

TPM Overview Sheet



Job#: 7911

PO#: 8889

Mill: mill_03

Quantity: 650

Company: RIM Manufacturing LLC

Dates of Operation: 2021-05-28 to 2021-04-08

Operators/Inspectors

Tubes

Mill Operator(s)

Stephen McCarty

001 - 650

Cutoff Operator(s)

Dante Moore

001 - 101
102 - 650

Inspector(s)

Pete Pressley
Christopher Howard

001 - 076
077 - 177
178 - 650

Used Material

*Shows tubes where material was changed out for a new coil. Intermediate tubes used the new coil until another changed occurred.

*Format: (coil number, heat number, material type) followed by tube number in next column.

Steel	Tube#	Fil. Mesh 1	Tube#	Fil. Mesh 2	Tube#	Drain. Mesh 1	Tube#	Drain. Mesh 2	Tube#
50690, D88F, 304L	001	14262, B1810205, 316L	001	14266, B1810205, 316L	001				
50689, 858724, 316L	060	14034, B1810205, 316L	033	14257, B1810205, 316L	033				
		13996, B1810205, 316L	043	14274, B1810205, 316L	043				
		14025, B1810205, 316L	054	14028, B1810205, 316L	054				
		14001, B1810205, 316L	060	14035, B1810205, 316L	060				
		14000, B1810205, 316L	064	14026, B1810205, 316L	064				
		14279, B1810205, 316L	073	14016, B1810205, 316L	073				
		14027, B1810205, 316L	093	14281, B1810205, 316L	093				
		14021, B1810205, 316L	112	14245, B1810205, 316L	112				



**TUBULAR PERFORATING
MANUFACTURING, LTD.**

FIRST PART CONFIRMATION

THIS IS REQUIRED AT SET-UP AND DAILY START UP.

DATE : 2021-06-01 08:02:02

JOB NUMBER : 7911

MILL NUMBER : mill_03

MATERIAL THICKNESS CHECK : 0.105 Inch (12 Gage)

DIMPLE/SLOT DEPTH CHECK : 0 0 0

BLANK END RING : 0 0 0

BLANK AREA : END 1- 0 END 2- 0

BEND TEST-PASS OR FAIL: Pass

REQUIRED DRIFT SIZE : 5.610

DRIFT PASS OR FAIL : Pass

MILL OPERATOR : Matthew Hedgecock

TPM Welding-Station Check Sheet



Job#: 7911

PO#: 8889

Cutoff: 65

Line Item: 1

+0.06

-0.06

Total Order: 650

OD: 6.15

Spec Mill: TPM-WPS-207-12

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

Dates Tubes Made : 2021-06-01 to 2021-06-01

Tube	OD Check	OD Check	Coil Change	Filter Mesh 1 Change	Filter Mesh 2 Change	Drainage Mesh 1 Change	Drainage Mesh 2 Change
7911-001	6.164	6.164	50690	14262	14266		
7911-002	6.164	6.165					
7911-003	6.165	6.165					
7911-004	6.165	6.161					
7911-005	6.161	6.162					
7911-006	6.162	6.162					
7911-007	6.162	6.16					
7911-008	6.16	6.165					
7911-009	6.165	6.161					
7911-010	6.161	6.165					
7911-011	6.165	6.165					
7911-012	6.165	6.17					
7911-013	6.17	6.164					
7911-014	6.164	6.16					
7911-015	6.16	6.163					
7911-016	6.163	6.16					
7911-017	6.16	6.16					

TPM Welding-Station Check Sheet



Job#: 7911

PO#: 8889

Cutoff: 65

Line Item: 1

+0.06

-0.06

Total Order: 650

OD: 6.15

Spec Mill: TPM-WPS-207-12

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

Dates Tubes Made : 2021-06-01 to 2021-06-01

Tube	OD Check	OD Check	Coil Change	Filter Mesh 1 Change	Filter Mesh 2 Change	Drainage Mesh 1 Change	Drainage Mesh 2 Change
7911-018	6.16	6.16					
7911-019	6.16	6.161					
7911-020	6.161	6.168					
7911-021	6.168	6.166					
7911-022	6.166	6.169					
7911-023	6.169	6.169					
7911-024	6.169	6.169					
7911-025	6.169	6.167					
7911-026	6.167	6.163					
7911-027	6.163	6.16					
7911-028	6.16	6.164					
7911-029	6.164	6.162					
7911-030	6.162	6.164					
7911-031	6.164	6.164					
7911-032	6.164	6.165					
7911-033	6.165	6.16		14034	14257		
7911-034	6.16	6.161					

TPM Welding-Station Check Sheet



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+0.06

-0.06

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Spec Mill: TPM-WPS-207-12

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

Dates Tubes Made : 2021-06-01 to 2021-06-01

Tube	OD Check	OD Check	Coil Change	Filter Mesh 1 Change	Filter Mesh 2 Change	Drainage Mesh 1 Change	Drainage Mesh 2 Change
7911-035	6.161	6.166					
7911-036	6.166	6.165					
7911-037	6.165	6.169					
7911-038	6.169	6.169					
7911-039	6.169	6.168					
7911-040	6.168	6.169					
7911-041	6.169	6.165					
7911-042	6.165	6.167					
7911-043	6.167	6.167		13996	14274		
7911-044	6.167	6.17					
7911-045	6.17	6.168					
7911-046	6.168	6.166					
7911-047	6.166	6.168					
7911-048	6.168	6.167					
7911-049	6.167	6.168					
7911-050	6.168	6.167					
7911-051	6.167	6.168					

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Spec Mill: TPM-WPS-207-12

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

Dates Tubes Made : 2021-06-01 to 2021-06-02

Tube	OD Check	OD Check	Coil Change	Filter Mesh 1 Change	Filter Mesh 2 Change	Drainage Mesh 1 Change	Drainage Mesh 2 Change
7911-052	6.168	6.169					
7911-053	6.169	6.167					
7911-054	6.167	6.168		14025	14028		
7911-055	6.168	6.169					
7911-056	6.169	6.165					
7911-057	6.165	6.164					
7911-058	6.164	6.167					
7911-059	6.167	6.164					
7911-060	6.164	6.164	50689	14001	14035		
7911-061	6.164	6.166					
7911-062	6.166	6.163					
7911-063	6.163	6.166					
7911-064	6.166	6.166		14000	14026		
7911-065	6.166	6.169					
7911-066	6.169	6.165					
7911-067	6.165	6.165					
7911-068	6.165	6.164					

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Line Item: 1

+0.06

-0.06

Total Order: 650

OD: 6.15

Spec Mill: TPM-WPS-207-12

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

Dates Tubes Made : 2021-06-02 to 2021-06-02

Tube	OD Check	OD Check	Coil Change	Filter Mesh 1 Change	Filter Mesh 2 Change	Drainage Mesh 1 Change	Drainage Mesh 2 Change
7911-069	6.164	6.167					
7911-070	6.167	6.17					
7911-071	6.17	6.168					
7911-072	6.168	6.164					
7911-073	6.164	6.168		14279	14016		
7911-074	6.168	6.166					
7911-075	6.166	6.168					
7911-076	6.168	6.167					
7911-077	6.167	6.168					
7911-078	6.168	6.168					
7911-079	6.168	6.164					
7911-080	6.164	6.165					
7911-081	6.165	6.161					
7911-082	6.161	6.161					
7911-083	6.161	6.16					
7911-084	6.161	6.169					
7911-085	6.169	6.163					

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+0.06

-0.06

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Spec Mill: TPM-WPS-207-12

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

Dates Tubes Made : 2021-06-02 to 2021-06-02

Tube	OD Check	OD Check	Coil Change	Filter Mesh 1 Change	Filter Mesh 2 Change	Drainage Mesh 1 Change	Drainage Mesh 2 Change
7911-086	6.163	6.163					
7911-087	6.163	6.164					
7911-088	6.164	6.164					
7911-089	6.164	6.168					
7911-090	6.168	6.167					
7911-091	6.167	6.168					
7911-092	6.168	6.169					
7911-093	6.169	6.162		14027	14281		
7911-094	6.168	6.166					
7911-095	6.166	6.165					
7911-096	6.165	6.165					
7911-097	6.165	6.164					
7911-098	6.164	6.166					
7911-099	6.166	6.168					
7911-100	6.168	6.165					
7911-101	6.168	6.168					
7911-102	6.168	6.166					

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+0.06

-0.06

Total Order: 650

OD: 6.15

Spec Mill: TPM-WPS-207-12

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

Dates Tubes Made : 2021-06-02 to 1969-12-31

Tube	OD Check	OD Check	Coil Change	Filter Mesh 1 Change	Filter Mesh 2 Change	Drainage Mesh 1 Change	Drainage Mesh 2 Change
7911-103	6.166	6.161					
7911-104	6.161	6.163					
7911-105	6.163	6.163					
7911-106	6.163	6.165					
7911-107	6.165	6.164					
7911-108	6.164	6.164					
7911-109	6.164	6.164					
7911-110	6.164	6.167					
7911-111	6.167	6.164					
7911-112	6.164	6.165		14021	14245		
7911-113	6.165	6.166					

TPM Cutoff-Station Check Sheet



Job#: 7911

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Total Order: 650

Line Item: 1

Cutoff Length: 63

Weld Spec Repair: TPM-WPS-316R

+0.125

-0.125

Date Started: 2021-05-28 07:07:17

Date Tubes Cut : 2021-06-01 to 2021-06-01

Tube	Length Check	Remarks
7911-001	63	
7911-002		
7911-003	63	
7911-004		
7911-005	63	
7911-006	63 1/16	
7911-007	63	
7911-008		
7911-009	63	
7911-010	63	
7911-011	63	
7911-012	63	
7911-013	63	
7911-014		
7911-015		
7911-016	63	
7911-017	63	
7911-018	63	
7911-019	63 1/8	
7911-020	63	

TPM Cutoff-Station Check Sheet



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Line Item: 1

Cutoff Length: 63

Weld Spec Repair: TPM-WPS-316R

+0.125

-0.125

Date Started: 2021-05-28 07:07:17

Date Tubes Cut : 2021-06-01 to 2021-06-01

Tube	Length Check	Remarks
7911-021		
7911-022		
7911-023		
7911-024	63	
7911-025	63	
7911-026	63	
7911-027		
7911-028	63 1/16	
7911-029	63	
7911-030	63	
7911-031		
7911-032	63	
7911-033		
7911-034	63	
7911-035	63	
7911-036	63	
7911-037		
7911-038	63	
7911-039	63	
7911-040	63	



**TUBULAR PERFORATING
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TPM Cutoff-Station Check Sheet

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Total Order: 650

Line Item: 1

Cutoff Length: 63

Weld Spec Repair: TPM-WPS-316R

+0.125

-0.125

Date Started: 2021-05-28 07:07:17

Date Tubes Cut : 2021-06-02 to 2021-06-02

Tube	Length Check	Remarks
7911-041	63	
7911-042	63	
7911-043	63	
7911-044	63	
7911-045	63	
7911-046	63	
7911-047	63	
7911-048	63	
7911-049	63	
7911-050	63	
7911-051	63	
7911-052	63	
7911-053	63	
7911-054	63	
7911-055	63	
7911-056	63	
7911-057	63 1/8	
7911-058	63	
7911-059	63	
7911-060	63	

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Line Item: 1

Cutoff Length: 63

Weld Spec Repair: TPM-WPS-316R

+0.125

-0.125

Date Started: 2021-05-28 07:07:17

Date Tubes Cut : 2021-06-02 to 2021-06-02

Tube	Length Check	Remarks
7911-061	63	
7911-062	63	
7911-063	63	
7911-064	63	
7911-065	63	
7911-066	63	
7911-067	63	
7911-068	63	
7911-069	63	
7911-070	63	
7911-071	63	
7911-072	63	
7911-073	63 1/16	
7911-074	63	
7911-075	63	
7911-076	63	
7911-077	63	
7911-078	63	
7911-079	63	
7911-080	63	

TPM Cutoff-Station Check Sheet



Job#: 7911

PO#: 8889

Total Order: 650

Line Item: 1

Cutoff Length: 63

Weld Spec Repair: TPM-WPS-316R

+0.125

-0.125

Date Started: 2021-05-28 07:07:17

Date Tubes Cut : 2021-06-02 to 2021-06-02

Tube	Length Check	Remarks
7911-081	63	
7911-082	63	
7911-083	63	
7911-084	63	
7911-085	63	
7911-086	63	
7911-087	63	
7911-088	63	
7911-089	63	
7911-090	63	
7911-091	63	
7911-092	63	
7911-093	63	
7911-094	63	
7911-095	63	
7911-096	63	
7911-097	63	
7911-098	63	
7911-099	63	
7911-100	63	

TPM Cutoff-Station Check Sheet



Job#: 7911

PO#: 8889

Total Order: 650

Line Item: 1

Cutoff Length: 63

Weld Spec Repair: TPM-WPS-316R

+0.125

-0.125

Date Started: 2021-05-28 07:07:17

Date Tubes Cut : 2021-06-02 to 1969-12-31

Tube	Length Check	Remarks
7911-101		
7911-102		
7911-103		
7911-104		
7911-105		
7911-106		
7911-107		
7911-108		
7911-109		
7911-110		
7911-111		
7911-112		
7911-113		



TPM Inspection-Station Check Sheet

Job#: 7911

PO#: 8889
Line Item: 1

Length: 63
+0.125
-0.125

Total Order: 650

OD: 6.15
+0.03
-0.03

Date Started: 2021-05-28 07:07:17

ID Drift: 5.610

Ship Date : 0000-00-00

Drift inspected (+ or -.002):
Dimensions: 5.610
By: Pete Pressley

Date Tubes inspected: 2021-06-01 to 2021-06-01

Tube	ID Drift	OD Check	Length Check	Weld	Repairs
7911-001	P	6.165	63	P	n
7911-002	P	6.164	63 1/16	P	n
7911-003	P	6.165	63 1/16	P	n
7911-004	P	6.164	63 1/16	P	n
7911-005	P	6.165	63	P	n
7911-006	P	6.163	63 1/16	P	n
7911-007	P	6.164	63 1/16	P	n
7911-008	P	6.163	63 1/16	P	n
7911-009	P	6.165	63 1/16	P	n
7911-010	P	6.164	63 1/16	P	n
7911-011	P	6.164	63	P	n

Key P = Passed N = None WL = Within Limits

Inspection Notes: BURR OUT. MAX OD IS 6.180. REF DWG K03-388-02.1 REV NONE. FINAL OAL W/ RINGS ADDED - $67.250 + .000 / -.250$ ". TUBES MUST BE DRIFTED AFTER THE RINGS ARE WELDED ONTO SHROUD. MAKE SURE THERE ARE NO MARKS PAST THE SCRIDE LINE. PLACE RING PROTECTORS ON RINGS BEFORE HANDLING. TUBES MUST BE WASHED AND TAGGED. REF DWG K03-397-00.1 REV C7.

TPM Inspection-Station Check Sheet



Job#: 7911

PO#: 8889

Length: 63

Line Item: 1

+0.125

-0.125

Total Order: 650

OD: 6.15

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

ID Drift: 5.610

Ship Date : 0000-00-00

Drift inspected (+ or -.002):

Dimensions: 5.610

By: Pete Pressley

Date Tubes inspected: 2021-06-01 to 2021-06-01

Tube	ID Drift	OD Check	Length Check	Weld	Repairs
7911-012	P	6.162	63	P	n
7911-013	P	6.163	63 1/16	P	n
7911-014	P	6.163	63	P	n
7911-015	P	6.163	63	P	n
7911-016	P	6.164	63 1/16	P	n
7911-017	P	6.164	63	P	n
7911-018	P	6.163	63	P	n
7911-019	P	6.162	63	P	n
7911-020	P	6.164	63	P	n
7911-021	P	6.166	63 1/16	P	n
7911-022	P	6.166	63	P	n

Key P = Passed N = None WL = Within Limits

Inspection Notes: BURR OUT. MAX OD IS 6.180. REF DWG K03-388-02.1 REV NONE. FINAL OAL W/ RINGS ADDED - $67.250 + .000 / -.250$ ". TUBES MUST BE DRIFTED AFTER THE RINGS ARE WELDED ONTO SHROUD. MAKE SURE THERE ARE NO MARKS PAST THE SCRIDE LINE. PLACE RING PROTECTORS ON RINGS BEFORE HANDLING. TUBES MUST BE WASHED AND TAGGED. REF DWG K03-397-00.1 REV C7.



TPM Inspection-Station Check Sheet

Job#: 7911

PO#: 8889
Line Item: 1

Length: 63
+0.125
-0.125

Total Order: 650

OD: 6.15
+0.03
-0.03

Date Started: 2021-05-28 07:07:17

ID Drift: 5.610

Ship Date : 0000-00-00

Drift inspected (+ or -.002):
Dimensions: 5.610
By: Pete Pressley

Date Tubes inspected: 2021-06-01 to 2021-06-01

Tube	ID Drift	OD Check	Length Check	Weld	Repairs
7911-023	P	6.168	63	P	n
7911-024	P	6.165	63 1/16	P	n
7911-025	P	6.163	63	P	n
7911-026	P	6.163	63	P	n
7911-027	P	6.16	63	P	n
7911-028	P	6.163	63 1/16	P	n
7911-029	P	6.163	63	P	n
7911-030	P	6.16	63	P	n
7911-031	P	6.163	63 1/16	P	n
7911-032	P	6.163	63	P	n
7911-033	P	6.163	63 1/16	P	n

Key P = Passed N = None WL = Within Limits

Inspection Notes: BURR OUT. MAX OD IS 6.180. REF DWG K03-388-02.1 REV NONE. FINAL OAL W/ RINGS ADDED - $67.250 + .000 / -.250$ ". TUBES MUST BE DRIFTED AFTER THE RINGS ARE WELDED ONTO SHROUD. MAKE SURE THERE ARE NO MARKS PAST THE SCRIDE LINE. PLACE RING PROTECTORS ON RINGS BEFORE HANDLING. TUBES MUST BE WASHED AND TAGGED. REF DWG K03-397-00.1 REV C7.

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+0.125

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OD: 6.15

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

ID Drift: 5.610

Ship Date : 0000-00-00

Drift inspected (+ or -.002):

Dimensions: 5.610

By: Pete Pressley

Date Tubes inspected: 2021-06-01 to 2021-06-02

Tube	ID Drift	OD Check	Length Check	Weld	Repairs
7911-034	P	6.163	63	P	n
7911-035	P	6.163	63	P	n
7911-036	P	6.164	63	P	n
7911-037	P	6.165	63	P	n
7911-038	P	6.165	63	P	n
7911-039	P	6.163	63 1/16	P	n
7911-040	P	6.166	63 1/16	P	n
7911-041	P	6.164	63	P	n
7911-042	P	6.164	63	P	n
7911-043	P	6.163	63	P	n
7911-044	P	6.165	63	P	n

Key P = Passed N = None WL = Within Limits

Inspection Notes: BURR OUT. MAX OD IS 6.180. REF DWG K03-388-02.1 REV NONE. FINAL OAL W/ RINGS ADDED - $67.250 + .000 / -.250$ ". TUBES MUST BE DRIFTED AFTER THE RINGS ARE WELDED ONTO SHROUD. MAKE SURE THERE ARE NO MARKS PAST THE SCRIDE LINE. PLACE RING PROTECTORS ON RINGS BEFORE HANDLING. TUBES MUST BE WASHED AND TAGGED. REF DWG K03-397-00.1 REV C7.

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+0.125

-0.125

Total Order: 650

OD: 6.15

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

ID Drift: 5.610

Ship Date : 0000-00-00

Drift inspected (+ or -.002):

Dimensions: 5.610

By: Pete Pressley

Date Tubes inspected: 2021-06-02 to 2021-06-02

Tube	ID Drift	OD Check	Length Check	Weld	Repairs
7911-045	P	6.164	63	P	n
7911-046	P	6.164	63 1/16	P	n
7911-047	P	6.165	63	P	n
7911-048	P	6.164	63	P	n
7911-049	P	6.163	63	P	n
7911-050	P	6.164	63	P	n
7911-051	P	6.164	63	P	n
7911-052	P	6.167	63	P	n
7911-053	P	6.165	63	P	n
7911-054	P	6.164	63 1/16	P	n
7911-055	P	6.163	63	P	n

Key P = Passed N = None WL = Within Limits

Inspection Notes: BURR OUT. MAX OD IS 6.180. REF DWG K03-388-02.1 REV NONE. FINAL OAL W/ RINGS ADDED - $67.250 + .000 / -.250$ ". TUBES MUST BE DRIFTED AFTER THE RINGS ARE WELDED ONTO SHROUD. MAKE SURE THERE ARE NO MARKS PAST THE SCRIDE LINE. PLACE RING PROTECTORS ON RINGS BEFORE HANDLING. TUBES MUST BE WASHED AND TAGGED. REF DWG K03-397-00.1 REV C7.

TPM Inspection-Station Check Sheet



Job#: 7911

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+0.125

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Total Order: 650

OD: 6.15

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

ID Drift: 5.610

Ship Date : 0000-00-00

Drift inspected (+ or -.002):

Dimensions: 5.610

By: Pete Pressley

Date Tubes inspected: 2021-06-02 to 2021-06-02

Tube	ID Drift	OD Check	Length Check	Weld	Repairs
7911-056	P	6.164	63 1/16	P	n
7911-057	P	6.163	63 1/8	P	n
7911-058	P	6.163	63 1/8	P	n
7911-059	P	6.162	63 1/8	P	n
7911-060	P	6.163	63 1/8	P	n
7911-061	P	6.164	63	P	n
7911-062	P	6.165	63 1/16	P	n
7911-063	P	6.164	63 1/16	P	n
7911-064	P	6.164	63	P	n
7911-065	P	6.164	63 1/16	P	n
7911-066	P	6.164	63	P	n

Key P = Passed N = None WL = Within Limits

Inspection Notes: BURR OUT. MAX OD IS 6.180. REF DWG K03-388-02.1 REV NONE. FINAL OAL W/ RINGS ADDED - $67.250 + .000 / -.250$ ". TUBES MUST BE DRIFTED AFTER THE RINGS ARE WELDED ONTO SHROUD. MAKE SURE THERE ARE NO MARKS PAST THE SCRIDE LINE. PLACE RING PROTECTORS ON RINGS BEFORE HANDLING. TUBES MUST BE WASHED AND TAGGED. REF DWG K03-397-00.1 REV C7.

TPM Inspection-Station Check Sheet



Job#: 7911

PO#: 8889

Length: 63

Line Item: 1

+0.125

-0.125

Total Order: 650

OD: 6.15

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

ID Drift: 5.610

Ship Date : 0000-00-00

Drift inspected (+ or -.002):

Dimensions: 5.610

By: Pete Pressley

Date Tubes inspected: 2021-06-02 to 2021-06-02

Tube	ID Drift	OD Check	Length Check	Weld	Repairs
7911-067	P	6.164	63	P	n
7911-068	P	6.165	63	P	n
7911-069	P	6.164	63 1/16	P	n
7911-070	P	6.167	63	P	n
7911-071	P	6.165	63 1/16	P	n
7911-072	P	6.164	63	P	n
7911-073	P	6.165	63 1/16	P	n
7911-074	P	6.167	63 1/8	P	n
7911-075	P	6.165	63	P	n
7911-076	P	6.165	63 1/8	P	N
7911-077	P	6.165	63	P	N

Key P = Passed N = None WL = Within Limits

Inspection Notes: BURR OUT. MAX OD IS 6.180. REF DWG K03-388-02.1 REV NONE. FINAL OAL W/ RINGS ADDED - $67.250 + .000 / -.250$ ". TUBES MUST BE DRIFTED AFTER THE RINGS ARE WELDED ONTO SHROUD. MAKE SURE THERE ARE NO MARKS PAST THE SCRIDE LINE. PLACE RING PROTECTORS ON RINGS BEFORE HANDLING. TUBES MUST BE WASHED AND TAGGED. REF DWG K03-397-00.1 REV C7.



TPM Inspection-Station Check Sheet

Job#: 7911

PO#: 8889
Line Item: 1

Length: 63
+0.125
-0.125

Total Order: 650

OD: 6.15
+0.03
-0.03

Date Started: 2021-05-28 07:07:17

ID Drift: 5.610

Ship Date : 0000-00-00

Drift inspected (+ or -.002):
Dimensions: 5.610
By: Pete Pressley

Date Tubes inspected: 2021-06-02 to 2021-06-02

Tube	ID Drift	OD Check	Length Check	Weld	Repairs
7911-078	P	6.165	63	P	N
7911-079	P	6.164	63 1/16	P	N
7911-080	P	6.164	63 1/16	P	N
7911-081	P	6.163	63	P	N
7911-082	P	6.163	63 1/16	P	N
7911-083	P	6.163	63	P	N
7911-084	P	6.165	63	P	N
7911-085	P	6.166	63	P	N
7911-086	P	6.165	63	P	N
7911-087	P	6.166	63	P	N
7911-088	P	6.166	63 1/16	P	N

Key P = Passed N = None WL = Within Limits

Inspection Notes: BURR OUT. MAX OD IS 6.180. REF DWG K03-388-02.1 REV NONE. FINAL OAL W/ RINGS ADDED - $67.250 + .000 / -.250$ ". TUBES MUST BE DRIFTED AFTER THE RINGS ARE WELDED ONTO SHROUD. MAKE SURE THERE ARE NO MARKS PAST THE SCRIDE LINE. PLACE RING PROTECTORS ON RINGS BEFORE HANDLING. TUBES MUST BE WASHED AND TAGGED. REF DWG K03-397-00.1 REV C7.

TPM Inspection-Station Check Sheet



Job#: 7911

PO#: 8889

Length: 63

Line Item: 1

+0.125

-0.125

Total Order: 650

OD: 6.15

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

ID Drift: 5.610

Ship Date : 0000-00-00

Drift inspected (+ or -.002):

Dimensions: 5.610

By: Pete Pressley

Date Tubes inspected: 2021-06-02 to 2021-06-02

Tube	ID Drift	OD Check	Length Check	Weld	Repairs
7911-089	P	6.164	63	P	N
7911-090	P	6.165	63	P	N
7911-091	P	6.165	63	P	N
7911-092	P	6.164	63	P	N
7911-093	P	6.163	63	P	N
7911-094	P	6.164	63	P	N
7911-095	P	6.164	63	P	N
7911-096	P	6.164	63	P	N
7911-097	P	6.165	63 1/16	P	N
7911-098	P	6.165	63 1/8	P	N
7911-099	P	6.165	63 1/16	P	N

Key P = Passed N = None WL = Within Limits

Inspection Notes: BURR OUT. MAX OD IS 6.180. REF DWG K03-388-02.1 REV NONE. FINAL OAL W/ RINGS ADDED - $67.250 + .000 / -.250$ ". TUBES MUST BE DRIFTED AFTER THE RINGS ARE WELDED ONTO SHROUD. MAKE SURE THERE ARE NO MARKS PAST THE SCRIDE LINE. PLACE RING PROTECTORS ON RINGS BEFORE HANDLING. TUBES MUST BE WASHED AND TAGGED. REF DWG K03-397-00.1 REV C7.



TPM Inspection-Station Check Sheet

Job#: 7911

PO#: 8889
Line Item: 1

Length: 63
+0.125
-0.125

Total Order: 650

OD: 6.15
+0.03
-0.03

Date Started: 2021-05-28 07:07:17

ID Drift: 5.610

Ship Date : 0000-00-00

Drift inspected (+ or -.002):
Dimensions: 5.610
By: Pete Pressley

Date Tubes inspected: 2021-06-02 to 2021-06-02

Tube	ID Drift	OD Check	Length Check	Weld	Repairs
7911-100	P	6.165	63 1/16	P	N
7911-101		0			
7911-102		0			
7911-103		0			
7911-104		0			
7911-105		0			
7911-106		0			
7911-107		0			
7911-108		0			
7911-109		0			
7911-110		0			

Key P = Passed N = None WL = Within Limits

Inspection Notes: BURR OUT. MAX OD IS 6.180. REF DWG K03-388-02.1 REV NONE. FINAL OAL W/ RINGS ADDED - $67.250 + .000 / -.250$ ". TUBES MUST BE DRIFTED AFTER THE RINGS ARE WELDED ONTO SHROUD. MAKE SURE THERE ARE NO MARKS PAST THE SCRIDE LINE. PLACE RING PROTECTORS ON RINGS BEFORE HANDLING. TUBES MUST BE WASHED AND TAGGED. REF DWG K03-397-00.1 REV C7.



TPM Inspection-Station Check Sheet

Job#: 7911

PO#: 8889

Length: 63

Line Item: 1

+0.125

-0.125

Total Order: 650

OD: 6.15

+0.03

-0.03

Date Started: 2021-05-28 07:07:17

ID Drift: 5.610

Ship Date : 0000-00-00

Drift inspected (+ or -.002):

Dimensions: 5.610

By: Pete Pressley

Date Tubes inspected: 2021-06-02 to 1969-12-31

Tube	ID Drift	OD Check	Length Check	Weld	Repairs
7911-111		0			
7911-112		0			
7911-113		0			

Key P = Passed N = None WL = Within Limits

Inspection Notes: BURR OUT. MAX OD IS 6.180. REF DWG K03-388-02.1 REV NONE. FINAL OAL W/ RINGS ADDED - 67.250+.000/-.250". TUBES MUST BE DRIFTED AFTER THE RINGS ARE WELDED ONTO SHROUD. MAKE SURE THERE ARE NO MARKS PAST THE SCRIDE LINE. PLACE RING PROTECTORS ON RINGS BEFORE HANDLING. TUBES MUST BE WASHED AND TAGGED. REF DWG K03-397-00.1 REV C7.



TPM Weld Sheet-GeoForm

Job#: 7911

PO#: 8889

Total Order: 650

Length: 63

Weld Spec Repair: TPM-WPS-316R

+ 0.125

- 0.125

Total Order: 650

Filler Rod: ER316/316L 1/16"

Min. Travel Speed: 1-2

Repair Amps: 65-150

Repair Volts: 11.5-18

Date Started: 2021-05-28 07:07:17

Date rings welded: 2021-06-02 to 2021-06-02

Tube	Ring A	Ring B	Filler Rod Heat	Filler Rod Manufacturer
7911-001	P	P	r8741	Washington alloy co.
7911-002	P	P		
7911-003	P	P		
7911-004	P	P	r8741	Washington alloy
7911-005	P	P		
7911-006	P	P		
7911-007	P	P		
7911-008	P	P		
7911-009	P	P		
7911-010	P	P		
7911-011	P	P		
7911-012	P	P		
7911-013	P	P		
7911-014	P	P		
7911-015	P	P		
7911-016	P	P		
7911-017	P	P		

Key P = Passed N = None WL = Within Limits



TPM Weld Sheet-GeoForm

Job#: 7911
Length: 63
 + 0.125
 - 0.125
Filler Rod: ER316/316L 1/16"
Repair Amps: 65-150
Date Started: 2021-05-28 07:07:17

PO#: 8889
Weld Spec Repair: TPM-WPS-316R
Total Order: 650
Min. Travel Speed: 1-2
Repair Volts: 11.5-18

Total Order: 650

Date rings welded: 2021-06-02 to 2021-06-01

Tube	Ring A	Ring B	Filler Rod Heat	Filler Rod Manufacturer
7911-018	P	P		
7911-019	P	P		
7911-020	P	P		
7911-021	P	P		
7911-022	P	P		
7911-023	P	P		
7911-024	P	P		
7911-025	P	P		
7911-026				
7911-027				
7911-028				

Key P = Passed N = None WL = Within Limits



TPM Weld Sheet-GeoForm

Job#: 7911
Length: 63
+ 0.125
- 0.125
Filler Rod: ER316/316L 1/16"
Repair Amps: 65-150
Date Started: 2021-05-28 07:07:17

PO#: 8889
Weld Spec Repair: TPM-WPS-316R
Total Order: 650
Min. Travel Speed: 1-2
Repair Volts: 11.5-18

Total Order: 650

Date rings welded: 2021-06-01 to 2021-06-01

Tube	Ring A	Ring B	Filler Rod Heat	Filler Rod Manufacturer
7911-029				
7911-030				
7911-031				
7911-032				
7911-033				
7911-034				
7911-035				
7911-036				
7911-037				
7911-038				
7911-039				

Key P = Passed N = None WL = Within Limits



TPM Weld Sheet-GeoForm

Job#: 7911

Length: 63

+ 0.125

- 0.125

Filler Rod: ER316/316L 1/16"

Repair Amps: 65-150

Date Started: 2021-05-28 07:07:17

PO#: 8889

Weld Spec Repair: TPM-WPS-316R

Total Order: 650

Min. Travel Speed: 1-2

Repair Volts: 11.5-18

Total Order: 650

Date rings welded: 2021-06-01 to 2021-06-01

Tube	Ring A	Ring B	Filler Rod Heat	Filler Rod Manufacturer
7911-040				
7911-041				
7911-042				
7911-043				
7911-044				
7911-045				
7911-046				
7911-047				
7911-048				
7911-049				
7911-050				

Key P = Passed N = None WL = Within Limits



TPM Weld Sheet-GeoForm

Job#: 7911

PO#: 8889

Total Order: 650

Length: 63

Weld Spec Repair: TPM-WPS-316R

+ 0.125

- 0.125

Total Order: 650

Filler Rod: ER316/316L 1/16"

Min. Travel Speed: 1-2

Repair Amps: 65-150

Repair Volts: 11.5-18

Date Started: 2021-05-28 07:07:17

Date rings welded: 2021-06-01 to 2021-06-01

Tube	Ring A	Ring B	Filler Rod Heat	Filler Rod Manufacturer
7911-051				
7911-052				
7911-053				
7911-054				
7911-055				
7911-056				
7911-057				
7911-058				
7911-059				
7911-060				
7911-061				

Key P = Passed N = None WL = Within Limits



TPM Weld Sheet-GeoForm

Job#: 7911

PO#: 8889

Total Order: 650

Length: 63

Weld Spec Repair: TPM-WPS-316R

+ 0.125

- 0.125

Total Order: 650

Filler Rod: ER316/316L 1/16"

Min. Travel Speed: 1-2

Repair Amps: 65-150

Repair Volts: 11.5-18

Date Started: 2021-05-28 07:07:17

Date rings welded: 2021-06-01 to 2021-06-02

Tube	Ring A	Ring B	Filler Rod Heat	Filler Rod Manufacturer
7911-062				
7911-063				
7911-064				
7911-065				
7911-066				
7911-067				
7911-068				
7911-069				
7911-070				
7911-071				
7911-072				

Key P = Passed N = None WL = Within Limits



TPM Weld Sheet-GeoForm

Job#: 7911

Length: 63

+ 0.125

- 0.125

Filler Rod: ER316/316L 1/16"

Repair Amps: 65-150

Date Started: 2021-05-28 07:07:17

PO#: 8889

Weld Spec Repair: TPM-WPS-316R

Total Order: 650

Min. Travel Speed: 1-2

Repair Volts: 11.5-18

Total Order: 650

Date rings welded: 2021-06-02 to 2021-06-02

Tube	Ring A	Ring B	Filler Rod Heat	Filler Rod Manufacturer
7911-073				
7911-074				
7911-075				
7911-076				
7911-077				
7911-078				
7911-079				
7911-080				
7911-081				
7911-082				
7911-083				

Key P = Passed N = None WL = Within Limits