Kettlewell Machine Works

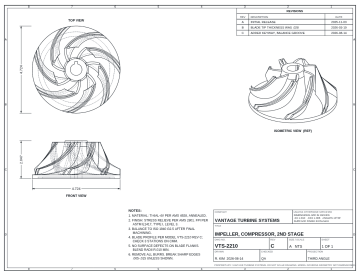
VTS-2210 · Rev C

Compressor impeller

WORK ORDER

1.1

Customer / PO	Vantage Turbine Systems / VT-660412
Customer work number	—
Quantity	12 pcs
Due date	Nov 6
Work center	DMG Mori DMU 50 5-axis
Material / lot	Titanium Ti-6Al-4V / Heat K27810
Priority	High
Requirements	Material certificate required; C of C required



Drawing VTS-2210 rev C

#	Operation	Qty good	Operator	Date	Sign-off
1	PO Received				
2	Contract review & traveler Alex Rivera				
3	Order material: Ti-6Al-4V bar Ø5.0" Rosa Delgado				
4	Saw blanks HE&M H90A band saw · Tyler Nguyen · setup 10 min, 8 min/pc				
5	CAM programming Luis Gomez · Program O2210-10 / O2210-20				
6	5-axis Op 10: hub & rough blades DMG Mori DMU 50 5-axis · Jamal Wright · Program O2210-10, setup 90 min, 38 min/pc				
7	Stress relieve AMS 2801 (outside) Outside: heat treat · Rosa Delgado				
8	5-axis Op 20: blades DMG Mori DMU 50 5-axis · Jamal Wright · Program O2210-20, setup 60 min, 142 min/pc				

#	Operation	Qty good	Operator	Date	Sign-off
9	Wire EDM keyway Mitsubishi MV2400R wire EDM · Tyler Nguyen · setup 30 min, 24 min/pc				
10	Deburr & break edges Deburr bench · Dana Brooks · setup 5 min, 18 min/pc				
11	Balance to ISO 1940 G2.5 Jamal Wright · setup 20 min, 9 min/pc				
12	FPI per ASTM E1417 (outside) Outside: NDT (FPI / MPI) · Rosa Delgado				
13	CMM inspection & FAI (AS9102) Zeiss Contura CMM · Kim Oh · setup 45 min, 22 min/pc				
14	Shipping				

Notes / issues

Current status: Machining

Printed Oct 29, 7:29 PM. Check the workspace for current revision and release conditions.