

TEMPORARY BATCH CARD DO NOT USE UNLESS SIGNED BY MANUFACTURING ENGINEER					Part Number: NJ192437	
					Batch Number: SALV 2589	
Method 17	Day Raised	GR / MTIN No:	Material Code:	Quantity:	1	
Description: HP Turbine Blade			Day No. Material N/A	Drwg Issue No:		
Previous Batch No: N/A			Cast Number: P30016 - 11SR	Cust. Order No:		
Reason for issue: TO PROGRESS BLADE (P30016-11) THAT REQUIRES THE BELOW OPERATIONS. ORIGINAL BATCH MW0483695 HAS ALREADY BEEN DISPATCHED					Signed: <i>[Signature]</i>	
					Date: 08/03/2013	
					Stamp: MRQ1105 Valid Till: 30/06/2013	
Day Opn. Compld	Operation Number	OPERATION DESCRIPTION		Department Number	Quantity 1	Insp / Opertr Stamp
FOR ALL OPERATIONS USE MANUFACTURING INSTRUCTIONS FOR NJ192437 METHOD 17.						
<i>12/3/13</i>	2310	INSPECT ON RECEIPT		0246	1	
<i>12/3/13</i>	2410	ELECTRO DISCHARGE MACHINING		0244	1	
<i>12/3/13</i>	2450	ELECTRO DISCHARGE MACHINING		0244	1	
<i>12/3/13</i>	2470	ELECTRO DISCHARGE MACHINING		0244	1	
<i>12/3/13</i>	2490	ELECTRO DISCHARGE MACHINING		0244	1	
<i>12/3/13</i>	2590	ULTRASONIC CLEAN		0246	1	
<i>12/3/13</i>	2630	DRY BLAST		0246	1	
<i>12/3/13</i>	2650	POLISH		0246	1	
<i>12/3/13</i>	2670	INSPECT VISUAL		0246	1	
<i>20/3/13</i>	2690	CONTROL CHECK		0283	1	
<i>20/3/13</i>	2730	ALUMINISE		0281	1	
<i>15/4/13</i>	2750	CONTROL CHECK		0283	1	
<i>16 APR 2013</i>	2790	INSPECT ON RECEIPT		0246	1	
<i>16 APR 2013</i>	2950	INSPECT PENETRANT		0246	1	
<i>16 APR 2013</i>	2970	INSPECT VISUAL		0246	1	
<i>16 APR 2013</i>	2990	INSPECT BINOCULAR		0246	1	
<i>16 APR 2013</i>	3430	INSPECT VISUAL		0246	1	
<i>17-4-13</i>	3470	INSPECT VISUAL		0246	1	

OC Sheet Finished Item NJ192437, Method 20, Revision 017

Serial Number	2310	2410	2450	2470	2490	2650	2670	2730	2790
P22176-02		✓						✓	
	RR G6W	OC 245	OC 245	OC 202	OC 202	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P22176-03		✓						✓	
	RR G6W	OC 245	OC 245	OC 202	OC 202	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P22176-04		✓	✓					✓	
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P22176-05		✓						✓	
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P22176-08		✓	✓					✓	
	RR G6W	OC 245	OC 245	OC 202	OC 202	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P22176-09			✓						
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P22176-11			✓						
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P22176-12			✓					✓	
	RR G6W	OC 245	OC 245	OC 202	OC 202	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P22176-13			✓					✓	
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P22176-14				✓				✓	
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P22176-15				✓					
	RR G6W	OC 245	OC 245	OC 202	OC 202	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P22176-16				✓				✓	
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D

JES125	SFC: MW0483695	/ = Good, S = Scrap, M = In Manuf Deviation, X = Concession
	Date: 10/07/2012	C = Correction, E = Error(Inspected Only) P = Project & Accepted

OC Sheet Finished Item NJ192437, Method 20, Revision 017

Serial Number	2310	2410	2450	2470	2490	2650	2670	2730	2790
P30016-07	/	/	/	/	/	/	/	/	/
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P30016-08	/	/	/	/	/	/	/	/	/
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P30016-09	/	/	/	/	/	/	/	/	/
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P30016-10	/	/	/	/	/	/	/	/	/
	RR G6W	OC 245	OC 245	OC 202	OC 202	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P30016-11	/	/	/	/	/	/	/	/	/
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P30016-12	/	/	/	/	/	/	/	/	/
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P30016-14	/	/	/	/	/	/	/	/	/
	RR G6W	OC 245	OC 245	OC 202	OC 202	OC 783	RR G3W	CUK 13 TPG	R-R G8D
P30016-15	/	/	/	/	/	/	/	/	/
	RR G6W	OC 245	OC 245	OC 199	OC 199	OC 783	RR G3W	CUK 13 TPG	R-R G8D
INSPECTION					OC 202	OC 202			
JES125	SFC: MW0483695	/ = Good, S = Scrap, M = In Manuf Deviation, X = Concession							
	Date: 10/07/2012	C = Correction, E = Error(Insp. Only) P = Project & Accepted							

OC Sheet Finished Item NJ192437, Method 20, Revision 017

Serial Number	010	040	0490	1770	1790	1810	1950	2150	2190
P22176-02				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P22176-03				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P22176-04				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P22176-05				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P22176-08				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P22176-09				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P22176-11				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P22176-12				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P22176-13				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203	RR G6W	
P22176-14				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P22176-15				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P22176-16				✓	✓	✓			
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		

JES125	SFC: MW0483695	/ = Good, S = Scrap, M = In Manuf Deviation, X = Concession
	Date: 10/07/2012	C = Correction, E = Error(Inspected Only) P = Project & Accepted

47022174

OC Sheet Finished Item NJ192437, Method 20, Revision 017

Serial Number	010	040	0490	1770	1790	1810	1950	2150	2190
P30016-07									
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P30016-08									
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P30016-09				PF					
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P30016-10									
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203	RR G6W	
P30016-11									
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P30016-12									
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P30016-14				RA					
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
P30016-15									
	RR G3F	OC 55	OC 55	OC 698	OC 698	OC 61	OC 203		
INSPECTION							OC 39	RR G6W	RR G6W
JES125	SFC: MW0483695	/ = Good, S = Scrap, M = In Manuf Deviation, X = Concession							
	Date: 10/07/2012	C = Correction, E = Error(Inspected Only) P = Project & Accepted							

47022174

OC Sheet Finished Item NJ192437, Method 20, Revision 017

Serial Number	2970	3430																		
P22176-02			1																	
P22176-03																				
P22176-04																				
P22176-05																				
P22176-08																				
P22176-09			✓																	
P22176-11																				
P22176-12																				
P22176-13			X																	
P22176-14																				
P22176-15																				
P22176-16																				

JES125

SFC: MW0483695

/ = Good, S = Scrap, M = In Manuf Deviation, X = Concession

Date: 10/07/2012

C = Correction, E = Error(Insp. Only) P = Project & Accepted

OC Sheet Finished Item NJ192437, Method 20, Revision 017

Serial Number	2970	3430														
P30016-07																
P30016-08																
P30016-09																
P30016-10																
P30016-11																
P30016-12																
P30016-14																
P30016-15																
INSPECTION																
JES125	SFC: MW0483695	/ = Good, S = Scrap, M = In Manuf Deviation, X = Concession														
	Date: 10/07/2012	C = Correction, E = Error(Inspected Only) P = Project & Accepted														

OC Sheet Finished Item NJ192437, Method 20, Revision 017

Serial Number	3470	CONCESSIONS	INFORMATION
P22176-02			$RA = 1.26 \mu M$ 
P22176-03			
P22176-04			
P22176-05			
P22176-08			
P22176-09			
P22176-11			
P22176-12			
P22176-13			
P22176-14			
P22176-15			
P22176-16			
JES125	SFC: MW0483695	<i>I</i> = Good, <i>S</i> = Scrap, <i>M</i> = In Manuf Deviation, <i>X</i> = Concession	
	Date: 10/07/2012	<i>C</i> = Correction, <i>E</i> = Error(Inspected Only) <i>P</i> = Project & Accepted	

OC Sheet Finished Item NJ192437, Method 20, Revision 017

Serial Number	3470	CONCESSIONS	INFORMATION
P30016-07		RR G2F	
P30016-08		RR G2F	
P30016-09		RR G2F	
P30016-10		RR G2F	
P30016-11		RR G2F	
P30016-12		RR G2F	
P30016-14		RR G2F	RA = 1,14 NM OC 698
P30016-15		RR G2F	
INSPECTION		RR G2F	
JES125	ISFC: MW0483695	/ = Good, S = Scrap, M = In Manuf Deviation, X = Concession	
	Date: 10/07/2012	C = Correction, E = Error(Inspected Only) P = Project & Accepted	

Finished Item NJ192437, Method 20, Revision 017

P22176-02	X		✓						
P22176-03	X		✓						
P22176-04	X		✓						
P22176-05	X		✓						
P22176-08	X		✓						
P22176-09	X		✓						
P22176-11	X		✓						
P22176-12	X		✓						
P22176-13	X		✓						
P22176-14	X		✓						
P22176-15	X		✓						
P22176-16	X		✓						
P30016-07	X		✓						
P30016-08	X		✓						
P30016-09	X		✓						
P30016-10	X		✓						
P30016-11	X		✓						
P30016-12	X		✓						
P30016-14	X		✓						
P30016-15	X		✓						
INSPECTION									

MW0483695

Launch Date 10-07-12

Manufacturing Unit MKB
BATCH CARD

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ITEM NJ192437
(Part Number)Shop Order 002004081613
(Shop Number)SFC MW0483695
(Batch Number)Router (Method)
SAP002004081613-1/20Rev 17
(Method Issue)

Batch Qty 20.00

ITEM Description
BLADE STAGE 1 H.P.TURBINE

Serial No

Swarf

Matl QSE

Messages
SB SENSITIVE BATCH

TIMES Op/Suffix/Keywd	Operation	Group/Path Book Op	Op Cert	Resource Type (Dept)	Qty	Oper No	Insp or Op Cert	Date Op Complete	SFDM Step
2790 INSREC	0246INSREC04601 INSPECT ON RECEIPT tr= 0.000 te= 1.840 Sensitive Part Operation		Y	02460460	20	COC 116839	R-R G&D	19 NOV 2012	2790
2950 PENINS	0246PENINS0547- INSPECT-PENETRANT tr= 0.000 te= 0.480 Sensitive Part Operation		Y	02460547	20		RR G&B	20 NOV 2012	2950
2970 VISINS	0246VISINS0546- INSPECT - VISUAL tr= 0.000 te= 3.630 Sensitive Part Operation		Y	02460546	20	Comes out 7.40 am	RR G&B	20 NOV 2012	2970
2990 BINSPT	0246BINSPT0442- INSPECT-BINOCULAR tr= 0.000 te= 1.820 Sensitive Part Operation		Y	02460442	20		RR G&B	20 NOV 2012	2990
3430 VISINS	0246VISINS04422 INSPECT - VISUAL tr= 0.000 te= 3.000 Sensitive Part Operation		Y	02460442	20		R-R G&D	19 NOV 2012	3430
3470 VISINS	0246VISINS04423 INSPECT - VISUAL tr= 0.000 te= 2.180 Sensitive Part Operation		Y	02460442	20		RR G2F	26 NOV 2012	3470

MW0483695



NJ192437

MW0483695



NJ192437

PMF CUSTOMER PROTECTION

Batch Conformity Check



Rolls-Royce

Section 1 : To be completed by the overchecker.

Despatching Cell : 4

Part No : NJ192437

Batch No : MW0483695 Qty : 20

Overchecker : 64026

Name: R.S. BLAKE

Date: 25-10-12 Stamp:



Section 2 : To be completed by the overchecker.

Complete the checks as listed below, record all failures against the relevant check.

	Action	✓ or X n/a	Blade Serial No(s)	Reject Reason
1	Actual batch qty matches paperwork. Batch card and history sheet has been completed correctly, stamped, dated etc	✓		
2	All blades identified as scrap have been removed from the batch (marked 'S' history sheet).	✓		
3	The batch does not contain any non-conforming parts (marked 'M' on history sheet).	✓		
4	Details of any non-conformance has been correctly completed on the history sheet	✓		
5	Required projections & surface finish checks have been completed & endorsed on history sheet	✓		
6	Part Marking (Serial & Part number) is Correct, Legible and in correct position.	✓		
7	Lock Plate Groove & Damper/Wire Grooves (where applicable) are present	N/A		
8	All other required features are present	✓		
9	Firtree & Shd Seats (where applicable) are free from Damage.	✓		
10	For NJ191513 only 100% visual check required on Shroud Leading Edge Inducer Face Section	N/A		
11	Other blade features (inc aerofoil) are free of any obvious damage/unusual casting marks etc	✓		

If all checks are ✓ or n/a, Complete Section 3 Box A. Batch to proceed to next operation laydown area. Checklist to be attached to batch card.

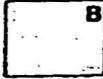
If any checks are X complete section 3 Box B. Batch to proceed to Cell Quarantine Area. Checklist to be retained with batch. Section 4 to be completed.

Section 3 : To be completed by Overchecker

A. This certifies that this batch has completed checks in Section 2 for the despatching Cells operations and does not contain any non-conforming product



B. This certifies that this batch has completed checks in Section 2 for the despatching Cells operations but contains failures, the batch has passed to section 4 for investigation & resolution



Cell Checklist Issued

PMF CUSTOMER PROTECTION

Batch Conformity Check



Rolls-Royce

Despatching Cell :

Part No :

Batch No :

Qty :

Section 4 : To be completed by Investigator/Quality Assurance Inspector/Quality engineer - List actions taken to resolve any problems identified in section 2

All non-conforming products (marked 'M' on history sheet) to be sentenced. If scrap history sheet to be endorsed "REJECT" and made removed from batch, if acceptable history sheet to be endorsed "ACCEPT"

Action No	Action Taken	Owner	Closed	Date	Comments
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					

After sentencing rejected parts to be scrapped of the SFDII system and removed before batch can proceed.

All recorded failures must be resolved before the batch leaves the Cell. Complete Section 5 .Checklist to be attached to batch card.

Section 5 : To be completed by Quality Assurance Inspector

This certifies that this batch now conforms to the checks in Section 2 and all failures raised have been resolved. All non-conformance produced in the Cell has been sentenced and removed from the batch.

Name :

Date:

Stamp :

BATCH CARD SEQUENCE ALTERATION APPROVAL

Part Number	NJ192437	Batch Number	Method 20	Rev 10
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This approval sheet must be attached to the Router on launch. Approval sheet must be signed by Manf. Engineering and scanned with the router

Authorisation is approved for the following operation sequence changes.

Reason:

THIS SEQUENCE IS FOR RTM322 HP1 PARTS THAT REQUIRE AN ADDITIONAL AQUEOUS CLEAN AFTER PENETRANT INSPECT TO AID VISUAL INSPECTION. PENDING FPA 02/14772.

Page	Operation/s	Change	Requirements	Restrictions
5	2970	Complete operation 2970 as per manufacturing instructions	Stamp and complete batchcard & history sheet	Must be complete before OP2980
	2980	AQUEOUS CLEAN	Datacard DHC260717. Stamp and complete batchcard & history sheet	Must be completed after OP2970 and before OP2990
5	2990	Complete operation 2990 as per manufacturing instructions	Stamp and complete batchcard & history sheet	Must be complete after OP2980

REVISED OPERATION ROUTE TO COVER SEQUENCE CHANGE.

Date	Operation	Dept	Change	Qty	Stamp
20/11/12	2980	246	AQUEOUS CLEAN	20	OC 75

This approval sheet must be attached to the Router on launch.

Approval sheet must be signed by Manf. Engineering and scanned with the router

Manf. Engineering Approval <i>Andrew Poole</i> <i>Gary Wilson</i>	Date 28/06/2012	Stamp RRQ1105	Valid Till 01/08/2012
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Launch Date 10-07-12

Manufacturing Unit MKB
BATCH CARD

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ITEM NJ192437

(Part Number)



Shop Order 002004081613

(Shop Number)



SFC MW0483695

(Batch Number)

Router (Method)
SAP002004081613-1/20Rev 17
(Method Issue)

Batch Qty 20.00

ITEM Description
BLADE STAGE 1 H.P.TURBINE

Serial No

Swarf

Matl QSE

Messages

SB SENSITIVE BATCH

TIMES Op/Suffix/Keywd	Operation	Group/Path Book Op	Op Cert	Resource Type (Dept)	Qty	Oper No	Insp or Op Cert	Date Op Complete	SFDM Step
2150 VISINS	0246VISINS0442- INSPECT - VISUAL tr= 0.000 te= 2.800 Sensitive Part Operation		Y	02460442	20		RR G6W	14 AUG 2012	2150
2170 CONCHK	0283CONCHK2360- CONTROL CHECK tr= 0.000 te= 0.010		Y	02832360	20		RR G3F	14 AUG 2012	2170
2190 PLATE	0281PLATE0090- PLATE tr= 0.000 te= 17.320 Sensitive Part Operation			02810090	20		RR G3F	14 AUG 2012	2190
2290 CONCHK	0283CONCHK23601 CONTROL CHECK tr= 0.000 te= 0.010 Sensitive Part Operation		Y	02832360	20		RR G4J	11 OCT 2012	2290
2310 INSREC	0246INSREC0460- INSPECT ON RECEIPT tr= 0.000 te= 1.840 Sensitive Part Operation		Y	02460460	20		RR G6W	13 OCT 2012	2310
2410 EDM	0244EDMROBO- ELECTRO DISCHARGE MACHINING tr= 0.000 te= 4.950 Sensitive Part Operation		Y	0244ROBO	20		OC 245	23/10/12	2410
2450 EDM	0244EDM0118- ELECTRO DISCHARGE MACHINING tr= 0.000 te= 3.450 Sensitive Part Operation		Y	02440118	20		OC 245	23/10/12	2450
2470 EDM	0244EDM01181 ELECTRO DISCHARGE MACHINING tr= 0.000 te= 4.650 Sensitive Part Operation		Y	02440118	20		OC 202	25/10/12	2470

MW0483695



NJ192437

MW0483695



Launch Date 10-07-12

**Manufacturing Unit MKB
BATCH CARD**

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ITEM NJ192437
(Part Number)Shop Order 002004081613
(Shop Number)SFC MW0483695
(Batch Number)Router (Method)
SAP002004081613-1/20Rev 17
(Method Issue)

Batch Qty 20.00

ITEM Description
BLADE STAGE 1 H.P.TURBINE

Serial No

Swarf

Matl QSE

Messages

SB SENSITIVE BATCH

TIMES Op/Suffix/Keywd	Operation	Group/Path Book Op	Op Cert	Resource Type (Dept)	Qty	Oper No	Insp or Op Cert	Date Op Complete	SFDM Step
2490 EDM	0244EDM01182 ELECTRO DISCHARGE MACHINING tr= 0.000 te= 17.150 Sensitive Part Operation		Y	02440118	20		OC 202	26/10/12	2490
2590 USNCLN	0246USNCLN0709- ULTRASONIC CLEAN tr= 0.000 te= 1.000 Sensitive Part Operation		Y	02460709	20	OC 65	OC 65	25 OCT 2012	2590
2630 DRBLST	0246DRBLST1402- DRY BLAST tr= 0.000 te= 1.210 Sensitive Part Operation		Y	02461402	20	OC 747		25/10/12	2630
2650 POLISH	0246POLISH1401- POLISH tr= 0.000 te= 4.780 Sensitive Part Operation		Y	02461401	20	OC 783		27/10/12	2650
2670 VISINS	0246VISINS04421 INSPECT - VISUAL tr= 0.000 te= 2.800 Sensitive Part Operation		Y	02460442	20		RR G3W	26th Oct 2012	2670
2690 CONCHK	0283CONCHK23602 CONTROL CHECK tr= 0.000 te= 0.010 Sensitive Part Operation		Y	02832360	20		RR G1C	31 OCT 2012	2690
2730 ALUMIN	0281ALUMIN0092- ALUMINISE tr= 0.000 te= 57.500			02810092	20		RR G1C	31 OCT 2012	2730
2750 CONCHK	0283CONCHK23603 CONTROL CHECK tr= 0.000 te= 0.010 Sensitive Part Operation		Y	02832360	20		RR G1C	1 NOV 2012	2750

MW0483695



NJ192437

MW0483695



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Launch Date 10-07-12

Manufacturing Unit MKB
BATCH CARD

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ITEM NJ192437

(Part Number)



Shop Order 002004081613

(Shop Number)



SFC MW0483695

(Batch Number)



Router (Method)
SAP002004081613-1/20



Rev 17
(Method Issue)

Batch Qty 20.00

ITEM Description
BLADE STAGE 1 H.P.TURBINE

Serial No

Swarf

Matl QSE

Messages
SB SENSITIVE BATCH

Customer STANDARD PRODUCTION



Customer ID PROD



Customer Order PP01

Manuf Area BLD2



Order Type P



Order Quantity 20.00



Plan Compl Date 25-09-12



DRAWING ISSUE STANDARD (IF REQUIRED)

GR/MATL RELEASE NOTE (IF REQUIRED)

Material Details Issued

Serial Number

REFER TO MANUFACTURING INSTRUCTIONS (MI) FOR ALL MANUFACTURING INFORMATION

MW0483695



NJ192437

MW0483695



NJ192437

20

Launch Date 10-07-12

Manufacturing Unit MKB
BATCH CARD

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ITEM NJ192437
(Part Number)Shop Order 002004081613
(Shop Number)SFC MW0483695
(Batch Number)Router (Method)
SAP002004081613-1/20Rev 17
(Method Issue)

Batch Qty 20.00

ITEM Description
BLADE STAGE 1 H.P.TURBINE

Serial No

Swarf

Matl QSE

Messages
SB SENSITIVE BATCH

TIMES Op/Suffix/Keywd	Operation	Group/Path Book Op	Op Cert	Resource Type (Dept)	Qty	Oper No	Insp or Op Cert	Date Op Complete	SFDM Step
0001 MARSHL	BLD2MARSHL- MARSHALLING OPERATION		Y	BLD2MSHL	20		RR G3F	09 JUL 2012	1
0010 CONCHK	0244CONCHK0001- CONTROL CHECK tr= 0.000 te= 0.250		Y	02440001	20		RR G3F	09 JUL 2012	10
0040 FITINS	0227FITINS0060- FIT INSERTS tr= 0.000 te= 0.800 Sensitive Part Operation		Y	02270060	20		OC 55	25/07/12	40
0490 SURGRD	0242SURGRD0127- SURFACE GRIND tr= 0.000 te= 5.800 Sensitive Part Operation		Y	02420127	20		OC 55	25/07/12	490
1770 GRIND	0244GRINDMAKO- GRINDER OPERATOR tr= 0.000 te= 10.330 Sensitive Part Operation		Y	0244MAKO	20		OC 698	4-8-12	1770
1790 ENGRVE	0244ENGRVEENGR- ENGRAVE tr= 0.000 te= 1.000 Sensitive Part Operation		Y	0244ENGR	20		OC 698	4-8-12	1790
1810 GRIND	0244GRIND0129- GRINDER OPERATOR tr= 0.000 te= 4.720 Sensitive Part Operation		Y	02440129	20	OC 61	OC 39	06 AUG 2012	1810
1950 POLISH	0247POLISH0218- POLISH tr= 0.000 te= 3.870 Sensitive Part Operation		Y	02470218	20		OC 203	07/08/12	1950

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