

HSD MARINE AND SHIPREPAIR PTE LTD

No-1 Kian Teck Drive. Singapore (628818)

WORK REPORT

Item	Materials Inspection with Lloyd's Surveyor		
Subject	Intermediate Shaft Coupling Bolt Supply		
Vessel		Job Number	2993
Maker	NA	Location	Singapore



Round Bar, Unmachined AISI 4140 (Heat No : 384277) (21.11.17)



Inspection on Site with Lloyd's Surveyor (15.11.17)



Surveyor Marked On Material (15.11.17)



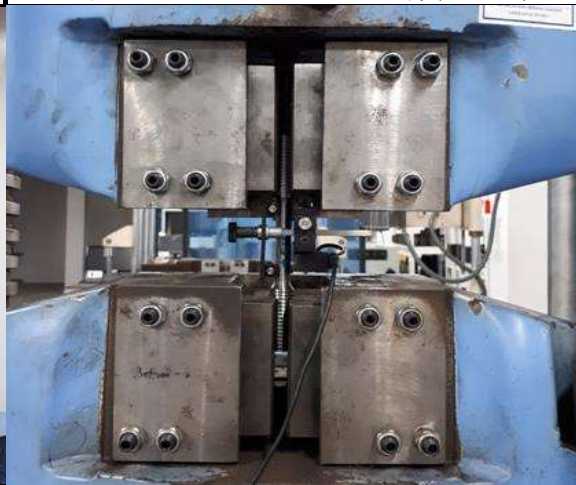
Prepare Material 250mm L for Lap Test (16.11.17)



Prepare Test Piece for Tensile & Charpy (17.11.17)



Prepare for Tensile Test (17.11.17)



Prepare for Tensile Test (17.11.17)



Prepare for Tensile Test (17.11.17)



Test Piece put on Dry Ice to get (-29 & -46deg) (17.11.17)



Prepare for Charpy Impact Test (17.11.17)



Prepare for Charpy Impact Test on (-29deg) (17.11.17)



Prepare for Charpy Impact Test (17.11.17)



Prepare for Charpy Impact Test on (-46deg) (17.11.17)



Self Calibration 0.0mm on Bore Gauge Set (21.11.17)



Measurement taken Bolt Hole from Flange (21.11.17)



Prepare Materials for Machining (22.11.17)



Marking Center Point on Raw Materials (22.11.17)



Machining Bolt Head on Lathe Machine (22.11.17)



Prepare Machining on CNC machine (22.11.17)



Machining Bolt on CNC machine (23.11.17)



Take Measurement on old Nut (23.11.17)



Threading on CNC Machine (23.11.17)



Checking on Thread with old Nut (23.11.17)



Machining Bolt head on Lathe Machine (23.11.17)



Tapping M36 on Bolt Head (23.11.17)



Milling Spanner Faces on Bolt Head (23.11.17)



Drilling Dia10mm for Split Pin Hole on Bolt (23.11.17)



Completed Milling, Threading, Drilling, Tapping on Bolt



Final Polishing to middle of given tolerance (23.11.17)



Witness & Stamped by Lloyd's Surveyor



Stamped LR Control No SNG 1705273 (24.11.17) 6pcs



Stamped LR Control No SNG 1705273 (27.11.17) 26pcs



Stamped LR Control No SNG 1705273 x 32pcs



Apply with tin layer oil



Wrapping with Oil Paper on Bolt



Wrapping & Marking on packed bolt



Packed With Pallet 1 & 2



Packed With Pallet 3 & 4



Fixed With New Bolts

Attachment :

- ** (1) Coupling Bolt Drawing
- ** (2) Tail Shaft Drawing
- ** (3) Mill Certificate
- ** (4) Lab Test Report
- ** (5) Lloyd's Surveyor Report
- ** (6) Measurement Report
- ** (7) MTS Report

Prepared by:

HSD MARINE AND SHIPREPAIR PTE LTD

NAME : DAVID

DATE : 29.11.2017

SIGNATURE :