

Workorder Information			
Startup date:	10.06.13	Del. date:	14-06-13
Production place:	Svendborg	Salesp.	Leif Riis
Customer:	Thybotech Aps	Contactp.	Thorben Nørskov
Customer email:	thorben@thybotech.dk	Phonen.	
Item name:	Pumpe	Item-n.	
1 stk. pumpe blæses indiv. Og udv, se tidligere billeder på 4062. Pas på pakflader, hus og løber coates 2 gange med 855, husk afbalancering af løber. - udvendig får den grunder og top 4008.			
Customer PO:	Kølevandspumpe 2 - Dong HEV	Ref. no.:	

10 Recieve control			
Description	Requirement	Result	Date/sign
Recieve control	PI-1 recieve control	ok	07.06.13 RT
Foto documentation	take picture	ok	07.06.13 RT

20 Disassemble and worn out areas ident.			
Description	Requirement	Result	Date/sign
Carefull disassemble	acc. to customer spec	NA	
Worn out areas identified	PI-2 mark up areas	OK	11.6.13 TK
Grinding if sharp edges	min. R2	OK	12.6.13 TK
Emulsion wash	steam wash + emulsion	OK	11.6.13 TK
Foto documentaton	take picture	OK	12.6.13 TK

30 Machining before coating			
Description	Requirement	Result	Date/sign
Identify areas for machin.	mark up areas	NA	
Identify machining depth	1 mm.	NA	
Machining supplier	name	NA	
Control machined areas	Visuel control	NA	
Foto documentaton	take picture		

40 Abrasive blasting and surface analysis							
Description	Requirement	Result					Date/sign
		step 1	step 2	step 3	step 4	step 5	
Remove ident. number signs before bl.		OK	OK				12.6.13 TK
Masking before blasting sensitive area		OK	OK				12.6.13 TK
Oil and grease	GT-6: none	OK	OK				12.6.13 TK
Chlorides	GT-1: <50 mg/m2	NA	30				12.6.13 TK
Ph	GT-2: 6-9	NA	7				12.6.13 TK
Fe2+	GT-3: <10 µg/cm2	NA	2				12.6.13 TK
Cleanliness	GT-4: SA 2,5 to SA 3	3	2,5				12.6.13 TK
Profile	GT-4: 75 - 125 micron	23 Mic	79				12.6.13 TK
Rework method	Blast/Dem./HP/Oven	NA	NA				12.6.13 TK
Surface defects	no surface defects	OK	OK				12.6.13 TK
Blast materials		Glas/ steel Grit					12.6.13 TK
Add. materials		Kr 500,-					12.6.13 TK
Foto documentaton	take picture				OK		12.6.13 TK

50 Coating application									
Coating area:		Løber		Indv.		Indv.		udv. RAL. 4008	
Coating material:		ARC 858		ARC 855 GY		ARC 855 BL		Grunder/top coat	
Required thickness:		Rep.		min 250 My		min 250 My		100 My	
Description	Result	Date/Sign	Result	Date/Sign	Result	Date/Sign	Result	Date/Sign	
Masking before coating	NA	12.6.13 TK	OK	12.6.13 TK	NA	12.6.13 TK	OK	13.6.13 TK	
Airtemperatur > 10 °C	20	12.6.13 TK	21,6	12.6.13 TK	22,9	12.6.13 TK	21,4	13.6.13 TK	
RH < 85%	50,8	12.6.13 TK	52,7	12.6.13 TK	49,6	12.6.13 TK	65,7	13.6.13 TK	
Dewpoint	9,5	12.6.13 TK	11,5	12.6.13 TK	11,8	12.6.13 TK	14,7	13.6.13 TK	
Surface temp. > 10°C	19,5	12.6.13 TK	21,2	12.6.13 TK	22	12.6.13 TK	21,4	13.6.13 TK	
Dewpoint Δ > 3°C	10	12.6.13 TK	9,7	12.6.13 TK	10,2	12.6.13 TK	6,7	13.6.13 TK	
Cleaning dust no dust	OK	12.6.13 TK	OK	12.6.13 TK	OK	12.6.13 TK	OK	13.6.13 TK	
Coating/wet film GT-7	1mm	12.6.13 TK	300 My	12.6.13 TK	NA	12.6.13 TK	130 MY	13.6.13 TK	
Overcoat time See datas.	OK	12.6.13 TK	OK	12.6.13 TK	NA	12.6.13 TK	OK	13.6.13 TK	
Foto document. Take pic.	OK	12.6.13 TK	OK	12.6.13 TK	OK	12.6.13 TK	OK	13.6.13 TK	
Material lot number			O86646		O86644				
	120131		O86647		O86645		12883238		
Material stock number			120330		120409		11490306		
	O83346		120315		120315		O13083008		
Material consumption	25 Gram		1,8 KG		1,5 KG		3,5 l.		
Additional consumption:									

60 Machining after coating			
Description	Requirement	Result	Date/sign
QC report from supplier	recieved	NA	
Control machined areas	visuel control	NA	
Foto documentation	take picture	NA	

70 Coating control									
Coating material		ARC 858		ARC 855 GY		ARC 855 BL		Grunder/top coat	
Description	Requirem.	Result	Date/Sign	Result	Date/Sign	Result	Date/Sign	Result	Date/Sign
Dry film thickness GT-8		NA		NA		568 MY	14.6.13 TK	111 MY	14.6.13 TK
Pinhole control GT-5		NA		NA		OK	13.6.13 TK	OK	13.6.13 TK
Visuel control GT-9		OK	12.6.13 TK	OK	12.6.13 TK	OK	13.6.13 TK	OK	13.6.13 TK
Remove coating spills						OK	12.6.13 TK	OK	13.6.13 TK
Sea water test MOT85									
Foto documentation	take picture					OK		OK	

80 Postcuring			
Description	Requirement	Result	Date/sign
Postcure	95C for 12h or 95C IR 2 h	NA	
Foto documentation	take picture	NA	

90 Assemble			
Description	Requirement	Result	Date/sign
Carefull assembly of item	acc. to customer spec.	NA	
Foto documentation	take picture	NA	

100 Final control			
Description	Result	Date/sign	
Balancing of rotating impellers	OK	13.6.13 tk	
Item safely packed PI-3	OK	14.6.13 TK	
Foto documentation take picture	OK	14.6.13 TK	
Supervisor approval of all processes / green label	OK	14.6.13 RT	