

SALES ORDER

OPENING DATE:
ENGINEER/SALES PERSON:

24/06/2014
Jim Whelan

Kent
STAINLESS



CUSTOMER:
CLIENT:
CUSTOMER Ref:
BUSINESS UNIT:

Honeywell Measurement Irl Ltd
T/F
EC

ORDER NO: **142558**

DUE DATE: **04/07/2014**

PROCESS ORDER	CODE	QTY/ In Stock	DESCRIPTION
6481	130101420	1.00 0.00	U Beam Sample 1000mm
6483	130101440	1.00 0.00	Sample Super U Beam Top Mount
6492	130101430	1.00 0.00	Super U Beam Sample 1000mm

475 x 275

RECEIVED
PRODUCTION PLANNING

24 JUN 2014
25 JUN 2014

0818365365

12053812

IBAN IE 39B0FI 90871812

053812

Intelligent Production - Process Sheet

Printed: 24/06/2014 16:45:31

Process Order: **6492**

Finish Date: 04/07/2014

Sales Order: **142558**

Owner: Whelan, James

End Product: 130101430

Super U Beam Sample 1000mm

Finished Whs: WAR_003

Production Qty: 1.000

Sequence No. 0001

Step Item 130101430 Process Time/Qty 1.000 Step Id 1
Description Super U Beam Sample 1000mm

Qty Required	Component
1.000	Mts U Beam Super MS (32009998)
2003971	
In Stock:0.00	
2.000	Super U Beam End Plate
130009180	
In Stock:0.00	
0.300	Mts of Mild Steel Flat Bar 100 x 20mm (6m Lengths)
2003821	
In Stock:108.55	
0.005	MS Sheet 3000 x 1500 x 12.0mm HRP 275jr
2003874	
In Stock:1.91	
0.005	MS Sheet 3000 x 1500 x 5.0mm
2003860	
In Stock:1.34	
0.500	Litres of AP 45 2 Pack Epoxy Primer (Grey)
2002783	
In Stock:122.40	
0.250	Litres of AT-146 Thinners
2002781	
In Stock:126.70	
0.250	Litres of Hardener J4501
2002784	
In Stock:83.55	
0.500	Litres of Top Coat AE251/2 RAL 7032
2002786	
In Stock:77.90	
0.250	Litres of PT-1002 Thinners
2002782	
In Stock:40.20	
0.100	Litres of Hardener J2511 curing agent
2002787	
In Stock:0.80	

Sequence No. 0002

Step Item 3000003 Process Time/Qty 0.080 Step Id 2
Description LASER LABOUR

Sequence No. 0003

Step Item 3000004 Process Time/Qty 0.080 Step Id 3
Description LASER MACHINE

Sequence No. 0004

Step Item 3000002 Process Time/Qty 8.000 Step Id 4
Description FABRICATION

Sequence No. 0005

Step Item 3000009 Process Time/Qty 3.000 Step Id 5
Description PAINTING

Intelligent Production - Process Sheet

Printed: 24/06/2014 15:14:44

Process Order: **6484**

Finish Date: 04/07/2014

Sales Order: **142558**

Owner: Whelan, James

End Product: 130101440

Sample Super U Beam Top Mount

Finished Whs: WAR_003

Production Qty: 1.000

Sequence No. 0001

Step Item 130101440 Process Time/Qty 1.000 Step Id 1
Description Sample Super U Beam Top Mount

Qty Required	Component
0.005 2003874 In Stock:1.91	MS Sheet 3000 x 1500 x 12.0mm HRP 275jr 
0.005 2003860 In Stock:1.34	MS Sheet 3000 x 1500 x 5.0mm 
0.300 2003822 In Stock:23.10	Mts of Mild Steel Flat Bar 100 x 25mm (6m Lengths) 

Sequence No. 0002

Step Item 3000003 Process Time/Qty 0.080 Step Id 2
Description LASER LABOUR

Sequence No. 0003

Step Item 3000004 Process Time/Qty 0.080 Step Id 3
Description LASER MACHINE

Sequence No. 0004

Step Item 3000002 Process Time/Qty 1.000 Step Id 4
Description FABRICATION

Intelligent Production - Process Sheet

Printed: 24/06/2014 15:11:57

Process Order: 6481

Finish Date: 04/07/2014

Sales Order: 142558

Owner: Whelan, James



End Product: 130101420

Beam Sample 1000mm

Finished Whs: WAR_003

Production Qty: 1.000

Sequence No. 0005

Step Item 130101420 **Process Time/Qty** 1.000 **Step Id** 5
Description U Beam Sample 1000mm

Qty Required	Component
0.300 2002783	Litres of AP 45 2 Pack Epoxy Primer (Grey)
In Stock:122.40	
0.150 2002781	Litres of AT-146 Thinners
In Stock:126.70	
0.150 2002784	Litres of Hardener J4501
In Stock:83.55	
0.300 2002786	Litres of Top Coat AE251/2 RAL 7032
In Stock:77.90	
0.150 2002782	Litres of PT-1002 Thinners
In Stock:40.20	
0.100 2002787	Litres of Hardener J2511 curing agent
In Stock:0.80	

Sequence No. 0006

Step Item 3000002 **Process Time/Qty** 3.000 **Step Id** 6
Description FABRICATION

Sequence No. 0007

Step Item 3000009 **Process Time/Qty** 3.000 **Step Id** 7
Description PAINTING

Sequence No. 0008

Step Item 3000014 **Process Time/Qty** 0.125 **Step Id** 8
Description PACKAGING HOURS



Honeywell Measurex U Beam Inspection Report

KS-UBIR

Rev 3

12-6-13

S/O	142558	Masking Details 07350103 - 19 mm Masking 07350104 - 19 mm Masking 07350105 - 16 mm Masking
Process Order	6481	
System No.	TBC	
U Beam Length	39.4" 1000.0 mm	
Type:	Standard U Beam 2080	
Dwg No.	07350103/W	
System Name	n/a	
Any Special Features:	Single beam	

FABRICATION

- 1 Check profile of formed "U" Beams that they are within the specified tolerance as per drgs
Leg + 5mm including camber - 2mm Width is determined by the jig
Actual Camber Beam No 1 _____ **Actual Camber Beam No 2** _____
- 2 Cut "U" Beams to length as per S/O ensuring they are within the allowed tolerance
Tolerance allowed ± 1.5 mm **Actual length Beam No1** _____ **Beam No 2** _____
Note : Both Beams must be the same length
- 3 Weld in end plates using jig
- 4 Check ends for squareness. Tolerance allowed 0.12 mm **Actual used** _____
Note : Use machined end plate provided to check squareness.
- 5 Before Masking off the 19mm or 16mm on each toe of "U" beam, ensure metal is shotblasted with no traces of primer or rust. Also zig-zag profile has been applied with a grinder
This area must be to SA 2½ quality.
- 6 Double check Beams are hard stamped as above
- 7 Check that all above dimensions are in tolerance and all other checks have been carried out.

Checked by Operator: _____ Date: _____
Checked by Supervisor: _____ Date: _____

PAINTING

- 8 Check all marks and indentations have been filled and sanded
- 9 Painter to apply correct masking tape size .
Note that 07350103 is 19mm & 07350105 is 16mm masking **Actual used** _____ mm
- 10 Painter check coat of primer is applied to 70/80 microns (approx) **Actual** _____ um
- 11 Check the finish coat of paint is the correct colour as per S/O "U" Beam Schedule
- 12 Painter to check finish coat of paint is applied to 100/120 microns (Min) **Actual** _____ um

Checked by Painter: _____ Date: _____

Checked By Engineering: _____

Date: _____

NOTES FOR SHIPPING

- 13 Wipe down beams with a dry cloth and thoroughly check Beams before shiping
- 14 Ensure shiping brackets are bolted on to the agreed procedure
- 15 Check strapping of "U" Beams on the lorry to ensure safe dispatch



Super " U " Beam Inspection Report

KS-SUBIR

Rev 002

11-6-13

S/O	142558
P/O	6492
System No.	TBC
Super U Beam Length	1000mm
Type:	Super U Beam 4031
Dwg No.	07642900/C
System Name	Middle East Paper Co.
Top Mounts Required	TRUE
Dim "A" (Distance from Cable End)	TBC
Dim "B" (Distance from Motor End)	TBC
Any Special Features	Top Mounts

FABRICATION	1 Check profile of formed "Super U" Beams that they are within the specified tolerance as per drawings Leg +7 mm including camber -3 mm Width is determined by the jig Actual camber of beam _____	Checked by Operator: _____ Date: _____ Checked by Supervisor: _____ Date: _____
	2 Cut "Super U" Beams to length as per above ensuring they are within the allowed tolerance Tolerance allowed ± 1.5 mm Actual length _____ Note : Both beams must be same length	
	3 Weld in 25mm thick end plates & ensure it protudes 3mm past end of beam all the way around the edge	
	4 Weld on Top Mounts if required Dimension "A" Actual _____ Dimension "B" Actual _____	
	5 Check ends for squareness. Tolerance allowed 0.12 mm Actual _____ Note: Use machined end plate provided to check squareness	
PAINTING	6 Mask off 19 mm on each toe of "Super U" beams ensuring metal is shotblasted with no traces of rust. This area must be to SA 2½ quality.	Checked by Painter: _____ Date: _____
	7 All marks and indentations must be filled and sanded	
	8 Apply coat of primer to 70/80 microns approx Actual _____	
	9 Apply finish coat of paint to 100/120 microns Actual _____ <u>TEXTURED FINISH MUST BE APPLIED TO OUTSIDE</u>	
	Checked By Engineering: _____ Date: _____	
NOTES FOR SHIPPING	10 Ensure shiping brackets are bolted on to the agreed procedure 11 Wipe down beams with cloth and thoroughly check beams before shiping 12 Check straping of "Super U" Beams on lorry to ensure safe dispatch	