



Work Order Router

6/26/2017 5:04:56PM

P65290FAB IMPELLER BLANK

10

B22

Work Order	Description	Due	Quantity	UO	Ship	Quantity	Sales Order		
029279	- IMPELLER BLANK	07/20/17	82.00	EA					
Part Number/Rev/Loc	Customer Name	Order	Cust Quantity						
P65290FAB 10	Xylem Inc	06/22/17	82.00						
Cust Number	Prod Line	8200 NORTH AUSTIN AVE	Complete						
0695	PP	MORTON GROVE IL 60053							
Cust P O Number				User Priority	QA/Buyoff				
				050					
Cust Part Number	Additional Description	Standard Router							
Cust Drawing Number						P65290FAB 10			
10					Price/Pc	Order Value			
Seq	LMO	WC-Part-Code	Description	Start	Due	Unit	-----LABOR-----	--- MATERIAL ---	Total
							Setup Runtime	Unit/Part	Total

000100 SET-UP ASSEMBLY BENCH
 ASSEMBLE THE FOLLOWING.
 5 P05860 BLADE 1 P53930 HUB 1 P05890 REAR SHROUD 1 P06330 FRONT SHROUD 1 P40608 BACK-UP PLATE
 STAKE IMPELLER



000200 M P05860

2

07/13/17 07/19/17 EA

IMPELLER BLADE

5.0000 410.0000



000300 M P53930

4

07/13/17 07/19/17 EA

HUB, IMPELLER

1.0000 82.0000



000400 M P05890

3

07/13/17 07/19/17 EA

REAR SHROUD

1.0000 82.0000



000500 M P06330

3

07/13/17 07/19/17 EA

FRONT SHROUD

1.0000 82.0000



000600 M P40608

1

07/13/17 07/19/17 EA

BACKUP PLATE (BSTR PMP)

1.0000 82.0000

FIRST

LAST

OKAY

JUL 1 2013

P65290



SECTION "A-A"

ZINC PLATE STEEL ASSEMBLY

[illegible]

Production Inspection Report

 Document No. 0005
 Job Traveler
 Revision: -

Part No.:		P65290FAB		Work Order No.:		029279												
Revision:		10		Coil Heat No.:		N/A												
Tool No.:		N/A		Press No.:		61												
Lead Time:				AQL:		1000												
Item No.	Dimension Type	Nominal Dimension	Tolerance Limit + -	Upper Spec Limit	Lower Spec Limit	Unit of Measure	Measuring Equipment	Frequency	Measurement Results (Data)									
1	Height	0.995	0.005 0.005	1.000	0.990	Inches	Caliper	Setup, CC, AQL	0.990	0.990								
2	Outside Diameter	3.875	0.005 0.005	3.880	3.870	Inches	Caliper	Setup, CC, AQL	3.908	3.908								
3	Leg to Leg Height	0.034	0.005 0.005	0.039	0.029	Inches	Drop Indicator	Setup, CC, AQL	0.039	0.029								
4	Height	1.960	0.005 0.005	1.965	1.955	Inches	Height Gage	Setup, CC, AQL	2.080	2.080								
5	Key Slot Diameter	0.3760	0.0005 0.0005	0.3765	0.3755	Inches	Caliper	Setup, CC, AQL										
6	Key Slot Length	0.4285	0.0025 0.0025	0.4310	0.4260	Inches	Caliper	Setup, CC, AQL										
7	Key Slot Notch Width	0.0958	0.0010 0.0010	0.0968	0.0948	Inches	Caliper	Setup, CC, AQL										
	Visual Check		Fail	Pass	Pass		Visual	Setup, CC, AQL										
	Packaging Product		Fail	Pass	Pass		Visual	Each Container										
	1st Piece Inspection		Fail	Pass	Pass		Visual	First Piece										
	Final Inspection		Fail	Pass	Pass		Visual	Last Piece										