

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

<b>Sub ID</b> 0	<b>Part ID</b> Manufacturing Tooling / Non-Recurring	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /
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<b>Operation</b>	<b>Resource</b>	<b>QtyPer</b>	<b>StartQty</b>	<b>EndQt</b>	<b>Drawing ID / Rev</b>				
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	
<b>Piece #</b>	<b>Part ID</b>		<b>Qty</b>	<b>Drawing ID / Rev</b>	<b>Vendor</b>	<b>Dimensions</b>			
50	E71T-1_045_FCAW-WELD WIRE,FCAW .045 DIA Vendor Part ID: E71T-1_045_FCAW		0.0						
(C)							QAP Count: 0		
<b>Piece #</b>	<b>Part ID</b>		<b>Qty</b>	<b>Drawing ID / Rev</b>	<b>Vendor</b>	<b>Dimensions</b>			
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		
<b>Piece #</b>	<b>Part ID</b>		<b>Qty</b>	<b>Drawing ID / Rev</b>	<b>Vendor</b>	<b>Dimensions</b>			
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		
<b>Piece #</b>	<b>Part ID</b>		<b>Qty</b>	<b>Drawing ID / Rev</b>	<b>Vendor</b>	<b>Dimensions</b>			
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		

<b>Sub ID</b> 1	<b>Part ID</b> MAGNETIC PROPERTIES MEASUREMEN	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /
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<b>Workorder</b> 64880/3.0	<b>Part ID</b>	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	<b>Engineer</b> 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		
<b>Piece #</b> 10 (C)	<b>Part ID</b> 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		<b>Qty</b> 1.0	<b>Drawing ID / Rev</b>	<b>Vendor</b>	<b>Dimensions</b>			

QAP Count: 0

<b>Sub ID</b> 2	<b>Part ID</b> FABRICATION / INSPECTION FIXTU	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /
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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 / ER308L_093_SAW 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			

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

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

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

<b>Operation</b> Sub: 2 / Seq: 50 (C)	<b>Resource</b> 815-CMM - GANTRY - PLANT 2 VERIFY FIXTURE GEOMETRY (100% DIMENSIONAL) PER DRAWING / 3D MODEL.  GENERATE REPORT AND FORWARD TO ENGINEERING.	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQt</b> 1.00	<b>Drawing ID / Rev</b> MTMFX-2894 / 2A	<b>IDC N/A</b>	<b>IDC Count : 0</b>	<b>Dwg Count: 1</b>	<b>Pgm Count: 2</b>	<b>QAP Count: 0</b>	<b>NDT Count: 0</b>	<b>WPS Count: 0</b>
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<b>Sub ID</b> 4	<b>Part ID</b> TUBING FOR BASE	<b>Qty</b> 1	<b>Drawing ID / Rev</b> / Parent Sub:2 Op:10
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<b>Operation</b> Sub: 4 / Seq: 10 (C)	<b>Resource</b> 405-SAWS- PLANT 2 SAW / DEBURR TUBING PER MATERIAL CARDS  IDC Count : 0	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQt</b> 1.00	<b>Drawing ID / Rev</b> SE121 / A	<b>Dwg Count: 5</b>	<b>Pgm Count: 0</b>	<b>QAP Count: 0</b>	<b>NDT Count: 0</b>	<b>WPS Count: 0</b>
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<b>Piece #</b> 10 (C)	<b>Part ID</b> 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	<b>Qty</b> 148.0	<b>Drawing ID / Rev</b>	<b>Vendor</b> 5068	<b>Dimensions</b> 74
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QAP Count: 0

<b>Piece #</b> 20 (C)	<b>Part ID</b> 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	<b>Qty</b> 216.0	<b>Drawing ID / Rev</b>	<b>Vendor</b> 5068	<b>Dimensions</b> 72
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<b>Workorder</b> 64880/3.0	<b>Part ID</b>	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	<b>Engineer</b> BLUE/DOUG MCCORKLE
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CERTS & MILL TEST REPORTS REQUIRED WITH SHIPMENT.  
STOCK SIZE 40 FT

QAP Count: 0

<b>Sub ID</b> 10	<b>Part ID</b> RISERS SUB-ASSEMBLIES	<b>Qty</b> 1	<b>Drawing ID / Rev</b> / Parent Sub:2 Op:10
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<b>Operation</b> Sub: 10 / Seq: 10 (C)	<b>Resource</b> 230-FABRICATION - WEIDNER INSTALL AND WELD TOP PLATES TO TUBES. IDC Count : 0	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQt</b> 1.00	<b>Drawing ID / Rev</b>	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 2
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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:

<b>Sub ID</b> 11	<b>Part ID</b> TUBING FOR RISERS	<b>Qty</b> 1	<b>Drawing ID / Rev</b> / Parent Sub:10 Op:10
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<b>Operation</b> Sub: 11 / Seq: 10 (C)	<b>Resource</b> 405-SAWS- PLANT 2 SAW AND DEBURR TUBES PER MATERIAL CARDS IDC Count : 0	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQt</b> 1.00	<b>Drawing ID / Rev</b>	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0
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<b>Piece #</b> 10	<b>Part ID</b> 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	<b>Qty</b> 11.8	<b>Drawing ID / Rev</b>	<b>Vendor</b> 5068	<b>Dimensions</b> 11.75
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(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

<b>Piece #</b> 20	<b>Part ID</b> 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	<b>Qty</b> 21.8	<b>Drawing ID / Rev</b>	<b>Vendor</b> 5068	<b>Dimensions</b> 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 Part ID Qty Drawing ID / Rev  
12 PLATES AND GUSSETS FOR RISERS 1 /  
Parent Sub:10 Op:10

Operation Resource QtyPer StartQty EndQt 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

<b>Workorder</b> 64880/3.0	<b>Part ID</b>	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	<b>Engineer</b> 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					

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

<b>Sub ID</b> 14	<b>Part ID</b> TEMPORARY ALIGMENT BAR (SHOP A)	<b>Qty</b> 1	<b>Drawing ID / Rev</b> / Parent Sub:2 Op:10
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<b>Operation</b> Sub: 14 / Seq: 10 (C)	<b>Resource</b> 108-TOOL ROOM - PLANT 1 TURN ONE END TO POINT PER ENGINEERING DIRECTION (CONTACT DOUG McCORKLE FOR DETAILS).	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQt</b> 1.00	<b>Drawing ID / Rev</b>
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<b>Workorder</b> 64880/3.0	<b>Part ID</b>	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	<b>Engineer</b> 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
<b>Piece #</b>	<b>Part ID</b>	<b>Qty</b>	<b>Drawing ID / Rev</b>	<b>Vendor</b>	<b>Dimensions</b>	
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		

<b>Sub ID</b> 15	<b>Part ID</b> BASE PLATE	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	Parent Sub:2 Op:10
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<b>Operation</b> Sub: 15 / Seq: 10	<b>Resource</b> 800-RECEIVING	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQt</b> 1.00	<b>Drawing ID / Rev</b>				
(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			
<b>Piece #</b>	<b>Part ID</b>	<b>Qty</b>	<b>Drawing ID / Rev</b>	<b>Vendor</b>	<b>Dimensions</b>				
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					

<b>Sub ID</b> 17	<b>Part ID</b> TABS FOR TUBE TO BASEPLATE (TO	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	Parent Sub:2 Op:10
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<b>Operation</b> Sub: 17 / Seq: 10	<b>Resource</b> 405-SAWS- PLANT 2	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQt</b> 1.00	<b>Drawing ID / Rev</b>				
(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			
<b>Piece #</b>	<b>Part ID</b>	<b>Qty</b>	<b>Drawing ID / Rev</b>	<b>Vendor</b>	<b>Dimensions</b>				
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					



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

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

<b>Sub ID</b> 23	<b>Part ID</b> REMOVABLE TOP SECTION OF FIXTU	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	Parent Sub:2 Op:40
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<b>Operation</b> Sub: 23 / Seq: 10 (C)	<b>Resource</b> 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.	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQt</b> 1.00	<b>Drawing ID / Rev</b> MTMFX-2894 / 2A				
	IDC Count : 0		Dwg Count: 1		Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 2	

<b>Workorder</b> 64880/3.0	<b>Part ID</b>	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	<b>Engineer</b> 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 / ER308L\_093\_SAW  
 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)

<b>Operation</b>	<b>Resource</b>	<b>QtyPer</b>	<b>StartQty</b>	<b>EndQt</b>	<b>Drawing ID / Rev</b>					
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			

<b>Operation</b>	<b>Resource</b>	<b>QtyPer</b>	<b>StartQty</b>	<b>EndQt</b>	<b>Drawing ID / Rev</b>					
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 / ER308L_093_SAW 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)										

<b>Operation</b>	<b>Resource</b>	<b>QtyPer</b>	<b>StartQty</b>	<b>EndQt</b>	<b>Drawing ID / Rev</b>					
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)										

<b>Workorder</b> 64880/3.0	<b>Part ID</b>	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	<b>Engineer</b> 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 / ER308L_093_SAW				
Notes: BRACING				

<b>Sub ID</b> 24	<b>Part ID</b> ROUND RISERS	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /
Parent Sub:23 Op:10			

<b>Operation</b> Sub: 24 / Seq: 10 (C)	<b>Resource</b> 405-SAWS- PLANT 2 SAW (4) BARS TO LENGTH PER DRAWING. DETAIL 7-10.	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQt</b> 1.00	<b>Drawing ID / Rev</b> MTMFX-2894 / 2A				
		IDC Count : 0	Dwg Count: 1	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0		
<b>Piece #</b> 10 (C)	<b>Part ID</b> 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.	<b>Qty</b> 84.5	<b>Drawing ID / Rev</b> /	<b>Vendor</b> 7750	<b>Dimensions</b> 84.5				
				QAP Count: 0					

<b>Sub ID</b> 25	<b>Part ID</b> MIDDLE PLATE	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /
Parent Sub:23 Op:10			

<b>Operation</b> Sub: 25 / Seq: 10 (C)	<b>Resource</b> 410-BURNOUT TABLE BURNOUT MIDDLE PLATE DETAIL PER GEOMETRY PROVIDED BY ENGINEERING.	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQt</b> 1.00	<b>Drawing ID / Rev</b> MTMFX-2894 / 2A				
		IDC Count : 0	Dwg Count: 1	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0		
<b>Piece #</b> 10 (C)	<b>Part ID</b> 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.	<b>Qty</b> 4,320.0	<b>Drawing ID / Rev</b> /	<b>Vendor</b> 1810	<b>Dimensions</b> 60*72				
				QAP Count: 1					

<b>Sub ID</b> 16	<b>Part ID</b> U-T CALIBRATION BLOCK (625 IN	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /
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<b>Workorder</b> 64880/3.0	<b>Part ID</b>	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	<b>Engineer</b> 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		
<b>Piece #</b>	<b>Part ID</b>	<b>Qty</b>	<b>Drawing ID / Rev</b>	<b>Vendor</b>	<b>Dimensions</b>				
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		

<b>Sub ID</b> 28	<b>Part ID</b> SEVERN GAGE	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	<b>Parent Sub:0 Op:10</b>
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Operation	Resource	QtyPer	StartQty	EndQt	Drawing ID / Rev				
Sub: 28 / Seq: 10 (R)	806-WELD ENGINEERING/ CWI VERIFY / EXPERIMENT / TEST THE GAGE REVIEW WITH ENGINEERING (DOUG McCORKLE) FORWARD TO Q/A FOR ITENTIFICATION AND LOGGING INTO THE CALIBRATION SYSTEM.	1.00	1.00	1.00					
		IDC Count : 0	Dwg Count: 0	Pgm Count: 0	QAP Count: 0	NDT Count: 0	WPS Count: 0		

<b>Workorder</b>	<b>Part ID</b>	<b>Qty</b>	<b>Drawing ID / Rev</b>	<b>Engineer</b>
64880/3.0		1	/	BLUE/DOUG MCCORKLE

<b>Piece #</b>	<b>Part ID</b>	<b>Qty</b>	<b>Drawing ID / Rev</b>	<b>Vendor</b>	<b>Dimensions</b>
10		1.0			
(C)	SEVERN GAGE LOW MU PERMEABILITY INDICATOR				

PURCHASE FROM SEVERN ENGINEERING COMPANY  
 OLD STAGE BUSINESS PARK  
 555 STAGE ROAD, SUITE 1-A  
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QAP Count: 0