



# Job Order



Job Order No. : J2403-0066  
 Start Date : 27/03/2024  
 Completion Date : 30/03/2024

Order No : FOR STOCK-1  
 Item No. & Desc. : CPH845H9XXH00TC--3 1/2" Hydro Trip Sub, 13Cr-80 Material, BLANK ends for 3-1/2" 9.2# TSH CS Hydril threads  
 Drawing No : CPH845H9XXH00TC Drawing Rev No : 01 Qty. : 30 nos  
 Special Instruction : CPH845H9XXH00TC--3 1/2" Hydro Trip Sub, 13Cr-80 Material, BLANK ends for 3-1/2" 9.2# TSH CS Hydril threads . FOR SO2324/00027-2. USE QP-2324-27-1-1.

| Sr No. | Item No. & Desc.   | Drawing No.        | Lot No.           | Lot Ref No.                   | BOM Qty. | Req. Qty. | Issued Qty. | Avail. Qty. | Bal. Qty. | UOM |
|--------|--|--------------------|-------------------|-------------------------------|----------|-----------|-------------|-------------|-----------|-----|
| 1      | CPH845H9XXH00TC1--TOP SUB FOR 3 1/2" Hydro Trip Sub, 13Cr-80 Material, BLANK ends for 3-1/2" 9.2# TSH CS Hydril threads MATERIAL : API L80-13Cr, 23 HRC MAX    | CPH845H9XXH00TC1   | J2402-0041#01     | 383                           | 1.000    | 30        | 10          | 30          | 0         | nos |
|        |  |                    | J2403-0020#01     | 23210024170                   |          |           | 20          |             |           |     |
| 2      | 05212A--2-1/2 STEEL BALL MATERIAL : SS 316 / SS304 / SS316L/AISI E52100  | 05212A             | LOT/03005/2023-24 | 3T 01/17                      | 1.000    | 30        | 7           | 30          | 0         | nos |
|        |  |                    | LOT/02589/2023-24 | 3T 01/17                      |          |           | 23          |             |           |     |
| 3      | CPH845H9XXH00TCH92--COLLET SUB-ASSEMBLY  | CPH845H9XXH00TCH92 | J2403-0033#01     | 22L1248/H-323/3907BHU-2024    | 1.000    | 30        | 8           | 30          | 0         | nos |
|        |  |                    | J2403-0033#02     | 22L1248/H-387/3907BHU-2024    |          |           | 20          |             |           |     |
|        |  |                    | J2403-0033#03     | 22L1248/H-323/3907XNTBHU-2024 |          |           | 2           |             |           |     |
| 4      | CPH845H9XXH00TC3--SHEAR RING FOR 3 1/2" Hydro Trip Sub, 13Cr-80 Material, BLANK ends for 3-1/2" 9.2# TSH CS Hydril threads MATERIAL : API L80-13Cr, 23 HRC MAX | CPH845H9XXH00TC3   | J2402-0042#01     | 3544M                         | 1.000    | 30        | 10          | 30          | 0         | nos |
|        |  |                    | J2403-0050#01     | 3MALV22372                    |          |           | 20          |             |           |     |
| 5      | CPH845H9XXH00TC4--BOTTOM SUB FOR 3 1/2" Hydro Trip Sub, 13Cr-80 Material, BLANK ends for 3-1/2" 9.2# TSH CS Hydril threads MATERIAL : API L80-13Cr, 23 HRC MAX | CPH845H9XXH00TC4   | J2403-0021#01     | 23210024170                   | 1.000    | 30        | 20          | 30          | 0         | nos |
|        |  |                    | J2402-0043#01     | 383                           |          |           | 10          |             |           |     |
| 6      | 0638242381--DIA 3/8-24 X 0.38 LTH, SHEAR SCREW DOG TYPE MATERIAL : BRASS UNS C46400  | 0638242381         | J2403-0058#01     | 22-04-17061-1                 | 12.000   | 360       | 72          | 360         | 0         | nos |
|        |  |                    | J2405-0093#01     | 22-04-17061-1                 |          |           | 89          |             |           |     |
|        |  |                    | J2405-0093#02     | 22-04-17061-1                 |          |           | 199         |             |           |     |

|   |   |            |                   |                 |       |     |     |     |   |     |
|---|---|------------|-------------------|-----------------|-------|-----|-----|-----|---|-----|
| 7 | 0314203511--HEX SOCKET SET SCREW DIA 1/4-20 X 5/16 LTH MATERIAL : STAINLESS STEEL | 0314203511 | LOT/02686/2023-24 | NA              | 4.000 | 120 | 120 | 120 | 0 | nos |
| 8 | 01239H9--O-RING 2-239 MATERIAL HNBR 90 DURO                                       | 01239H9    | LOT/02513/2023-24 | H-36652SUL-2023 | 1.000 | 30  | 30  | 30  | 0 | nos |

| Process No | Process                              | Shop Floor | Machine Type                | Cycle Time | SOP                         | Process Parameter | Program |
|------------|--------------------------------------|------------|-----------------------------|------------|-----------------------------|-------------------|---------|
| 1          | ASSEMBLY                             | Inhouse    | Manual                      | 15         | SOP-GEN-4 WITH LETEST REV.  | N.A.              | N.A.    |
| 2          | DRIFT TEST                           | Inhouse    | Manual                      | 0          | N/A                         | N.A.              | N.A.    |
| 3          | HYDROTEST                            | Inhouse    | hydraulic test pump machine | 30         | SOP-GEN-31 WITH LETEST REV. | N.A.              | N.A.    |
| 4          | FINAL MARKING AS PER SO INSTRUCTION. | Inhouse    | Marking machine             | 2          | SOP-GEN-11 WITH LATEST REV. | N.A.              | N.A.    |

| Date       | Process Seq. No | Machine                 | Operator     | Acp. Qty. | Rej. Qty. | Set. Rej. Qty. | Setting Time (hrs.) | Start Time  | End Time    |
|------------|-----------------|-------------------------|--------------|-----------|-----------|----------------|---------------------|-------------|-------------|
| 22/05/2024 | 1               | Manual                  | RANJIT KUMAR | 6         | 0         | 0              |                     | 08:00:00 AM | 08:00:00 PM |
| 22/05/2024 | 2               | Manual                  | NIRMAL SAHU  | 6         | 0         | 0              |                     | 08:30:00 AM | 07:30:00 PM |
| 22/05/2024 | 3               | hydraulic pressure pump | RANJIT KUMAR | 6         | 0         | 0              |                     | 08:00:00 AM | 08:00:00 PM |
|            |                 |                         |              |           |           |                |                     |             |             |
|            |                 |                         |              |           |           |                |                     |             |             |
|            |                 |                         |              |           |           |                |                     |             |             |
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|            |                 |                         |              |           |           |                |                     |             |             |
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|            |                 |                         |              |           |           |                |                     |             |             |
|            |                 |                         |              |           |           |                |                     |             |             |

| Process Seq. No | Rejection Reason | Rej. Qty. |
|-----------------|------------------|-----------|
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| Parameter               | Specification | Upper Limit | Lower Limit | Instrument / Gauge Used | Sampling |
|-------------------------|---------------|-------------|-------------|-------------------------|----------|
| <b>DRIFT TEST</b>       |               |             |             |                         |          |
| Drift Test Verification | Drift Test    | Ok          | Not Ok      | CPS-DM-0312-92-42       | 1        |

Prepared By

QA Approval

Data Entry

Authorisation

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Unit No.1, Survey No. 244,Orchid Industrial Estate, Chinchpada Vasai East, Maharashtra. Pin - 401208, India  
P: E: CIN No. : U29220MH2011PTC220510