

# SALES ORDER

OPENING DATE:  
ENGINEER/SALES PERSON:

24/06/2014  
Sean Kent



CUSTOMER:  
CLIENT:  
CUSTOMER Ref:  
BUSINESS UNIT:

Polydeck Resins Ltd  
WHITE LAKE CHEESE  
2417/2627/519  
BP

ORDER NO: **142557**  
DUE DATE: **16/07/2014**

PROCESS ORDER	CODE	QTY/ <i>In Stock</i>	DESCRIPTION
6474	2004887	25.70 0.80	KSHC20304 Channel Hex Standard
6475	130081520	1.00 0.00	KV315\110 304S/S
6476	2004566	1.00 0.00	KHB260\110\304 Filter Baskets Rd S/O



Process Order: **6474**  
Finish Date: 16/07/2014  
Sales Order:  
Owner: **142557**  
Kent, Sean

# Intelligent Production - Process Sheet

Printed: 24/06/2014



End Product: 2004887  
KSHC20304 Channel Hex Standard

Finished Whs: WAR\_003  
Production Qty: 26.000

Sequence No. 0001

Step Item 2004887  
Description KSHC20304 Channel Hex Standard  
Process Time/Qty 25.700 Step Id 1

Qty Required	Component
1.645 2001032 In Stock: 78.57	304 Sheet 3000 x 1500 x 2.0mm CR 
0.051 2001082 In Stock: 3.43	304 Sheet 3000 x 1500 x 4.0mm HR 
1.542 2000965 In Stock: 28.64	Mts of 12mm Round Bar 304 (3m Lengths) 
102.800 3000095 In Stock: 334.00	M10 Hex Nut - ZP 
51.400 2005248 In Stock: 897.00	M10 x 65 Hex Head Set Screw - Z/P 
51.400 2003101 In Stock: 1,074.00	M8 x 25 Hex Head Set Screw - A2 
51.400 2003080 In Stock: 1,016.00	M8 Hex Nut - A2 

Sequence No. 0002

Step Item 3000003  
Description LASER LABOUR  
Process Time/Qty 1.285 Step Id 2

Sequence No. 0003

Step Item 3000004  
Description LASER MACHINE  
Process Time/Qty 1.285 Step Id 3

Sequence No. 0004

Step Item 3000007  
Description BRAKE PRESS  
Process Time/Qty 6.425 Step Id 4

Sequence No. 0005

Step Item 3000002  
Description FABRICATION  
Process Time/Qty 32.125 Step Id 5

Sequence No. 0006

Step Item 3000016  
Description PICKLE & PASSIVATE  
Process Time/Qty 2.570 Step Id 6

TAINLESS

# Intelligent Production - Process Sheet

Printed: 24/06/2014 13

Process Order: **6475**

Finish Date: 16/07/2014

Sales Order: **142557**

Owner: Kent, Sean

End Product: 130081520  
KV315\110 304S/S

Finished Whs: WAR\_003  
Production Qty: 1.000

## Sequence No. 0001

Step Item 130081520 Process Time/Qty 1.000 Step Id 1  
Description KV315\110 304S/S

Qty Required	Component
0.076	304 Sheet 3000 x 1500 x 3.0mm HR
<b>2001067</b>	
In Stock: 0.20	
0.010	304 Sheet 3000 x 1500 x 2.0mm CR
<b>2001032</b>	
In Stock: 78.57	
0.200	Mts of 110mm OD x 1.5mm Wall Longitudinally wld TP
<b>2000429</b>	
In Stock: 343.55	

## Sequence No. 0002

Step Item 3000003 Process Time/Qty 0.083 Step Id 2  
Description LASER LABOUR

## Sequence No. 0003

Step Item 3000004 Process Time/Qty 0.083 Step Id 3  
Description LASER MACHINE

## Sequence No. 0004

Step Item 3000007 Process Time/Qty 0.450 Step Id 4  
Description BRAKE PRESS

## Sequence No. 0005

Step Item 3000002 Process Time/Qty 1.000 Step Id 5  
Description FABRICATION

## Sequence No. 0006

Step Item 3000016 Process Time/Qty 0.050 Step Id 6  
Description PICKLE & PASSIVATE



# Intelligent Production - Process Sheet

Printed: 24/06/2014 13:

Process Order: **6476**

Finish Date: 16/07/2014

Sales Order: **142557**

Owner: Kent, Sean



End Product: 2004566  
KHB260\110\304 Filter Baskets Rd S/O

Finished Whs: WAR\_003

Production Qty: 1.000

Sequence No. 0001

Step Item 2004566  
Description KHB260\110\304 Filter Baskets Rd S/O  
Process Time/Qty 1.000  
Step Id 1

Qty Required	Component
0.014	316 Sheet 3000 x 1500 x 1.5mm Perforated 5mm Dia
<b>2002225</b>	
In Stock: 0.09	
0.050	304 Sheet 3000 x 1500 x 2.0mm CR
<b>2001032</b>	
In Stock: 78.57	

Sequence No. 0002

Step Item 3000003  
Description LASER LABOUR  
Process Time/Qty 0.100  
Step Id 2

Sequence No. 0003

Step Item 3000004  
Description LASER MACHINE  
Process Time/Qty 0.100  
Step Id 3

Sequence No. 0004

Step Item 3000002  
Description FABRICATION  
Process Time/Qty 0.400  
Step Id 4

Sequence No. 0005

Step Item 3000007  
Description BRAKE PRESS  
Process Time/Qty 0.400  
Step Id 5

Sequence No. 0006

Step Item 3000016  
Description PICKLE & PASSIVATE  
Process Time/Qty 0.050  
Step Id 6



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Process Control Inspection Sheet  
KS - PCIS

Rev 10 29-05-13

S/O No:	142557	Process No:		Customer:	polydeck		
Product:				KSHC20			
Tol: ±		All Dims	mm	Material Certs	Heat No. Required	Mark for Logo	

Drawing Details			Engineering Check		Testing Details		Yes	If YES give details
	Yes	No	NOTE: All Critical Dimensions to be checked must be Boxed or Highlighted on drg's					
Approved Drawings	Yes				Dye pen			
Standard Drawing	Yes				X-Ray			
DXF's Posted	Yes				Welding Jig No. (If Any)			
Finish Required		Dipped			PMI Test			
Paint details (RAL, coating thickness etc):					Pneumatic			
Engineer Sign Off:	Sean Kent	Date:	24/06/2014		Hydrostatic			
Notes to Production:					Other			

Laser			
	Yes	No	
Material Grade correct	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Thickness Check ok
Cut Quality good	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Quantity / Quality Check done
Comment:			Operator sign off: <i>[Signature]</i>
			Supervisor sign off:

Forming Brake Press			
	Yes	No	
Pre Bend Polish	<input type="checkbox"/>	<input type="checkbox"/>	Thickness Check ok
Critical Dimensions correct	<input type="checkbox"/>	<input type="checkbox"/>	Quantity / Quality Check done
Comment:			Operator sign off:
			Supervisor sign off:

Fabrication & Assembly			
	Yes	No	
Start Quantity check	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Test Fit / Run
Critical Dimensions correct	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Quantity / Quality Check done
Results of any Tests carried out:			Operator sign off: <i>[Signature]</i>
Comment:			Supervisor sign off: <i>[Signature]</i>

Polishing			
	Yes	No	
Dipped & Passivated	<input type="checkbox"/>	<input type="checkbox"/>	Electropolish to required RA
Grit Polish to required RA	<input type="checkbox"/>	<input type="checkbox"/>	Workpiece washed / neutralised
Spray Pickle	<input type="checkbox"/>	<input type="checkbox"/>	Quality Check done
Comment:			Operator sign off:
			Supervisor sign off:

Bead Blasting			
	Yes	No	
Bead Blast	<input type="checkbox"/>	<input type="checkbox"/>	Dipped & Passivated
Quantity check	<input type="checkbox"/>	<input type="checkbox"/>	Quality Check done
Comment:			Operator sign off:
			Supervisor sign off:




Painting			
	Yes	No	
Colour correct	<input type="checkbox"/>	<input type="checkbox"/>	Quality Check done
Coat thickness correct	<input type="checkbox"/>	<input type="checkbox"/>	
Comment:			Operator sign off:
			Supervisor sign off:

Wrapping & Transport			
	Yes	No	
Pallet check passed	<input type="checkbox"/>	<input type="checkbox"/>	Shrink Wrap
Crating check passed	<input type="checkbox"/>	<input type="checkbox"/>	Quality Check done
Fittings included	<input type="checkbox"/>	<input type="checkbox"/>	
Comment:			Operator sign off:
			Supervisor sign off:
Notes from Production:			



DO NOT SCALE



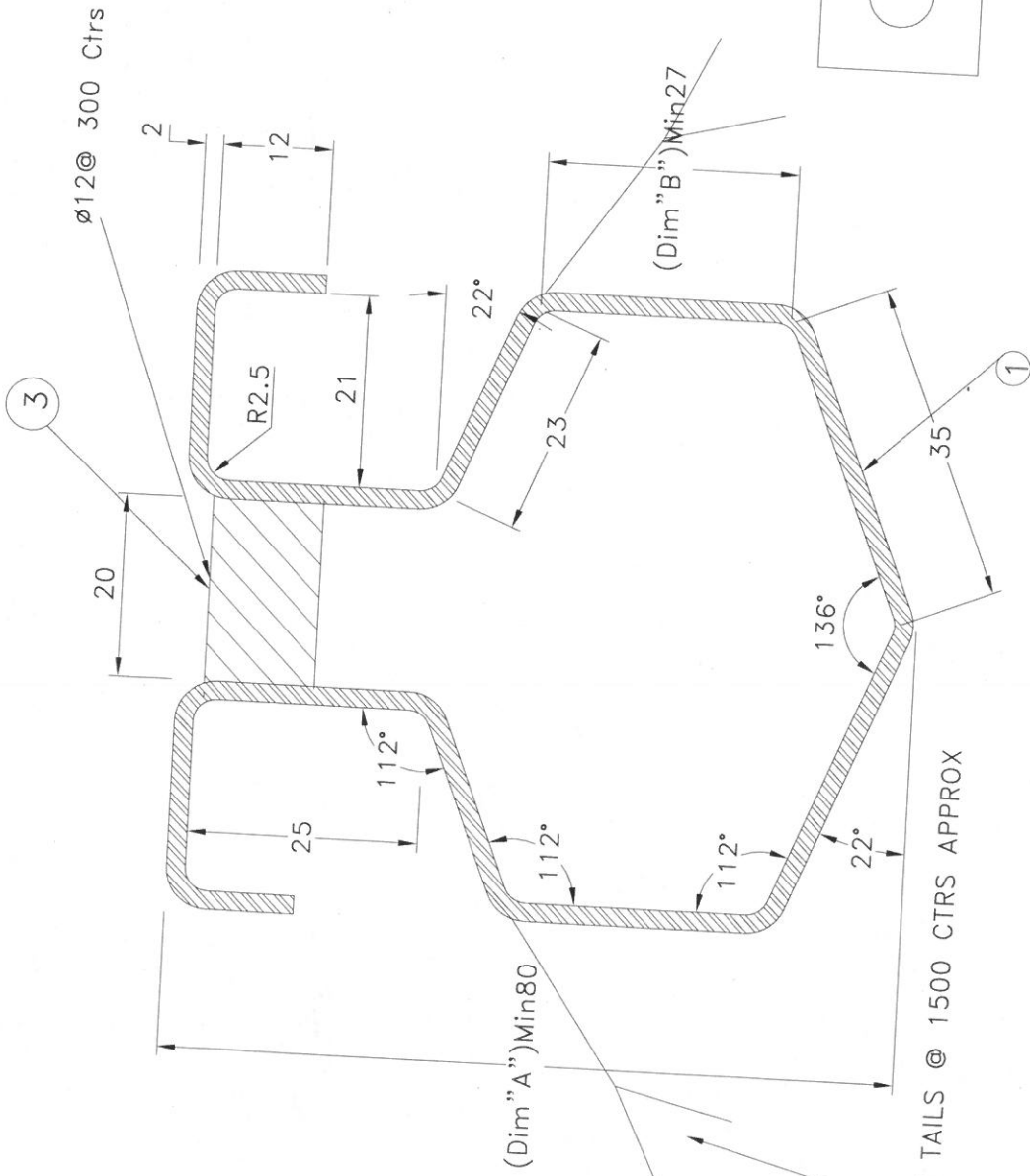
 <b>Kent</b> STAINLESS kent process technologies tel: +353 (0)53 43216 fax: +353 (0) 53 41802 www.kentstainless.com	 FIRST ANGLE PROJECTION	FILENAME	DRG. NO.	REV	SHEETS	DATE: 23/6/14
		APP6177_A	APP6177_01	A	2	
		TITLE KSHC20 SLOT CHANNEL				
		CLIENT WHITE LAKES CHEESE				
GENERAL TOLERANCES: 0-200MM ±0.5MM 200-1000MM ±1.0MM OVER 1000MM ±2.0MM ANGULAR ±0.5°		QUANTITY		DATE		APPROVED BY: 
		I OFF				
		MATERIAL		DH		
		304 SS		DH		
		FINISH		BY		DATE
				APPROVED BY:		

NOTES

:IF IN DOUBT ASK

:DEBUR ALL SHARP EDGES

:DO NOT SCALE



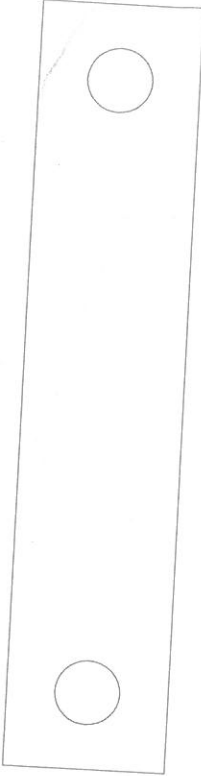
316 2B	
304 2B	✓

NOTES:

1. Std. fall 1mm in 150mm  
20mm cover 3000mm.

DEV SIZE@DimA=80

12	143	X2=	286
21			
25			
23			
27 DimB			
35			
TOTAL	143	X2=	286



37

(4) LEVELING BARS @ 1500 CTRS  
APPROX UNDERNEATH CHANNEL

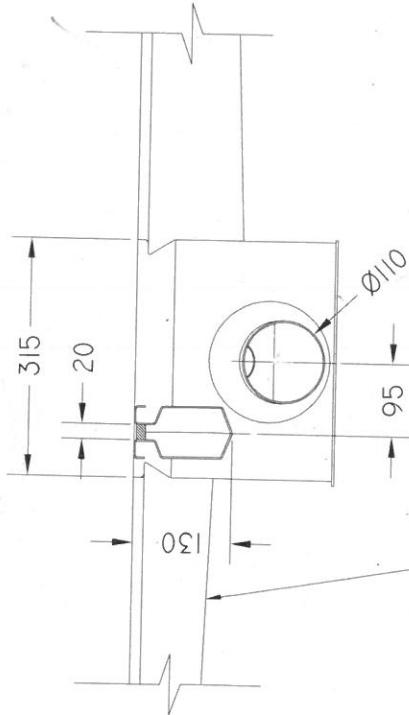
<b>Kent</b> STAINLESS KENT MANUFACTURING LTD. WORKS, WEXFORD, IRELAND (7 lines)	GENERAL TOLERANCES: 0-200MM ±0.5MM 200-1000MM ±1.0MM OVER 1000MM ±2.0MM ANGULAR ±0.5°	TITLE KSHC 20 HEX CHANNEL CLIENT	DRAWN BY B. HAMMEL DATE 15/04/98 SCALE NTS DIMENSIONS MM	QUANTITY 02	ALL CHANNELS TO BE CUT FROM 2B MATERIAL	DH GK	09/08/06
	FIRST ANGLE PROJECTION	FILENAME K944_04 DRG NO. K944_01	REV 02	SHEETS 02	FINISH DIPPED	REV 01	RELEASE GR
APPROVED BY:			BY APP.		DATE		
			G KFHOF		DATE		

# NOTES

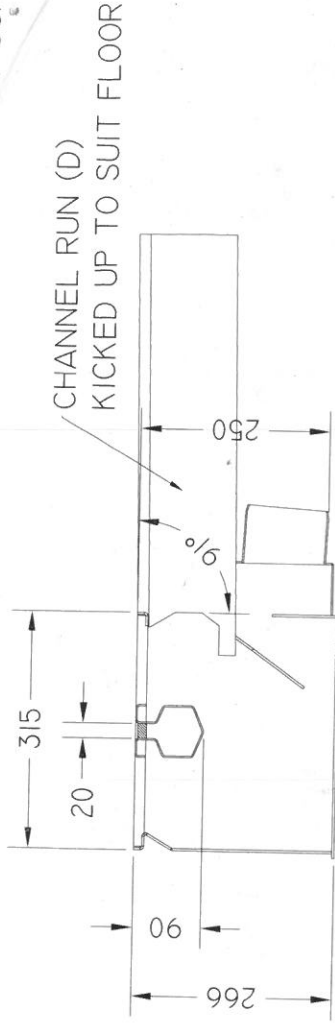
IF IN DOUBT ASK

DEBUR ALL SHARP EDGES

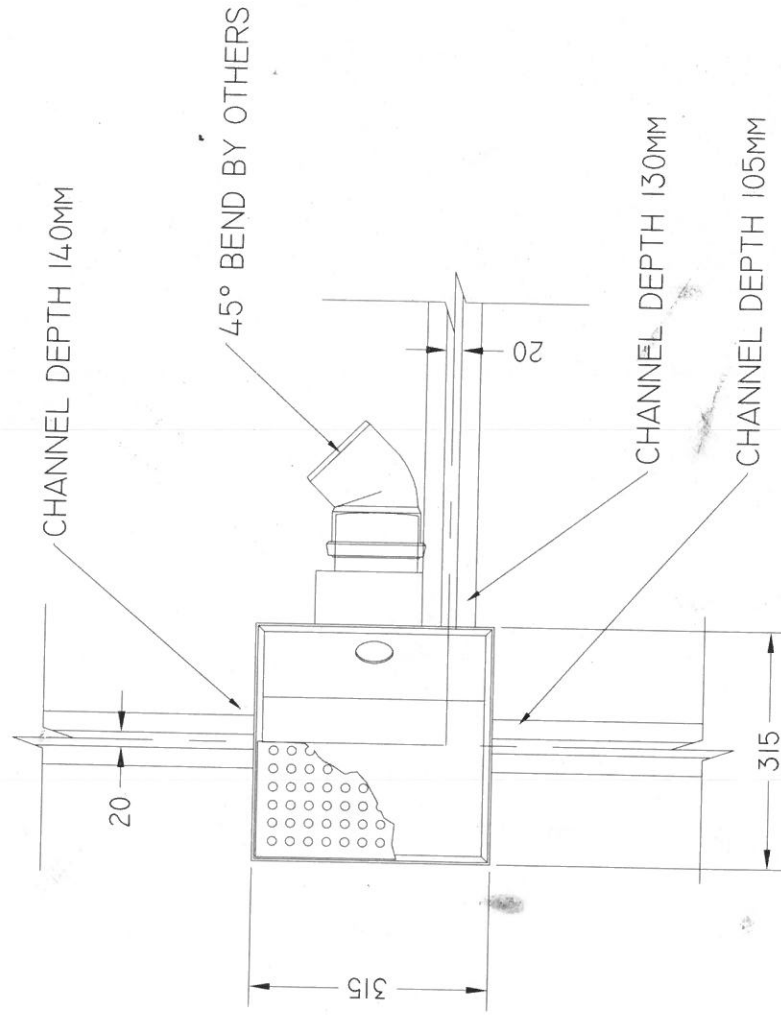
DO NOT SCALE



CHANNEL RUN (E)  
KICKED UP TO SUIT FLOOR



CHANNEL RUN (D)  
KICKED UP TO SUIT FLOOR



CHANNEL DEPTH 140MM

45° BEND BY OTHERS

CHANNEL DEPTH 130MM

CHANNEL DEPTH 105MM



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GENERAL TOLERANCES:

0-200MM  $\pm 0.5$ MM  
200-1000MM  $\pm 1.0$ MM  
OVER 1000MM  $\pm 2.0$ MM  
ANGULAR  $\pm 0.5^\circ$



FIRST ANGLE  
PROJECTION

TITLE  
KSHC20 SLOT CHANNEL

CLIENT  
WHITE LAKES CHEESE

FILENAME  
APP6177\_A

DRG. NO.  
APP6177\_02

DRAWN BY  
DH

DATE  
09/06/14

SCALE  
NTS

DIMENSIONS  
MM

QUANTITY  
1 OFF

MATERIAL  
304 SS

FINISH

REV  
A

DESCRIPTION  
FOR APPROVAL

APPROVED BY:  
skate

DATE:  
23/6/14

DH  
BY  
APP.  
DATE  
16/04/14

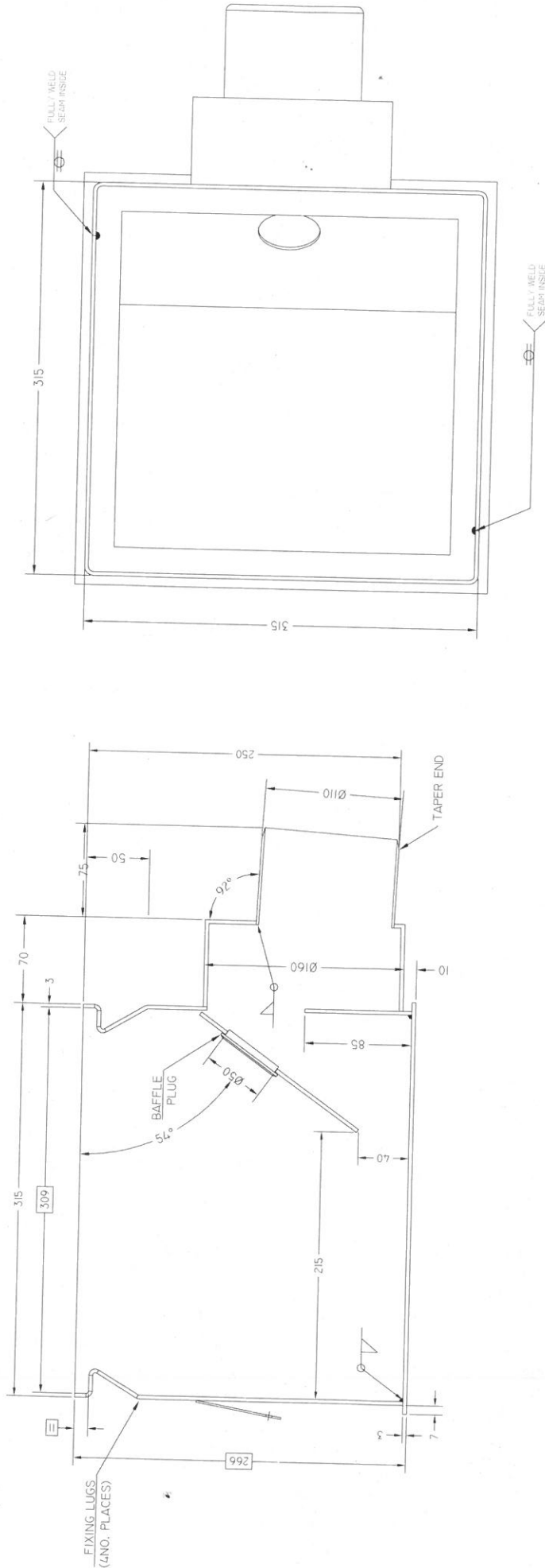


NOTES

IF IN DOUBT ASK

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GENERAL TOLERANCES:  
0-200MM  $\pm 0.5$ MM  
200-1000MM  $\pm 1.0$ MM  
OVER 1000MM  $\pm 2.0$ MM  
ANGULAR  $\pm 0.5^\circ$

TITLE  
KSHC20 SLOT CHANNEL  
CLIENT  
WHITE LAKES CHEESE  
FILENAME  
APP6177\_A  
DRG. NO.  
APP6177\_02

REV SHEETS  
A 2

QUANTITY  
1 OFF

MATERIAL  
304 SS

FINISH

APPROVED BY:  
gale

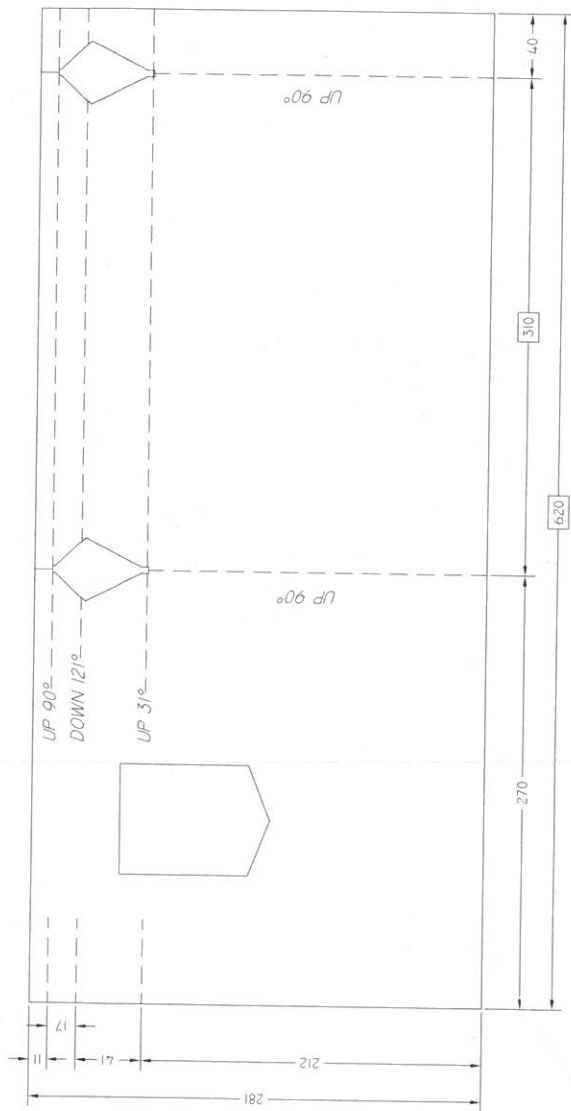
DATE:  
23/6/14

# NOTES

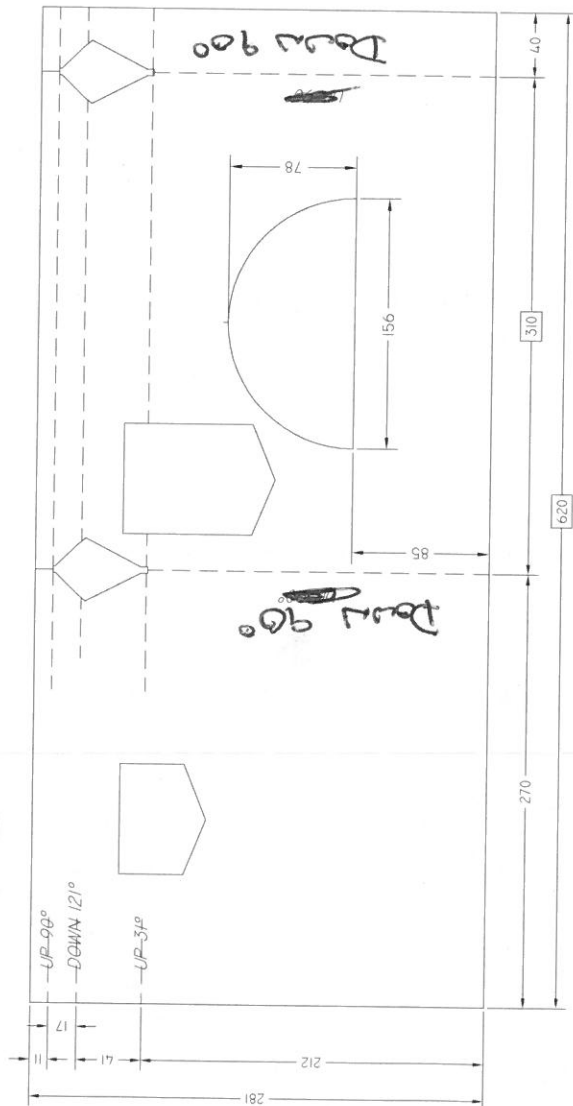
IF IN DOUBT ASK

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DO NOT SCALE



QTY: 1 NO. PER GULLY



QTY: 1 NO. PER GULLY

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GENERAL TOLERANCES:  
0-200MM  $\pm 0.5$ MM  
200-1000MM  $\pm 1.0$ MM  
OVER 1000MM  $\pm 2.0$ MM  
ANGULAR  $\pm 0.5^\circ$



FIRST ANGLE  
PROJECTION

TITLE  
KSHC20 SLOT CHANNEL  
CLIENT  
WHITE LAKES CHEESE  
FILENAME  
APP6177\_A  
DRG. NO.  
APP6177\_02

REV SHEETS  
A 2

DRAWN BY  
DH  
DATE  
09/06/14  
SCALE  
NTS  
DIMENSIONS  
MM

QUANTITY  
1 OFF  
MATERIAL  
304 SS  
FINISH

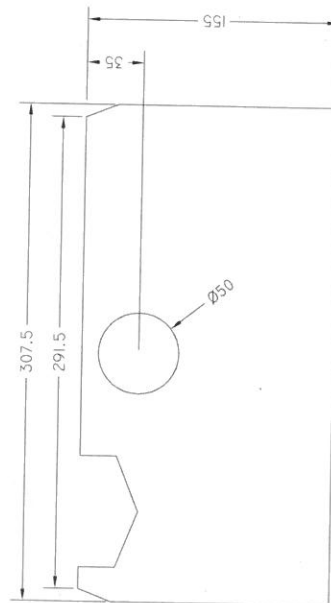
FOR APPROVAL  
REV DESCRIPTION  
APPROVED BY:  
82410

DATE:  
23/6/14

DO NOT SCALE

A hand-drawn diagram of a rectangle. The rectangle is oriented horizontally. To the left of the rectangle, there is a vertical dimension line with arrows at both ends, labeled '330'. Above the rectangle, there is a horizontal dimension line with arrows at both ends, labeled '330'. The rectangle is drawn with thin black lines on a white background.

3MM S/STEEL  
QTY: 1 NO. PER GULLY




3MM S/STEEL  
QTY: 1 NO. PER GULLY

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 **ISO 9001**

<p>GENERAL TOLERANCES:</p> <p>0-200MM <math>\pm 0.5</math>MM</p> <p>200-1000MM <math>\pm 1.0</math>MM</p> <p>OVER 1000MM <math>\pm 2.0</math>MM</p> <p>ANGULAR <math>\pm 0.5^\circ</math></p>	 <p>FIRST ANGLE PROJECTION</p>	FILENAME		DRG. NO.	REV	SHEETS	TITLE	
		APP6177_A		APP6177-02	A	2	KSHC20 SLOT CHANNEL	
		CLIENT		WHITE LAKES CHEESE				
		DRAWN BY DH		QUANTITY 1 OFF				
DATE		09/06/14					MATERIAL	
SCALE		NTS					304 SS	
DIMENSIONS MM		FINISH					REV	
APPROVED BY:		APPROVED BY:					A	
DATE:		DATE:					DH	
BY		BY					DH	
APP.		APP.					DATE	
DATE		DATE					16/04/14	

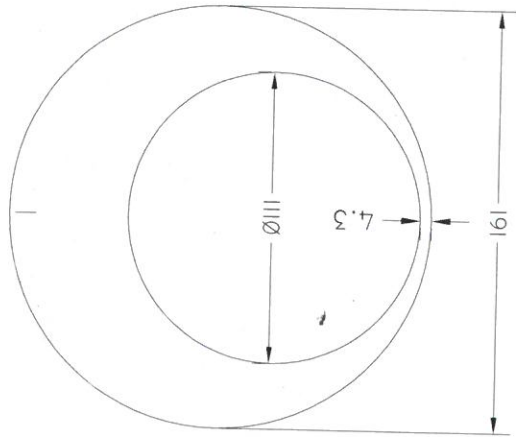


# NOTES

IF IN DOUBT ASK

DEBUR ALL SHARP EDGES

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2MM S/STEEL  
QTY: 1 NO. PER GULLY

2MM S/STEEL  
QTY: 1 NO. PER GULLY

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GENERAL TOLERANCES:  
0-200MM  $\pm 0.5$ MM  
200-1000MM  $\pm 1.0$ MM  
OVER 1000MM  $\pm 2.0$ MM  
ANGULAR  $\pm 0.5^\circ$

FIRST ANGLE  
PROJECTION

DRG. NO. APP6177\_A  
APP6177\_02

REV SHEETS  
A 2

TITLE	KSHC20 SLOT CHANNEL	DRAWN BY	DH	DATE	09/06/14
CLIENT	WHITE LAKES CHEESE	SCALE	NTS	DIMENSIONS	MM
FILENAME	APP6177_A	DRG. NO.	APP6177_02	REV	A
REV	A	SHEETS	2	DATE	09/06/14

QUANTITY	1 OFF
MATERIAL	304 SS
FINISH	

REV	A	FOR APPROVAL	DH	BY	DH	DATE	16/04/14
DESCRIPTION							
APPROVED BY:							
DATE:							23/6/14