	Part ID FABRICATION / INSPECTION FIXTU	Qty 1	Drawing ID / Rev /
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Parent Sub:0 Op:10

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev				
Sub: 2 / Seq: 5 (R)	753-CAD/CAM - LARGE MILLING N/C PROGRAMMING NOTIFY DOUG McCORKLE PRIOR TO BEGINNING FOR DETAILED INSTRUCTIONS	1.00	1.00	1.00	MTMFX-2894 / 2A				
	IDC N/A	IDC Count : 0	Dwg Count: 1	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0		

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev				
Sub: 2 / Seq: 10 (C)	230-FABRICATION - WEIDNER LOCATE AND WELD THE BASE PLATE TO THE TUBE FRAME STRUCTURE (NOTE: POSITION WELDS SO THEY CAN BE EASILY REMOVED LATER).	1.00	1.00	1.00	MTMFX-2894 / 2A				
	IDC N/A	IDC Count : 0	Dwg Count: 1	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 5		
	WPS190 Rev:1 FCAW SEM----WPS192 Rev:2 GTAW MAN---WPS355.1 Rev:1 GTAW MAN---WPS385 Rev:0 FCAW SEM----WPS386 Rev:0 GTAW GTAW - Manual Fillers: ER308L_045_GMAW / ER308L_062_GTAW / ER308L_093_GTAW GTAW - Manual Fillers: ER309L_045_GMAW / ER309L_062_GTAW / ER309L_093_GTAW GTAW - Manual Fillers: ER70S-2_035_GTAW / ER70S-2_045_GMAW / ER70S-2_062_GMAW / ER70S-2_062_GTAW / ER70S-2_093_GMAW / ER70S-2_093_GTAW FCAW - Semi-automatic Fillers: TEST FCAW - Semi-automatic Fillers: E309LT1-1_045_FCAW								

Workorder: 64880/3.0 Part ID: Qty: 1 Drawing ID / Rev: / Engineer: BLUE/DOUG MCCORKLE

FCAW - Semi-automatic Fillers: TEST
 FCAW - Semi-automatic Fillers: E70T-1_045_FCAW / E70T-1_062_FCAW / E70T-1_093_FCAW
 Notes:
 GUSSETS TO TUBE

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev			
Sub: 2 / Seq: 20 (C)	134-FRORIEP SETUP FIXTURE BASE PLATE AND FACE OFF THE TOP SURFACE FLAT. SCRIBE LOCATIONS FOR THE (4) RECTANGULAR RISER BLOCKS AND (1) PORT LOCATOR POST PER DRAWING AND CAD MODEL.	1.00	1.00	1.00	MTMFX-2894 / 2A			
	IDC N/A IDC Count : 0		Dwg Count: 1	Pgm Count: 3	QAP Count: 0	NDT Count: 0	WPS Count: 0	

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev			
Sub: 2 / Seq: 24 (C)	230-FABRICATION - WEIDNER PER MACHINE SHOP SCRIBE LINES LOCATE AND WELD ON THE (4) RECTANGULAR RISER BLOCKS AND THE (1) ROUND PORT LOCATOR POST.	1.00	1.00	1.00	MTMFX-2894 / 2A			
	IDC N/A IDC Count : 0		Dwg Count: 1	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0	

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev			
Sub: 2 / Seq: 26 (C)	134-FRORIEP SETUP FIXTURE AND MACHINE THE TOPS OF THE (4) RECTANGULAR RISERS, THE (4) CORNER SMX LOCATOR POCKETS, THE (1) ROUND PORT LOCATOR POST PER THE DRAWING AND CAD MODEL.	1.00	1.00	1.00	MTMFX-2894 / 2A			
	INSTALL ALL OF THE HOLES PER DRAWING. IDC N/A IDC Count : 0		Dwg Count: 1	Pgm Count: 3	QAP Count: 0	NDT Count: 0	WPS Count: 0	

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev			
Sub: 2 / Seq: 40 (C)	230-FABRICATION - WEIDNER ASSEMBLE FIXTURE TOGETHER USING SCREWS AND DOWELS.	1.00	1.00	1.00	MTMFX-2894 / 2A			
	IDC N/A IDC Count : 0		Dwg Count: 1	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0	

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10 (C)	HHCS .50-13UNC-2B X 1.5" LG SST DELIVER TO DOUG McCORKLE UPON RECEIPT	12.0			
				QAP Count: 0	

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
20 (C)	1/2" DOWEL PIN X 1.75" LONG SST	2.0			

Workorder 64880/3.0	Part ID	Qty 1	Drawing ID / Rev /	Engineer BLUE/DOUG MCCORKLE
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QAP Count: 0

Piece # 30 (C)	Part ID 3/4"-10 HHCS X 2.25" LONG SST (300 SERIES)	Qty 8.0	Drawing ID / Rev	Vendor	Dimensions
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QAP Count: 0

Piece # 40 (C)	Part ID .750" DIA. DOWELS SST (300 SERIES) X 2"	Qty 2.0	Drawing ID / Rev	Vendor	Dimensions
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QAP Count: 0

Operation Sub: 2 / Seq: 50 (C)	Resource 815-CMM - GANTRY - PLANT 2 VERIFY FIXTURE GEOMETRY (100% DIMENSIONAL) PER DRAWING / 3D MODEL. GENERATE REPORT AND FORWARD TO ENGINEERING.	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev MTMFX-2894 / 2A	IDC N/A	IDC Count : 0	Dwg Count: 1	Pgm Count: 1	QAP Count: 0	NDT Count: 0	WPS Count: 0
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Sub ID 4	Part ID TUBING FOR BASE	Qty 1	Drawing ID / Rev / Parent Sub:2 Op:10
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Operation Sub: 4 / Seq: 10 (C)	Resource 405-SAWS- PLANT 2 SAW / DEBURR TUBING PER MATERIAL CARDS IDC Count : 0	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev SE121 / A	Dwg Count: 5	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0
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Piece # 10 (C)	Part ID A500 GR B_72-TUBE,SQUARE,HR. 4.0" X .25" WALL Vendor Part ID: A500 GR B_72 Mfg Part ID: A500 GR B A500 GR B TUBE,SQUARE,HR. 4.0" X .25" WALL CERTS & MILL TEST REPORTS REQUIRED WITH SHIPMENT. STOCK SIZE 40 FT	Qty 148.0	Drawing ID / Rev	Vendor 5068	Dimensions 74
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QAP Count: 0

Piece # 20 (C)	Part ID A500 GR B_72-TUBE,SQUARE,HR. 4.0" X .25" WALL Vendor Part ID: A500 GR B_72 Mfg Part ID: A500 GR B A500 GR B TUBE,SQUARE,HR. 4.0" X .25" WALL	Qty 216.0	Drawing ID / Rev	Vendor 5068	Dimensions 72
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CERTS & MILL TEST REPORTS REQUIRED WITH SHIPMENT.
STOCK SIZE 40 FT

QAP Count: 0

Sub ID 10	Part ID RISERS SUB-ASSEMBLIES	Qty 1	Drawing ID / Rev / Parent Sub:2 Op:10
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Operation Sub: 10 / Seq: 10 (C)	Resource 230-FABRICATION - WEIDNER INSTALL AND WELD TOP PLATES TO TUBES. IDC Count : 0	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 2
<p>WPS385 Rev:0 FCAW SEM---WPS386 Rev:0 GTAW MAN GTAW - Manual Fillers: ER309L_045_GMAW / ER309L_062_GTAW / ER309L_093_GTAW FCAW - Semi-automatic Fillers: TEST FCAW - Semi-automatic Fillers: E309LT1-1_045_FCAW FCAW - Semi-automatic Fillers: TEST Notes:</p>										

Sub ID 11	Part ID TUBING FOR RISERS	Qty 1	Drawing ID / Rev / Parent Sub:10 Op:10
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Operation Sub: 11 / Seq: 10 (C)	Resource 405-SAWS- PLANT 2 SAW AND DEBURR TUBES PER MATERIAL CARDS IDC Count : 0	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0
Piece # 10	Part ID A500 GR B_72-TUBE,SQUARE,HR. 4.0" X .25" WALL Vendor Part ID: A500 GR B_72 Mfg Part ID: A500 GR B	Qty 11.8	Drawing ID / Rev	Vendor 5068	Dimensions 11.75					
(C)	A500 GR B TUBE,SQUARE,HR. 4.0" X .25" WALL CERTS & MILL TEST REPORTS REQUIRED WITH SHIPMENT. STOCK SIZE 40 FT									
									QAP Count: 0	

Piece # 20	Part ID A500 GR B_72-TUBE,SQUARE,HR. 4.0" X .25" WALL Vendor Part ID: A500 GR B_72 Mfg Part ID: A500 GR B	Qty 21.8	Drawing ID / Rev	Vendor 5068	Dimensions 21.75
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Workorder 64880/3.0 Part ID Qty Drawing ID / Rev Engineer BLUE/DOUG MCCORKLE

(C) A500 GR B
TUBE,SQUARE,HR. 4.0" X .25" WALL
CERTS & MILL TEST REPORTS REQUIRED WITH SHIPMENT.
STOCK SIZE 40 FT

QAP Count: 0

Piece # Part ID Qty Drawing ID / Rev Vendor Dimensions
30 A500 GR B_72-TUBE,SQUARE,HR. 4.0" X .25" WALL 24.0 5068 24

Vendor Part ID: A500 GR B_72
Mfg Part ID: A500 GR B

(C) A500 GR B
TUBE,SQUARE,HR. 4.0" X .25" WALL
CERTS & MILL TEST REPORTS REQUIRED WITH SHIPMENT.
STOCK SIZE 40 FT

QAP Count: 0

Piece # Part ID Qty Drawing ID / Rev Vendor Dimensions
40 A500 GR B_72-TUBE,SQUARE,HR. 4.0" X .25" WALL 16.0 5068 16

Vendor Part ID: A500 GR B_72
Mfg Part ID: A500 GR B

(C) A500 GR B
TUBE,SQUARE,HR. 4.0" X .25" WALL
CERTS & MILL TEST REPORTS REQUIRED WITH SHIPMENT.
STOCK SIZE 40 FT

QAP Count: 0

Sub ID 12 Part ID PLATES AND GUSSETS FOR RISERS Qty 1 Drawing ID / Rev / Parent Sub:10 Op:10

Operation Resource QtyPer StartQty EndQty Drawing ID / Rev
Sub: 12 / Seq: 10 410-BURNOUT TABLE 1.00 1.00 1.00 MTMFX-2894 / 2A
(C) NEST AND BURNOUT TOP PLATE AND GUSSET DETAILS PER DRAWING. QUANTITIES AS FOLLOWS:
1 PIECE EACH OF THE FOLLOWING:
DETAILS 8 THROUGH 11, 14 THROUGH 17, 20 THROUGH 23.

IDC Count : 0 Dwg Count: 1 Pgm Count: 0 QAP Count: 0 NDT Count: 0 WPS Count: 0

Piece # Part ID Qty Drawing ID / Rev Vendor Dimensions
10 304_11-PLATE,SST 1.0" THK 74.3 7750 4.5*5.5

Vendor Part ID: 304_11
Mfg Part ID: 304 MATERIAL

(C) 304 MATERIAL
PLATE, STAINLESS, 1.0" THK
CERTS & MILL TEST REPORTS REQUIRED WITH SHIPMENT.

QAP Count: 0

Workorder 64880/3.0	Part ID	Qty 1	Drawing ID / Rev /	Engineer BLUE/DOUG MCCORKLE
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Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
20	304_14-PLATE,SST 1.5" THK Vendor Part ID: 304_14 Mfg Part ID: 304 MATERIAL	25.0		7750	5*5
(C)	304 MATERIAL PLATE, STAINLESS, 1.5" THK CERTS & MILL TEST REPORTS REQUIRED WITH SHIPMENT.				
QAP Count: 1					

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
30	304L_5-PLATE,SST .5" THK Vendor Part ID: 304L_5 Mfg Part ID: 304L STAINLESS	568.0		1810	568
(C)	PLATE, 304L STAINLESS STEEL .5" THK CERTS & MILL TEST REPORT REQ'D WITH SHIPMENT.				
QAP Count: 0					

Sub ID 13	Part ID TOP SUPPORT DETAIL	Qty 1	Drawing ID / Rev MTMFX-2894 / A1 Parent Sub:2 Op:10
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Operation Sub: 13 / Seq: 10 (C)	Resource 410-BURNOUT TABLE BURNOUT SHAPE PER PROVIDED GEOMETRY IDC Count : 0	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev MTMFX-2894 / 2A Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0
Piece # 10	Part ID 304_13-PLATE,SST 1.25" THK Vendor Part ID: 304_13 Mfg Part ID: 304 MATERIAL			Qty 1,914.0	Drawing ID / Rev	Vendor 7750	Dimensions 1914	
(C)	304 MATERIAL PLATE, STAINLESS, 1.25" THK CERTS & MILL TEST REPORTS REQUIRED WITH SHIPMENT.							QAP Count: 0

Sub ID 14	Part ID TEMPORARY ALIGMENT BAR (SHOP A)	Qty 1	Drawing ID / Rev / Parent Sub:2 Op:10
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Operation Sub: 14 / Seq: 10 (C)	Resource 108-TOOL ROOM - PLANT 1 TURN ONE END TO POINT PER ENGINEERING DIRECTION (CONTACT DOUG McCORKLE FOR DETAILS).	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev
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Workorder 64880/3.0	Part ID	Qty 1	Drawing ID / Rev /	Engineer BLUE/DOUG MCCORKLE
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	IDC Count : 0	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0
Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions	
10	316L_100-BAR,ROUND,SST 1.25" DIA Vendor Part ID: 316L_100	61.0		7750	61	
(C)	316L STAINLESS BAR, ROUND 1.25" DIA. CERTIFICATION AND MATERIAL TEST REPORT REQUIRED WITH SHIPMENT. ANNEALED,COLD FINISHED					
	Material Certification:					
				QAP Count: 1		

Sub ID 15	Part ID BASE PLATE	Qty 1	Drawing ID / Rev /	Parent Sub:2 Op:10
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Operation Sub: 15 / Seq: 10	Resource 800-RECEIVING	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev				
(C)	VERIFY RECTANGLE PER MATERIAL CARD AND MOVE								
	IDC Count : 0	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0			
Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions				
10	304L_15-PLATE,SST 2.0" THK Vendor Part ID: 304L_15 Mfg Part ID: 304L STAINLESS	5,920.0		1810	74*80				
(C)	PLATE, 304L STAINLESS STEEL 2.0" THK CERTS & MILL TEST REPORT REQ'D WITH SHIPMENT.								
				QAP Count: 2					

Sub ID 17	Part ID TABS FOR TUBE TO BASEPLATE (TO	Qty 1	Drawing ID / Rev /	Parent Sub:2 Op:10
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Operation Sub: 17 / Seq: 10	Resource 405-SAWS- PLANT 2	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev				
(C)	SAW AND DEBURR TABS PER MATERIAL CARD								
	IDC Count : 0	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0			
Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions				
10	304_802-BAR,FLAT,SST .5" X .75" Vendor Part ID: 304_802 Mfg Part ID: 304 MATERIAL	60.0		5068	2				
(C)	BAR,FLAT,SST. .5" X .75"								
				QAP Count: 0					

Workorder 64880/3.0	Part ID	Qty 1	Drawing ID / Rev /	Engineer BLUE/DOUG MCCORKLE
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Sub ID 26	Part ID PORT LOCATOR POST	Qty 1	Drawing ID / Rev /	Parent Sub:2 Op:24
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Operation Sub: 26 / Seq: 10 (C)	Resource 405-SAWS- PLANT 2 SAW BAR TO LENGTH PER MATERIAL CARD.	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev MTMFX-2894 / 2A				
	IDC Count : 0		Dwg Count: 1		Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0	
Piece # 10	Part ID 316-L_340-BAR,ROUND,SST 3.75" RD Vendor Part ID: 316-L_340 Mfg Part ID: 316-L MATERIAL			Qty 17.0	Drawing ID / Rev	Vendor 7750	Dimensions 17		
(C)	316-L MATERIAL BAR,ROUND,SST. 3.75" RD.								QAP Count: 0

Sub ID 27	Part ID RECTANGULAR RISERS	Qty 4	Drawing ID / Rev /	Parent Sub:2 Op:24
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Operation Sub: 27 / Seq: 10 (C)	Resource 410-BURNOUT TABLE BURNOUT (4) PIECES 1.5 X 3.25 X 20.0	QtyPer 4.00	StartQty 4.00	EndQt 4.00	Drawing ID / Rev MTMFX-2894 / 2A				
	IDC Count : 0		Dwg Count: 1		Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0	
Piece # 10	Part ID 316L_15-PLATE,SST 1.5" THK Vendor Part ID: 316L_15			Qty 260.0	Drawing ID / Rev	Vendor 5068	Dimensions 3.25*20		
(C)	FIXTURE MATERIAL								QAP Count: 0

Sub ID 23	Part ID REMOVABLE TOP SECTION OF FIXTU	Qty 1	Drawing ID / Rev /	Parent Sub:2 Op:40
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Operation Sub: 23 / Seq: 10 (C)	Resource 230-FABRICATION - WEIDNER USE TEMPLATE PROVIDED BY ENGINEERING TO LOCATE THE (4) ROUND RISERS IN POSITION ON THE MIDDLE PLATE. WELD (4) ROUND RISERS TO MIDDLE PLATE AS SHOWN ON DRAWING.	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev MTMFX-2894 / 2A				
	IDC Count : 0		Dwg Count: 1		Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 2	

Workorder 64880/3.0	Part ID	Qty 1	Drawing ID / Rev /	Engineer BLUE/DOUG MCCORKLE
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WPS353.1 Rev:0 FCAW SEM---WPS355.1 Rev:1 GTAW MAN
 GTAW - Manual Fillers: ER308L_045_GMAW / ER308L_062_GTAW / ER308L_093_GTAW
 FCAW - Semi-automatic Fillers: E308LT0-1_035_FCAW / E308LT0-1_045_FCAW
 FCAW - Semi-automatic Fillers: E308LT1-1_035_FCAW / E308LT1-1_045_FCAW / E308LT1-1_062_FCAW
 FCAW - Semi-automatic Fillers: E308LT1-4_045_FCAW
 Notes: FIXTURING (FILLET WELDS)

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev					
Sub: 23 / Seq: 20 (C)	160-30FT MITSU	1.00	1.00	1.00	MTMFX-2894 / 2A					
SETUP MIDDLE PLATE WITH (4) ROUND RISERS WELDED ON. INDICATE IN BEST CONDITION WITH RESPECT TO THE ROUND RISERS FOR LOCATION.										
INSTALL ALL OF THE SCREW CLEARANCE HOLES AND THE DOWEL HOLES PER DRAWING.										
MACHINE A QUALIFIER CUT SOMEWHERE INSIDE THE CLEARANCE OPENING IN THE MIDDLE OF THE PLATE TO AID IN SETTING UP THE FIXTURE FOR MORE MACHINING LATER.										
MACHINE THE TOPS OF ALL (4) RISERS TO MATCH THE DRAWING. CONTACT THE WELD SHOP TO ADD BRACES TO THE RISERS IF NECESSARY.										
		IDC Count : 0	Dwg Count: 1	Pgm Count: 6	QAP Count: 0	NDT Count: 0	WPS Count: 0			

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev					
Sub: 23 / Seq: 30 (C)	230-FABRICATION - WEIDNER	1.00	1.00	1.00	MTMFX-2894 / 2A					
USE TEMPLATE PROVIDED BY ENGINEERING TO LOCATE THE TOP PLATE TO THE MIDDLE PLATE AND RISERS.										
WELD TOP PLATE ONTO THE ROUND RISERS AS SHOWN ON DRAWING.										
		IDC Count : 0	Dwg Count: 1	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 2			
WPS353.1 Rev:0 FCAW SEM---WPS355.1 Rev:1 GTAW MAN GTAW - Manual Fillers: ER308L_045_GMAW / ER308L_062_GTAW / ER308L_093_GTAW FCAW - Semi-automatic Fillers: E308LT0-1_035_FCAW / E308LT0-1_045_FCAW FCAW - Semi-automatic Fillers: E308LT1-1_035_FCAW / E308LT1-1_045_FCAW / E308LT1-1_062_FCAW FCAW - Semi-automatic Fillers: E308LT1-4_045_FCAW Notes: FIXTURING (FILLET WELDS)										

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev					
Sub: 23 / Seq: 40 (C)	160-30FT MITSU	1.00	1.00	1.00	MTMFX2894 / 2A					
SETUP THE REMOVABLE TOP SECTION SUBASSEMBLY USING PREVIOUSLY CUT QUALIFIERS AND INSTALLED HOLES.										
CONTOUR MACHINE THE SUBASSEMBLY CONTACT SURFACES PER THE DRAWING.										
IF NECESSARY, WELD BRACING IN PLACE PER WPS (STAINLESS MATERIAL ONLY)										

Workorder 64880/3.0	Part ID	Qty 1	Drawing ID / Rev /	Engineer BLUE/DOUG MCCORKLE		
IDC Count : 0 Dwg Count: 0 Pgm Count: 0 QAP Count: 0 NDT Count: 0 WPS Count: 1 WPS355.1 Rev:1 GTAW MAN GTAW - Manual Fillers: ER308L_045_GMAW / ER308L_062_GTAW / ER308L_093_GTAW Notes: BRACING						

Sub ID 24	Part ID ROUND RISERS	Qty 1	Drawing ID / Rev /	Parent Sub:23 Op:10		
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Operation Sub: 24 / Seq: 10 (C)	Resource 405-SAWS- PLANT 2 SAW (4) BARS TO LENGTH PER DRAWING. DETAIL 7-10.	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev MTMFX-2894 / 2A		
IDC Count : 0 Dwg Count: 1 Pgm Count: 0 QAP Count: 0 NDT Count: 0 WPS Count: 0							
Piece # 10 (C)	Part ID 316-L_340-BAR,ROUND,SST 3.75" RD Vendor Part ID: 316-L_340 Mfg Part ID: 316-L MATERIAL 316-L MATERIAL BAR,ROUND,SST. 3.75" RD.	Qty 84.5	Drawing ID / Rev	Vendor 7750	Dimensions 84.5		
		QAP Count: 0					

Sub ID 25	Part ID MIDDLE PLATE	Qty 1	Drawing ID / Rev /	Parent Sub:23 Op:10		
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Operation Sub: 25 / Seq: 10 (C)	Resource 410-BURNOUT TABLE BURNOUT MIDDLE PLATE DETAIL PER GEOMETRY PROVIDED BY ENGINEERING.	QtyPer 1.00	StartQty 1.00	EndQt 1.00	Drawing ID / Rev MTMFX-2894 / 2A		
IDC Count : 0 Dwg Count: 1 Pgm Count: 0 QAP Count: 0 NDT Count: 0 WPS Count: 0							
Piece # 10 (C)	Part ID 304L_12-PLATE,SST 1.25" THK Vendor Part ID: 304L_12 Mfg Part ID: 304L MATERIAL PLATE, 304L STAINLESS STEEL 1.25" THK CERTS & MILL TEST REPORT REQ'D WITH SHIPMENT.	Qty 4,320.0	Drawing ID / Rev	Vendor 1810	Dimensions 60*72		
		QAP Count: 1					

Sub ID 16	Part ID U-T CALIBRATION BLOCK (625 IN	Qty 1	Drawing ID / Rev /				
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Workorder 64880/3.0	Part ID	Qty 1	Drawing ID / Rev /	Engineer BLUE/DOUG MCCORKLE
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Parent Sub:0 Op:10

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev				
Sub: 16 / Seq: 10 (C)	800-RECEIVING recieve, verify certs & move	1.00	1.00	1.00					
		IDC Count : 0	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0		
Piece #	Part ID		Qty	Drawing ID / Rev	Vendor	Dimensions			
10	INCONEL 625_2-PLATE,NICKEL ALLOY .75" THK Vendor Part ID: INCONEL 625_2 Mfg Part ID: INCONEL 625		11.3		1810	1.875*6			
(C)	INCONEL 625 PLATE,NICKEL ALLOY .75" THK CERTS & MILL TEST REPORTS REQ'D WITH SHIPMENT.								
					QAP Count: 1				

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev				
Sub: 16 / Seq: 20 (C)	108-TOOL ROOM - PLANT 1 MACHINE / GRIND PER ENGINEERING SKETCH (PROVIDED BY DOUG McCORKLE)	1.00	1.00	1.00					
		IDC Count : 0	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0		

Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev				
Sub: 16 / Seq: 30 (R)	805-INPROCESS INSPECTION - PLA INSPECT / CALIBRATE / LOG GAGE PERMANENTLY MARK FOLLOWING INFORMATION ON THE GAGE: GAGE NUMBER MATERIAL TYPE MATERIAL HEAT LOT NUMBER ACTUAL THICKNESS OF EACH STEP NOTIFY DOUG McCORKLE WHEN COMPLETE	1.00	1.00	1.00					
		IDC Count : 0	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0		