STP STP Rank STP Manoj STP Bunty STP Final STP – F

1. Extrusion Dejacketing

2. Dejacketing Roller Straightening 54+ 54+ 54+ 54+ 54+ 54+

3. Roller Straightening End Cutting Machine 54 54 54 54 54 54

4. End Cutting Machine Degreasing 14 14 14 14 14 14

5. Degreasing Annealing 15+ 47 47 32 38 47

5a. Annealing ID conditioning-Blank 10+ 16 25 45 8 5

6. ID conditioning-B Roller Straightening 55 38 52 41 44 34

7. Roller Straightening Honing 43 46 39 50 51 53

8. Honing Degreasing 26 33 34 27 26 24

9. Degreasing OD GrindingO 31 34 31 33 30 29

10. OD Grinding Quality Check 13 7 14 17 13 12

11. Quality Check Ultrasound Testing 29 16 9 7 8 8

12. Ultrasound Testing OD Conditioning 30 7 6 11 6 10

13. OD Conditioning ID Conditioning-H 10 9 13 7 5 1

13a. ID Conditioning-H Degreasing 26 33 34 27 26 24

14. Degreasing Ultrasound Testing 46 39 30 39 29 29

15. Ultrasound Testing Pilgering 17 19 14 18 19 12

16. Pilgering Degreasing 59 34 39 42 34 36

17. Degreasing Roller Straightening 66 66 66 66 66 66

18. Roller Straight End Cutting Machine 54 54 54 54 54 54

19. End Cutting Machine Honing 14 24 29 15 18 17

20. Honing Degreasing 26 33 34 27 26 24

21. Degreasing OD polishingA 18 18 18 18 18 18

22. OD polishing Eddy current Testing 17 17 11 34 8 9

22a. Eddy current Testing ID Polishing 10 14 17 36 16 16

23. ID Polishing/ECT Sand Blasting 30/21 30/21 30/15 30/39 30/15 30/15

24. Sand Blasting Boroscope 21 21 15 39 15 15

25. Boroscope Sizing 0 0 0 0 0 0

26. Sizing Pressure Testing 40 30 36 13 36 36

27. Pressure Testing HWBC & HWC 46 24 30 24 28 31

28. HWBC & HWC Ultrasound Testing 35 10 6 10 6 5

29. Ultrasound Testing End operationsS 31 21 12 21 10 9

30. End operations Weight before Autoclave 9 0 0 0 0 0

31. Weight before Autoclave Autoclaving 16 10 5 9 19 7

32. Autoclaving Hand Straightening 10 13 12 12 23 12

33. Hand Straightening Quality Check 13 13 7 29 7 7

STP - 857+ - 3428+m error path blank-112 – 448m error path tube- 40 – 160m

STP DHEERAJ - 777 – 3108 m error path blank-88 – 352m error path tube-44 – 176m

STP MANOJ - 787 - 3148m error path blank-83– 332m error path tube- 47 – 188m

STP BUNTY - 822 - 3288m error path blank-84 – 336m error path tube- 66 – 264m

STP FINAL - 742 - 2968m error path blank-66- 264m error path tube- 46 – 184m

STP FINAL - 724 -2896 m error path blank-m error path tube- m