

FINAL INSPECTION REPORT & CERTIFICATE OF CONFORMANCE

UNEW's capital part refurbishment operations are governed by proprietary engineering technologies, precision standards, and rigorous QA/QC procedures developed for aviation grade manufacturing. While refurbishment work is normally conducted at UNEW's U.S. facility, certain components from restricted regions are not eligible for import under U.S. national security and export control regulations.

To maintain uninterrupted service and consistent product quality, UNEW has partnered with EthosEnergy (United Kingdom)—a world-class turbine repair and overhaul organization operating one of the most advanced facilities in the industry. The EthosEnergy shop is equipped with fully automated precision systems, vacuum furnaces, electron beam welders, and advanced HVOF/TBC coating cells. Its quality system is certified to ISO 9001:2015, ISO 14001:2015, ISO 45001:2018, and ISO 17025:2017, ensuring full traceability, environmental stewardship, and occupational safety compliance.

All repair activities performed at EthosEnergy strictly follow UNEW's proprietary refurbishment procedures, material specifications, and inspection standards. The physical repair processes are executed by EthosEnergy, while UNEW retains full technical authority over repair methodology, metallurgical control, quality benchmarks, and final acceptance. This partnership guarantees that every refurbished component meets UNEW's aviation grade quality and reliability standards for power generation service.

Customer Name: Nghi Son Refinery & Petrochemical, LLC.

Component type: MS6001FA 1st STAGE BUCKET

Date of Report: October 15, 2025

Responsible Product Engineer: 

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Engineer

Report prepared by: 

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Report writer

Report reviewed and approved by: 

Mr. Pheerayawat Muadna
(Engineering Manager)

FINAL INSPECTION REPORT

1. INTRODUCTION:

92 pcs. Of MS6001FA 1st STAGE BUCKET have been fully refurbished based on the requirements of the incoming inspection report findings:

Component Basic			
Quantity	91	1	-
Original part number	323E2149 G001	323E2149 G002	-
Material type	GTD 111	GTD 111	-
Manufacturer	GE	GE	-
As received coatings applied	MCrAlY and TBC coating		
Configuration	-		

Customer supplied component history	
Total fired hours	24,000
Total starts	-
Total factor fired hours	-
# of previous repairs	-
Hours of operation since last repair	-
Operational fuel type	-
Mode of operation (base load / peaking)	-
Maintenance Intervals Combustion	-
Maintenance Intervals Hot gas path	-
Unloaded condition	
Incoming packing / container condition	Good
Signs of transit damage (if damaged upon receipt photos to be included within report)	-

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2. INSPECTION SUMMARY:

Based on the findings of the incoming inspection process (results and details of inspection given later in this report) the following processes and refurbishments have been performed

Repair requirements

Repair level required

DESCRIPTION		QTY	UNIT
Inspect	Incoming Inspections	1	Set
Heavy Repair	Repair	1	Set
Coating	HVOF MCrAlY coat & TBC	1	Set

Additional items

DESCRIPTION		QTY	UNIT
Required	Apply TBC coating on tip cap (Based on as received condition)	1	SET

Scrap (if/any):	-
Additional recommendations (If/any) :	-

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3. ENGINEERING REPAIR SUMMARY:

All MS6001FA 1st Stage Buckets underwent a comprehensive heavy repair program under UNEW's technical authority and EthosEnergy's ISO-certified quality management system. The components were inspected, refurbished, and certified in accordance with the approved Work Scope of Repair and UNEW Proprietary Engineering Standards for critical gas turbine rotating parts.

Upon receipt, each bucket was serialized, photographed, and fully inspected through dimensional checks, wall-thickness measurement, FPI, and airflow testing. The inspection revealed typical high-temperature service degradation including oxidation, thermal cracking, tip wear, and cooling passage fouling. All findings were documented in the incoming inspection report for repair authorization.

Defective material was removed by precision machining and blending, followed by GTAW weld restoration of tip regions, angel wings, and localized airfoil cracks using high-temperature welding techniques with Rene 80-compatible filler metal. Full squealer tip reconstruction was performed at elevated temperature to ensure metallurgical integrity. Welds were validated through 100% fluorescent penetrant and X-ray inspections, and final profiles were re-machined to OEM tolerances. Wall-thickness and dimensional checks confirmed full restoration to design geometry.

After welding, all buckets underwent vacuum solution and age heat treatments to re-establish the γ' phase microstructure and relieve residual stress. Cooling passages were verified open by dynamic flow and mass airflow testing. External surfaces were then treated with HVOF-applied MCrAlY bond coat and plasma-sprayed TBC, followed by vacuum diffusion and final aging heat treatments to achieve optimal oxidation resistance and coating adhesion.

Finishing operations included masking of internal passages, shot-peening of fir-tree roots, installation of new locking tangs, and moment-weight balancing of all blades to ensure uniform rotor assembly balance. Final visual, dimensional, radiographic, thermographic, and airflow inspections confirmed complete conformance with engineering, metallurgical, and coating requirements.

All repair and inspection activities were conducted under UNEW's proprietary quality standards and EthosEnergy's certifications to ISO 9001:2015, ISO 14001:2015, ISO 45001:2018, and ISO 17025:2017. The fully refurbished 1st Stage Buckets have been validated for dimensional, structural, and metallurgical integrity and are hereby deemed serviceable for reinstallation at NSRP.

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4. CERTIFICATE OF CONFORMANCE:

Component: MS6001FA 1st Stage Bucket Assembly

Quantity: 92 Pieces

Material: Rene 80 (Nickel-Based Superalloy)

Repair Category: Heavy Repair

Work Order No.: (Insert Number)

Customer: Nghi Son Refinery & Petrochemical LLC

Repair Facility: EthosEnergy (Thailand) Ltd.

Technical Authority: UNEW, Inc. (USA)

EthosEnergy (Thailand) Ltd., under the technical authorization of UNEW, Inc., hereby certifies that all MS6001FA 1st Stage Buckets listed above have been inspected, refurbished, and tested in full compliance with the EthosEnergy Work Scope of Repair, UNEW Proprietary Standards, and applicable engineering specifications.

The heavy-repair scope performed included:

- Comprehensive inspection (dimensional, FPI, X-ray, and airflow) and full defect mapping.
- Removal of oxidation, cracks, and tip wear by machining and blending.
- High-temperature GTAW weld restoration of airfoil tips, angel wings, and platform areas.
- Vacuum solution and age heat treatments to restore microstructure and mechanical integrity.
- Wall-thickness verification, EDM restoration of cooling passages, and airflow balance testing.
- Application of HVOF MCrAlY bond coat and plasma-sprayed TBC, followed by diffusion and stabilization heat treatments.
- Shot-peening of fir-tree roots, installation of locking tangs, and moment-weight balancing to ensure rotor dynamic conformity.

All work was performed in accordance with ISO 9001:2015, ISO 14001:2015, ISO 45001:2018, and ISO 17025:2017 certified quality systems.

Final visual, radiographic, thermographic, dimensional, and airflow inspections confirmed that all components meet or exceed contractual, metallurgical, and operational specifications.

Accordingly, EthosEnergy (Thailand) Ltd. and UNEW, Inc. jointly certify that the subject 1st Stage Buckets are in serviceable condition and fully compliant with all applicable requirements for reinstallation at Nghi Son Refinery & Petrochemical.

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5. SCOPE OF WORK:

MS6001FA STAGE 1 BLADE

Work scope	Inspect	Heavy	Coating
Inspect			
Perform receipt inspection and record serial numbers (highlight locking blade)	X		
Perform metallurgical evaluation of base material and coating type, report on condition	X		
Mask root sections and internal passages abrasive blast external gas path surfaces to remove TBC	X		
Perform incoming dynamic flow inspection to verify cooling passages are free and clear	X		
Perform incoming mass airflow inspection of sample lot.	X		
Perform chemical strip of fir tree root tang coating	X		
Perform incoming solution heat treatment in full vacuum environment	X		
Perform chemical strip of external gas path coatings	X		
Perform heat tint operation to ensure full coating removal	X		
Perform fluorescent penetrant inspection and record all defects.	X		
Perform visual inspection and record all defects	X		
Perform dimensional inspection, report all non-conformities	X		
Perform wall thicknesses inspection	X		
Compile incoming Inspection report and forward to customer.	X		
Hold points until Customer discussions and agreement on repair scopes have been held/reached.	X		
Repair			

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5. SCOPE OF WORK:(CONTINUE)

Blend to remove oxidation and FOD damage within blend repair limits		X	
Remove defective material in repairable areas in preparation for weld repairs.		X	
Machine to remove squealer tip area.		X	
Perform fluorescent penetrant inspection of prepared areas		X	
Weld prepared localized tip cracking and angel wing cracking.		X	
Perform elevated temperature welding to fully restore the squealer tip and or angel wings		X	
Perform machining of the bucket tip height, bucket airfoil contours and squealer pocket to required dimension		X	
Perform wall thicknesses inspection		X	
Perform post repair solution heat treatment in full vacuum environment		X	
Perform fluorescent penetrant inspection		X	
Perform visual inspection		X	
Perform 100% X-Ray inspection of the welded tip regions.		X	
Perform dynamic flow inspection to verify cooling passages are free and clear		X	
Perform dimensional inspection		X	
Perform pin gauge check of all cooling holes and record results		X	
Coating			
Apply External HVOF MCrAlY coating			X
Perform post coating diffusion heat treatment in a vacuum environment			X
Perform visual inspection			X

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5. SCOPE OF WORK:(CONTINUE)

Perform final age heat treatment in air or argon shielded environments		X	
Perform Pulse Thermography inspection			X
Perform visual inspection			X
Mask off all external and internal cooling surfaces to protect coated areas.		X	
Perform shot peen operation of firtree root		X	
Apply Thermal spray TBC Coating and perform surface enhancement of coated surfaces			X
Perform mass air flow checks		X	
Apply root locking Tang		X	
Perform moment weigh of blades and produce balance chart, label blade location		X	
Perform final visual inspection		X	
Compile Final Report, pack and ship components with all required documentation as listed in Purchase Order		X	

Required:

- Apply TBC coating on tip cap (Based on as received condition)

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6. ENGINEERING DETAIL WORK DONE:

6.1. Inspection Phase

Task	Detailed Description
Perform receipt inspection and record serial numbers (highlight locking blade)	Each bucket was received, counted, and logged by serial number. Locking blades were identified and marked for tracking. Visual inspection was carried out to identify transit or surface damage.
Perform metallurgical evaluation of base material and coating type, report on condition	Samples were analyzed microscopically to assess base-metal microstructure, coating condition, and service degradation. Findings guided selection of heat-treatment and repair procedures.
Mask root sections and internal passages; abrasive blast external gas-path surfaces to remove TBC	Root and cooling holes were masked to prevent contamination. External gas-path surfaces were grit-blasted under controlled parameters to remove degraded Thermal Barrier Coating (TBC) and oxidation.
Perform incoming dynamic flow inspection to verify cooling passages are free and clear	Dynamic airflow tests confirmed cooling circuits were open and unrestricted. Data established baseline flow for later comparison.
Perform incoming mass airflow inspection of sample lot	A representative sample of buckets underwent calibrated airflow testing to verify cooling flow uniformity and detect any partially blocked passages.
Perform chemical strip of fir-tree root tang coating	Root tang coatings were chemically stripped using a mild etchant to remove oxidation and coatings, revealing the substrate for inspection.
Perform incoming solution heat treatment in full vacuum environment	Buckets underwent solution heat treatment in a high-vacuum furnace to dissolve carbides, relieve service stress, and stabilize microstructure before repair.
Perform chemical strip of external gas-path coatings	Residual MCrAlY or aluminide coatings were chemically stripped to bare metal to enable defect detection and re-coating later.

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Task	Detailed Description
Perform heat-tint operation to ensure full coating removal	Controlled oxidation tint was applied to highlight any remaining coating traces or hidden cracks.
Perform fluorescent penetrant inspection and record all defects	A full-surface FPI identified cracking, tip distress, and oxidation pitting. All defect indications were recorded and photographed for reference.
Perform visual inspection and record all defects	Visual and microscopic inspection of airfoil, tip, and root regions recorded erosion, FOD impact, and surface defects.
Perform dimensional inspection, report all non-conformities	Dimensional verification (tip height, chord, platform) was performed using CMM and templates; deviations were reported for corrective machining.
Perform wall-thickness inspection	Ultrasonic wall-thickness measurements determined metal loss in cooling channels and thin sections. Results guided weld restoration.
Compile incoming inspection report and forward to customer	Inspection results, photographs, FPI maps, and measurements were compiled into a detailed Incoming Inspection Report submitted for customer review.
Hold points until customer discussions and agreement on repair scopes have been held/reached	Repair work was paused until UNEW and NSRP confirmed repair classification, acceptance limits, and final scope authorization.

6.2. Repair Phase

Task	Detailed Description
Blend to remove oxidation and FOD damage within blend repair limits	Damaged areas caused by oxidation and foreign object impact were mechanically blended using precision rotary tools within OEM-defined limits to achieve clean metal.

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Task	Detailed Description
Remove defective material in repairable areas in preparation for weld repairs	Crack zones and degraded metal were machined out to sound base material, creating uniform weld-prep cavities.
Machine to remove squealer tip area	The entire worn or damaged squealer tip region was machined off to enable complete rebuild.
Perform fluorescent penetrant inspection of prepared areas	FPI verified all cracks and contamination were removed from machined areas prior to welding.
Weld prepared localized tip cracking and angel wing cracking	Minor cracking at tip edges and angel wings was repaired using GTAW welding with Rene 80-compatible filler metal under inert argon shielding.
Perform elevated temperature welding to fully restore the squealer tip and/or angel wings	Full squealer tips and angel wings were rebuilt using multi-pass high-temperature welding under preheated and temperature-controlled conditions to prevent heat-affected zone cracking.
Perform machining of bucket tip height, bucket airfoil contours, and squealer pocket to required dimension	Machining restored the rebuilt regions to OEM-defined dimensions. Airfoil contours and tip heights were precisely matched to design profiles.
Perform wall-thickness inspection	Ultrasonic inspection confirmed minimum wall-thickness integrity across repaired regions and cooling paths.
Perform post-repair solution heat treatment in full vacuum environment	A vacuum solution heat treatment cycle restored uniform microstructure, relieved stress from welding, and prepared surfaces for coating.
Perform fluorescent penetrant inspection	Post-heat-treatment FPI verified weld quality and ensured no reoccurrence of cracks after thermal cycling.

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Task	Detailed Description
Perform visual inspection	Visual and magnified examination confirmed the surface condition, smoothness, and repair completion.
Perform 100% X-ray inspection of welded tip regions	All tip welds were X-rayed to detect subsurface porosity, inclusions, or incomplete fusion. Results were archived in the repair record.
Perform dynamic flow inspection to verify cooling passages are free and clear	After repair, airflow tests reconfirmed that internal cooling channels were clear and consistent with baseline measurements.
Perform dimensional inspection	Comprehensive dimensional checks ensured all root, tip, and airfoil geometry met specifications.
Perform pin gauge check of all cooling holes and record results	Each cooling hole was verified for diameter and straightness using calibrated pin gauges to ensure consistent flow and integrity.

6.3. Coating and Final Finishing Phase

Task	Detailed Description
Apply external HVOF MCrAlY coating	A dense, oxidation-resistant MCrAlY coating was applied via High-Velocity Oxygen Fuel (HVOF) process, restoring bond-coat protection on the airfoil surfaces.
Perform post-coating diffusion heat treatment in vacuum environment	Vacuum diffusion heat treatment was conducted to bond the MCrAlY coating to the base alloy, enhancing adhesion and oxidation resistance.
Perform visual inspection	Inspected the coating surface for uniformity, bond integrity, and absence of overspray or roughness.
Perform final age heat treatment in air or argon-shielded environment	Final age-hardening was conducted to restore mechanical properties and stabilize the microstructure after coating.

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Task	Detailed Description
Perform pulse thermography inspection	Non-destructive pulse thermography verified coating adhesion and uniform thickness across the entire surface.
Perform visual inspection	Post-thermography visual check confirmed coating appearance, color consistency, and surface quality.
Mask off all external and internal cooling surfaces to protect coated areas	Cooling holes and root sections were masked prior to finishing to avoid contamination and maintain cooling performance.
Perform shot peen operation of fir-tree root	Controlled shot-peening of the fir-tree roots introduced beneficial compressive stress, improving fatigue strength and extending service life.
Apply thermal spray TBC coating and perform surface enhancement of coated surfaces	A thermal-spray-applied TBC was deposited on gas-path surfaces to reduce metal temperature. Surface enhancement was performed to optimize roughness and adherence.
Perform mass airflow checks	Final airflow testing confirmed that cooling performance was within design limits after coating.
Apply root locking tang	New locking tangs were installed at the bucket root to secure blade retention during rotor assembly.
Perform moment weigh of blades and produce balance chart, label blade location	Each blade was weighed, recorded, and labeled. A rotor balance chart was created to ensure proper mass distribution during assembly.
Perform final visual inspection	Complete visual verification under magnification ensured that all repairs, coatings, and markings met engineering standards.
Compile final report, pack, and ship components with all required documentation	Final Inspection Report, NDT records, heat-treatment charts, and certificates were compiled. Components were packed and labeled for return to NSRP.

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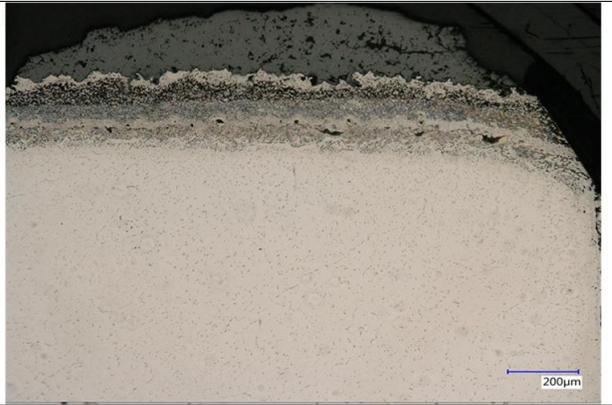
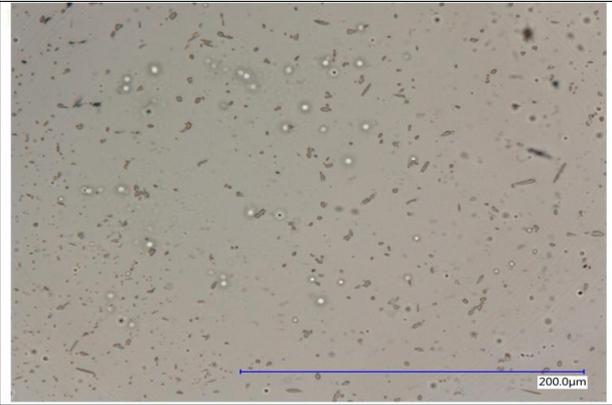
Result

All 1st Stage Buckets successfully completed a full heavy-repair process in accordance with UNEW proprietary engineering procedures and EthosEnergy ISO-certified quality controls.

All dimensional, metallurgical, and coating inspections confirmed that the refurbished components meet OEM-equivalent standards and are certified serviceable for reinstallation at Nghi Son Refinery & Petrochemical.

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7. MATERIAL EVALUATION

Report No.	L11073		Job order no.	824025							
Serial no.(or ID)	J1AJ024361 (Item# 92)		Cutting location	Trailing Edge Tip							
Received status	<input checked="" type="checkbox"/> As-Received <input type="checkbox"/> Pre-Weld HT <input type="checkbox"/> Post-Weld HT <input type="checkbox"/> Other										
Analysis Result											
XRF inspection result, main composition in %				Hardness Test	-						
Element	Co	Cr	Ni	Ti	W	Ta	Mo	Fe	Al	Grain size	-
Nominal	9.5	14.0	Bal	4.9	3.8	2.8	-	-	4.0	Coating Type	MCrAlY (HVOF) and TBC top-coating
Result	9.5	13.5	58.8	5.1	4.1	3.6	-	-	4.0	Alloy grade	GTD111
Microstructure											
<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>Fig.1 Showing the hot gas path coating and substrate condition.(Etched)</p> </div> <div style="text-align: center;">  <p>Fig.2 Showing the typical microstructure at higher magnification.(Etched)</p> </div> </div>											
<p>The sample was mounted in L11073 to assess if the material would be acceptable for repair. The following was observed. Hot gas path was protected by MCrAlY (HVOF) and TBC top-coating, refer to Fig.1. Base material was confirmed as GTD111 alloy, Fig.2. (Please note the sample was taken from squealer tip where have full weld. Attempting to take one more sample low in the airfoil may affect the blade and is therefore not recommended. Material type can be confirmed by material code on shank wall and XRF inspection as shown above.)</p>											
Recommendation											
<p>Based on the finding above, the base material was considered suitable for repair following coating removal by grit blast and acid stripping respectively.</p>											

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8. PHOTOGRAPHS

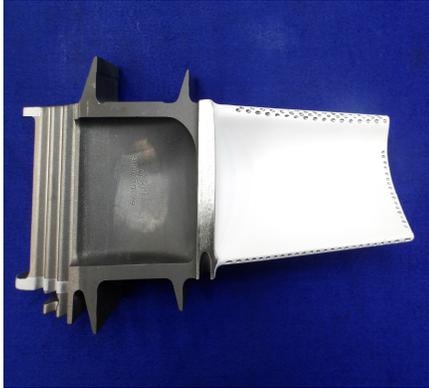


Figure 1. Final inspection.



Figure 2. Final inspection.



Figure 3. Final inspection.



Figure 4. Final inspection.



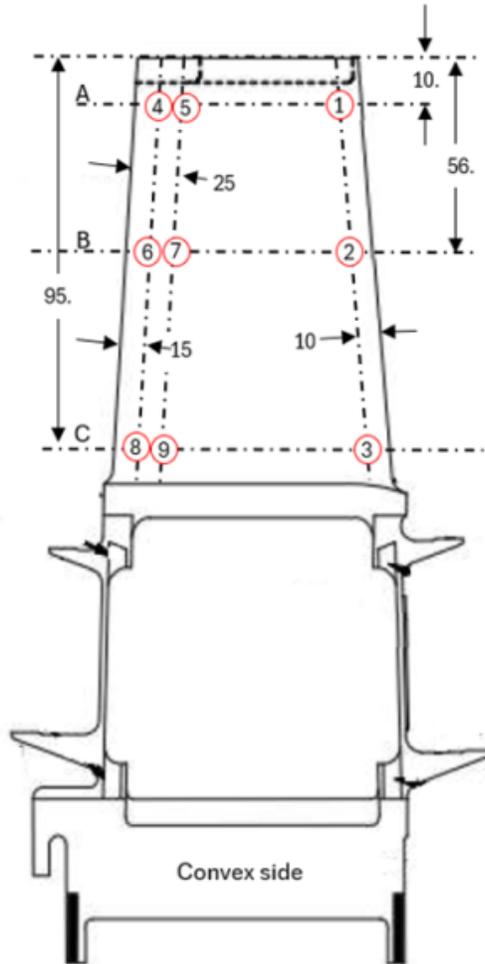
Figure 5. Final inspection.



Figure 6. Final inspection.

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9. THICKNESS RESULTS



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9.0 THICKNESS RESULTS (CONTINUE)

WALL THICKNESS CHECK SHEET																			
ITEM	POSITION (Unit:mm)																		Result
	CONCAVE									CONVEX									
	1	2	3	4	5	6	7	8	9	1	2	3	4	5	6	7	8	9	
1	2.30	3.09	2.91	1.39	2.14	1.54	2.76	1.58	3.00	1.78	2.26	3.85	1.38	1.56	1.66	1.80	1.86	2.09	ACC
2	2.17	3.00	2.71	1.32	2.02	2.02	3.51	1.91	3.54	1.77	2.58	3.75	1.44	1.65	1.23	1.39	1.73	2.12	ACC
3	2.33	3.34	2.90	1.23	2.05	1.67	3.50	1.68	3.18	1.86	2.22	3.42	1.50	1.68	1.73	1.79	1.93	2.39	ACC
4	2.23	2.86	2.54	1.32	2.30	1.91	3.17	1.89	3.11	1.72	2.23	3.57	1.30	1.32	1.56	1.66	1.86	2.41	ACC
5	1.95	3.17	2.88	1.49	2.31	1.92	3.18	1.74	3.17	1.81	2.20	3.50	1.25	1.30	1.50	1.55	1.69	2.29	ACC
6	2.45	3.35	3.11	1.33	2.09	1.73	3.31	1.73	3.05	1.56	2.15	3.62	1.26	1.46	1.56	1.68	2.00	2.26	ACC
7	2.16	2.65	2.43	1.27	2.04	1.43	2.92	1.47	2.86	1.71	2.36	2.76	1.36	1.76	1.87	2.21	2.01	2.48	ACC
8	2.00	2.97	2.62	1.38	2.22	1.72	3.04	1.64	3.02	1.69	2.21	3.44	1.10	1.24	1.61	1.68	2.00	2.28	ACC
9	2.01	2.81	2.51	1.18	2.00	1.54	3.08	1.54	2.68	1.57	2.32	3.51	1.50	1.62	1.66	1.81	2.10	2.46	ACC
10	2.08	3.03	2.74	1.25	2.09	1.67	3.10	1.69	2.94	1.76	2.29	3.58	1.34	1.65	1.42	1.78	1.94	2.24	ACC
11	2.27	3.06	2.48	1.41	1.95	1.63	3.05	1.46	2.96	1.66	2.47	3.91	1.65	1.76	1.89	2.00	2.16	2.56	ACC
12	2.20	2.78	2.56	1.28	2.15	1.85	3.10	1.80	3.10	1.79	2.38	3.75	1.26	1.55	1.78	1.85	1.90	2.31	ACC
13	2.60	3.12	2.90	1.26	2.25	1.80	3.22	1.73	3.11	1.67	2.36	3.81	1.36	1.50	1.55	1.68	2.00	2.34	ACC
14	2.00	2.87	2.67	1.16	2.01	1.76	3.18	1.74	3.12	1.90	2.37	3.97	1.37	1.68	1.52	1.66	1.97	2.31	ACC
15	2.25	3.05	2.89	1.67	2.10	1.98	3.35	1.82	3.15	1.62	2.45	3.37	1.29	1.38	1.41	1.55	1.71	2.05	ACC
16	2.18	3.14	2.66	1.24	1.97	1.70	2.96	1.83	3.00	1.72	2.44	3.73	1.40	1.61	1.69	1.91	1.97	2.24	ACC
17	2.38	3.13	3.01	1.18	1.85	1.75	3.05	1.56	3.06	1.69	2.43	3.86	1.55	1.67	1.60	1.78	2.00	2.21	ACC
18	2.15	2.87	3.01	1.23	2.06	1.92	3.26	2.67	3.00	1.89	2.36	3.51	1.40	1.52	1.30	1.50	1.62	2.08	ACC
19	2.28	2.86	2.60	1.10	2.02	1.54	2.84	1.64	2.90	1.68	2.40	3.91	1.46	1.54	1.64	1.89	1.91	2.36	ACC
20	2.31	3.11	2.78	1.24	2.02	1.73	3.11	1.79	3.18	1.48	2.34	3.38	1.24	1.38	1.28	1.44	1.72	2.03	ACC
21	2.50	3.17	2.76	1.57	2.27	1.88	3.26	1.89	3.15	1.66	2.26	3.64	1.31	1.27	1.39	1.65	1.80	2.35	ACC
22	2.16	2.97	2.66	1.45	2.33	1.86	3.31	1.88	3.24	1.79	2.28	3.60	1.31	1.33	1.53	1.49	1.88	2.11	ACC
23	2.27	2.98	2.66	1.20	2.06	1.97	3.28	1.83	3.16	1.79	2.32	3.52	1.32	1.36	1.53	1.70	2.06	2.34	ACC
24	2.22	2.96	2.68	1.27	2.01	1.82	2.91	1.73	2.82	1.71	2.22	3.48	1.28	1.55	1.55	1.78	1.88	2.33	ACC
25	2.19	2.75	2.42	1.23	2.06	1.75	3.11	1.78	2.91	1.51	2.29	4.15	1.42	1.57	1.54	1.71	1.91	2.31	ACC
26	2.33	3.11	2.76	1.24	1.93	1.89	3.06	1.64	3.01	1.46	2.29	3.48	1.27	1.50	1.46	1.81	1.92	2.43	ACC
27	2.31	3.08	2.75	1.42	2.22	1.97	3.21	1.61	3.06	1.58	2.24	3.47	1.19	1.49	1.45	1.63	2.03	2.21	ACC
28	2.22	3.00	2.54	1.37	1.97	1.76	2.96	1.70	2.87	1.58	2.33	3.51	1.41	1.57	1.64	1.73	1.97	2.24	ACC
29	2.11	3.10	2.72	1.41	2.01	2.09	3.23	1.86	3.31	1.60	2.33	3.83	1.33	1.64	1.43	1.56	1.71	2.13	ACC
30	2.31	3.38	2.84	1.16	1.89	1.51	2.93	1.78	3.12	1.39	2.22	3.40	1.63	1.69	1.68	1.92	2.11	2.47	ACC
31	2.20	3.10	2.94	1.12	1.80	1.48	2.83	1.35	2.92	1.58	2.31	3.46	1.67	1.72	1.89	1.98	2.32	2.52	ACC
32	2.36	3.15	2.60	1.41	2.08	1.54	3.09	1.42	3.18	1.73	2.13	3.49	1.16	1.30	1.51	1.54	1.86	2.12	ACC
33	2.32	3.03	2.56	1.41	1.95	1.46	3.12	1.42	3.21	1.63	2.13	3.50	1.31	1.56	1.57	1.75	1.91	2.12	ACC
34	2.18	2.92	2.73	1.54	2.32	1.86	3.10	1.76	3.12	1.74	2.46	3.53	1.17	1.43	1.44	1.72	1.75	2.22	ACC
35	2.31	3.00	2.71	1.18	2.01	1.63	2.92	1.64	3.23	1.57	2.48	3.91	1.47	1.62	1.75	1.89	1.93	2.22	ACC
36	2.31	3.36	3.11	1.40	2.29	1.83	3.21	1.83	3.38	1.62	2.25	3.73	1.28	1.32	1.39	1.44	1.76	1.99	ACC
37	2.44	3.15	2.90	1.27	2.16	1.59	3.05	1.55	3.06	1.39	2.05	3.38	1.65	1.69	1.78	1.90	2.19	2.39	ACC
38	3.33	3.04	2.74	1.54	2.24	1.72	3.40	1.81	3.12	1.74	2.21	3.64	1.26	1.40	1.68	1.72	1.90	2.16	ACC
39	2.01	3.05	2.54	1.23	2.03	1.83	3.28	1.73	2.97	1.86	2.45	3.90	1.41	1.63	1.60	1.83	2.01	2.47	ACC
40	2.36	3.04	2.56	1.50	2.32	1.79	3.32	1.73	3.30	1.68	2.47	3.58	1.24	1.33	1.49	1.53	1.90	2.23	ACC
41	2.29	2.93	2.64	1.48	2.20	1.86	3.43	1.68	2.90	1.61	2.20	3.71	1.15	1.32	1.42	1.61	1.99	2.46	ACC
42	2.08	3.16	2.58	1.23	2.21	1.75	3.11	1.51	2.57	1.69	2.29	3.43	1.25	1.38	1.60	1.66	2.07	2.55	ACC
43	2.10	2.91	2.76	1.33	2.00	1.63	2.85	1.48	3.16	1.68	2.23	3.56	1.24	2.43	1.72	1.64	1.95	2.24	ACC
44	2.20	2.80	2.44	1.26	1.87	1.53	3.08	1.57	2.97	1.68	2.49	3.89	1.32	1.62	1.56	1.73	1.78	2.23	ACC
45	2.17	3.00	2.86	1.35	2.02	1.60	2.91	1.57	3.08	1.63	2.23	3.68	1.46	1.63	1.76	1.89	1.91	2.38	ACC
46	1.86	3.36	2.91	1.33	2.09	1.96	3.27	1.73	3.25	1.63	2.41	3.66	1.28	1.57	1.33	1.26	1.79	2.07	ACC

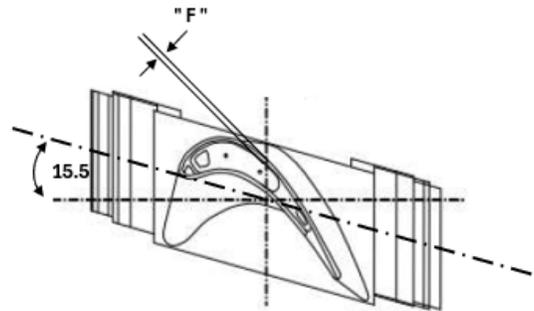
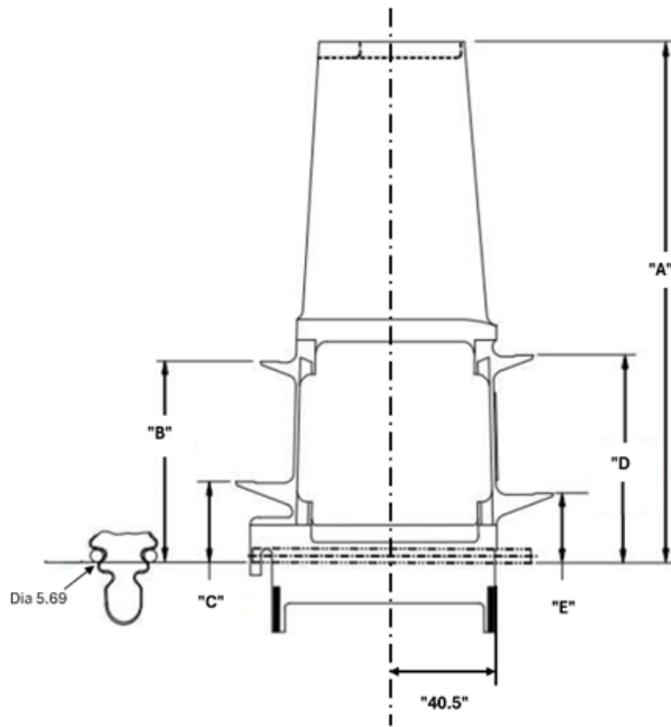
FINAL INSPECTION REPORT

9.0 THICKNESS RESULTS (CONTINUE)

WALL THICKNESS CHECK SHEET																			
ITEM	POSITION (Unit:mm)																		Result
	CONCAVE									CONVEX									
	1	2	3	4	5	6	7	8	9	1	2	3	4	5	6	7	8	9	
47	2.21	2.78	2.63	1.38	2.12	1.36	2.53	1.51	2.71	1.92	2.28	3.52	1.22	1.40	1.73	1.77	2.09	2.50	ACC
48	2.36	3.25	2.96	1.12	1.97	1.72	3.04	1.73	3.22	1.52	2.36	3.73	1.42	1.56	1.65	1.80	1.97	2.30	ACC
49	2.51	3.41	3.22	1.38	2.32	1.91	3.12	2.02	3.10	1.55	2.00	3.52	1.33	1.44	1.30	1.48	1.71	1.92	ACC
50	2.31	3.10	2.71	1.30	2.16	1.61	3.00	1.68	2.96	1.60	2.26	3.41	1.56	1.58	1.67	1.90	2.14	2.41	ACC
51	2.14	3.02	2.55	1.38	2.19	1.94	3.29	1.83	3.20	1.73	2.48	3.92	1.11	1.35	1.21	1.39	1.78	2.21	ACC
52	2.18	2.93	2.55	1.31	1.93	1.55	2.81	1.65	2.90	1.69	2.25	3.70	1.45	1.56	1.75	1.83	2.14	2.30	ACC
53	2.27	2.84	2.38	1.38	2.11	1.56	3.22	1.43	3.21	1.58	2.47	3.78	1.48	1.50	1.78	1.71	2.12	2.33	ACC
54	2.28	3.19	2.77	1.29	1.84	1.56	3.00	1.45	2.92	1.62	2.28	3.64	1.36	1.55	1.69	1.71	1.99	2.27	ACC
55	2.18	2.78	2.45	1.37	2.06	2.00	3.21	1.91	3.06	1.90	2.43	3.84	1.21	1.36	1.43	1.45	1.95	2.24	ACC
56	2.25	2.90	2.59	1.28	2.05	1.39	2.80	1.35	2.66	1.60	2.36	3.40	1.45	1.70	1.85	1.96	2.21	2.60	ACC
57	2.30	3.13	2.90	1.24	2.07	1.69	3.14	1.54	3.28	1.77	2.49	3.78	1.41	1.44	1.51	1.62	1.86	2.48	ACC
58	2.05	2.88	2.62	1.78	2.20	1.94	3.17	1.86	3.16	1.79	2.42	3.58	1.34	1.40	1.45	1.60	1.83	2.15	ACC
59	2.19	3.06	2.70	1.41	2.08	1.65	3.28	1.79	3.15	1.83	2.52	3.78	1.31	1.60	1.69	1.78	2.16	2.43	ACC
60	2.23	2.91	2.56	1.42	2.05	1.77	3.06	1.59	2.95	1.72	2.47	3.68	1.51	1.69	1.66	1.80	2.06	2.26	ACC
61	1.94	2.93	2.81	1.52	2.04	1.89	3.12	1.87	3.06	1.96	2.54	3.80	1.22	1.49	1.37	1.45	1.87	2.21	ACC
62	2.12	3.28	2.51	1.40	2.33	1.93	3.16	1.60	3.38	1.53	2.10	3.55	1.30	1.46	1.69	1.69	1.97	2.46	ACC
63	2.21	2.83	2.50	1.28	2.12	2.01	3.41	1.68	3.31	1.65	2.33	3.66	1.28	1.56	1.43	1.74	1.90	2.31	ACC
64	2.36	3.15	2.46	1.20	2.04	1.52	3.08	1.69	2.96	1.36	2.32	3.84	1.46	1.64	1.68	1.79	2.07	2.39	ACC
65	2.19	3.11	2.88	1.29	2.00	1.71	3.06	1.69	2.90	1.80	2.41	3.52	1.26	1.33	1.60	1.75	1.95	2.31	ACC
66	2.21	2.89	2.60	1.49	2.16	1.90	2.95	1.69	2.85	1.66	2.33	3.82	1.28	1.66	1.56	1.89	1.94	2.34	ACC
67	2.21	3.07	2.92	1.29	2.12	1.41	3.01	1.66	3.06	1.79	2.47	3.95	1.38	1.64	1.81	2.01	2.06	2.50	ACC
68	2.18	2.85	2.55	1.29	1.94	1.72	2.89	1.75	3.25	1.63	2.33	3.70	1.46	1.61	1.58	1.61	1.90	2.10	ACC
69	2.10	3.01	2.81	1.46	2.16	1.81	3.18	1.76	3.20	1.69	2.36	3.73	1.20	1.20	1.28	1.61	1.72	2.24	ACC
70	2.32	2.91	2.57	1.42	2.18	1.70	2.98	1.63	2.82	1.91	2.31	3.91	1.36	1.44	1.81	1.74	1.91	2.43	ACC
71	1.98	2.91	2.66	1.48	2.13	1.78	2.91	2.73	3.29	1.53	2.40	2.70	1.22	1.22	1.64	1.71	1.77	2.27	ACC
72	2.29	3.08	2.56	1.40	2.11	1.76	3.04	1.62	2.96	1.73	2.45	3.74	1.33	1.51	1.60	1.54	2.00	2.22	ACC
73	2.35	3.01	3.09	1.30	2.05	1.96	3.12	1.56	3.15	1.67	2.36	3.29	1.42	1.53	1.49	1.75	2.10	2.45	ACC
74	2.14	2.76	2.55	1.49	2.20	1.67	2.88	1.68	2.98	1.84	2.32	3.43	1.27	1.56	1.73	1.87	2.21	2.61	ACC
75	2.14	3.05	2.65	1.43	2.22	1.91	3.27	1.80	3.00	1.77	2.48	3.63	1.27	1.35	1.41	1.61	1.81	2.12	ACC
76	2.38	2.96	2.75	1.25	2.00	1.48	2.82	1.73	2.91	1.76	2.41	3.85	1.51	1.63	1.83	2.05	2.18	2.47	ACC
77	2.18	3.20	2.91	1.53	2.30	1.80	3.18	1.74	2.91	1.71	2.32	3.77	1.26	1.43	1.60	1.67	1.87	2.35	ACC
78	2.10	3.06	2.89	1.29	1.92	1.66	2.95	1.95	3.10	1.75	2.15	3.60	1.59	1.77	1.65	1.70	1.79	2.21	ACC
79	2.30	3.18	2.73	1.16	1.86	1.63	3.06	1.50	2.98	1.76	2.18	3.40	1.34	1.55	1.53	1.66	1.97	2.29	ACC
80	2.05	2.81	2.30	1.25	1.75	1.35	2.60	1.19	2.65	1.23	2.04	3.40	1.26	1.36	1.95	2.10	2.05	2.55	ACC
81	2.12	3.11	2.89	1.36	2.03	1.76	3.10	1.76	3.15	1.90	2.43	4.01	1.40	1.51	1.62	1.57	1.94	2.12	ACC
82	2.20	3.14	2.58	1.36	2.20	1.93	3.14	1.74	3.09	1.78	2.32	3.93	1.36	1.60	1.66	1.68	2.05	2.27	ACC
83	2.33	2.90	2.51	1.52	2.31	1.87	3.14	1.66	3.02	1.73	2.40	3.94	1.23	1.42	1.49	1.76	1.96	2.57	ACC
84	2.15	2.91	2.67	1.19	2.00	1.39	2.83	1.61	2.88	1.63	2.06	3.54	1.35	1.56	1.85	1.95	2.05	2.33	ACC
85	2.40	2.97	2.67	1.41	2.10	1.63	3.01	1.61	2.94	1.66	2.35	3.71	1.25	1.44	1.45	1.50	1.96	2.31	ACC
86	2.00	3.10	2.71	1.11	2.10	1.92	3.40	1.67	3.23	1.47	2.16	3.36	1.51	1.57	1.56	1.60	1.87	2.24	ACC
87	2.31	3.15	2.90	1.17	2.15	1.52	3.00	1.51	3.06	1.42	2.22	3.55	1.33	1.50	1.61	1.67	2.04	2.41	ACC
88	2.41	3.11	2.84	1.12	2.07	1.68	3.11	1.75	3.20	1.63	2.23	3.38	1.53	1.58	1.65	1.84	2.06	3.16	ACC
89	2.18	2.90	2.56	1.50	2.23	2.16	3.34	1.92	3.17	1.76	2.36	3.87	1.20	1.52	1.36	1.56	1.83	2.02	ACC
90	1.97	3.12	2.85	1.64	2.08	1.94	3.24	1.73	3.10	1.67	2.19	3.52	1.14	1.43	1.33	1.73	1.74	2.32	ACC
91	2.24	3.01	2.51	1.52	2.28	1.92	3.12	1.70	3.18	1.62	2.28	3.66	1.12	1.26	1.56	1.69	1.96	2.28	ACC
92	2.19	2.91	2.54	1.42	2.10	1.73	2.94	1.63	2.93	1.70	2.20	3.49	1.38	1.54	1.68	1.77	2.13	2.32	ACC

FINAL INSPECTION REPORT

10. GENERAL DIMENSION



FINAL INSPECTION REPORT

10.0 GENERAL DIMENSION (CONTINUE)

GENERAL DIMENSION DATA TABLE							
DIMENSIONS (Unit:mm)							
ITEM	A	B	C	D	E	F	Result
1	209.35	82.37	34.18	85.02	29.75	1.23	ACC
2	209.39	82.42	34.21	84.98	29.67	1.26	ACC
3	209.39	82.56	34.27	84.98	29.81	1.10	ACC
4	209.39	82.49	34.24	85.08	29.75	1.06	ACC
5	209.34	82.41	34.26	84.87	29.67	1.10	ACC
6	209.39	82.52	34.25	85.02	29.74	1.02	ACC
7	209.39	82.48	34.27	85.09	29.81	1.31	ACC
8	209.38	82.44	34.25	85.06	29.75	1.20	ACC
9	209.37	82.56	34.30	85.07	29.75	1.44	ACC
10	209.36	82.58	34.29	85.14	29.79	1.02	ACC
11	209.36	82.45	34.22	84.94	29.74	1.38	ACC
12	209.38	82.50	34.22	85.08	29.77	1.24	ACC
13	209.33	82.49	34.25	84.94	29.70	1.17	ACC
14	209.30	82.55	34.27	85.10	29.75	1.17	ACC
15	209.40	82.44	34.27	85.02	29.82	1.48	ACC
16	209.37	82.40	34.15	84.99	29.75	1.22	ACC
17	209.33	82.53	34.23	85.07	29.81	1.15	ACC
18	209.33	82.52	34.26	85.01	29.73	1.27	ACC
19	209.36	82.51	34.21	84.97	29.78	1.47	ACC
20	209.37	82.43	34.25	85.00	29.78	1.38	ACC
21	209.36	82.43	34.28	84.98	29.69	1.31	ACC
22	209.38	82.36	34.17	84.89	29.67	1.45	ACC
23	209.37	82.48	34.21	85.05	29.73	1.10	ACC
24	209.34	82.50	34.22	85.09	29.74	1.23	ACC
25	209.40	82.41	34.19	84.85	29.69	1.25	ACC
26	209.40	82.46	34.24	84.93	29.71	1.27	ACC
27	209.38	82.41	34.18	84.94	29.81	1.30	ACC
28	209.37	82.49	34.25	84.97	29.70	1.04	ACC
29	209.36	82.47	34.18	85.04	29.76	1.48	ACC
30	209.39	82.40	34.22	84.87	29.66	1.43	ACC
31	209.39	82.43	34.22	85.11	29.85	1.29	ACC
32	209.39	82.45	34.18	85.09	29.78	1.25	ACC
33	209.36	82.37	34.23	85.02	29.66	1.10	ACC
34	209.37	82.56	34.23	85.10	29.81	1.30	ACC
35	209.33	82.47	34.26	85.00	29.78	1.20	ACC
36	209.35	82.48	34.25	85.04	29.75	1.15	ACC
37	209.38	82.47	34.28	85.03	29.80	1.23	ACC
38	209.39	82.42	34.23	84.98	29.75	1.03	ACC
39	209.35	82.48	34.28	84.97	29.80	1.40	ACC
40	209.40	82.59	34.29	85.11	29.84	1.17	ACC
41	209.35	82.47	34.33	84.94	29.73	1.27	ACC
42	209.35	82.43	34.19	84.92	29.70	1.33	ACC
43	209.31	82.49	34.27	85.07	29.79	1.07	ACC
44	209.34	82.36	34.24	85.06	29.72	1.35	ACC
45	209.36	82.43	34.24	84.85	29.75	1.44	ACC

FINAL INSPECTION REPORT

10.0 GENERAL DIMENSION (CONTINUE)

GENERAL DIMENSION DATA TABLE							
DIMENSIONS (Unit:mm)							
ITEM	A	B	C	D	E	F	Result
46	209.33	82.55	34.34	85.10	29.80	1.36	ACC
47	209.39	82.44	34.25	85.13	29.78	1.01	ACC
48	209.33	82.48	34.22	85.05	29.80	1.08	ACC
49	209.36	82.43	34.24	84.89	29.76	1.12	ACC
50	209.39	82.49	34.24	85.09	29.84	1.13	ACC
51	209.39	82.46	34.23	85.02	29.79	1.26	ACC
52	209.37	82.52	34.31	85.00	29.73	1.05	ACC
53	209.37	82.51	34.27	85.04	29.78	1.39	ACC
54	209.39	82.49	34.30	85.00	29.78	1.49	ACC
55	209.37	82.41	34.24	85.06	29.69	1.05	ACC
56	209.35	82.43	34.24	84.98	29.63	1.21	ACC
57	209.32	82.50	34.27	85.03	29.77	1.17	ACC
58	209.37	82.49	34.24	85.04	29.77	1.27	ACC
59	209.29	82.41	34.24	85.05	29.64	1.28	ACC
60	209.33	82.39	34.22	85.02	29.71	1.33	ACC
61	209.38	82.40	34.23	84.94	29.71	1.14	ACC
62	209.38	82.51	34.27	85.06	29.84	1.13	ACC
63	209.38	82.45	34.28	84.94	29.65	1.14	ACC
64	209.39	82.45	34.24	85.06	29.75	1.08	ACC
65	209.29	82.49	34.22	85.04	29.76	1.14	ACC
66	209.37	82.44	34.24	85.16	29.75	1.30	ACC
67	209.38	82.51	34.28	85.05	29.76	1.35	ACC
68	209.38	82.59	34.30	85.15	29.81	1.15	ACC
69	209.33	82.46	34.24	84.96	29.78	1.48	ACC
70	209.39	82.53	34.29	85.09	29.72	1.05	ACC
71	209.36	82.38	34.20	84.89	29.65	1.44	ACC
72	209.32	82.44	34.26	85.03	29.80	1.20	ACC
73	209.35	82.45	34.27	84.93	29.74	1.01	ACC
74	209.37	82.61	34.27	84.98	29.66	1.32	ACC
75	209.37	82.40	34.20	85.04	29.67	1.36	ACC
76	209.34	82.51	34.28	85.04	29.79	1.04	ACC
77	209.39	82.53	34.33	85.07	29.77	1.41	ACC
78	209.29	82.46	34.27	85.01	29.70	1.39	ACC
79	209.36	82.38	34.24	85.01	29.75	1.35	ACC
80	209.39	82.35	34.29	84.92	29.74	1.44	ACC
81	209.32	82.31	34.22	84.88	29.71	1.22	ACC
82	209.35	82.46	34.23	84.95	29.68	1.36	ACC
83	209.35	82.54	34.24	85.07	29.85	1.27	ACC
84	209.38	82.49	34.26	85.18	29.81	1.33	ACC
85	209.40	82.50	34.26	84.99	29.74	1.21	ACC
86	209.38	82.43	34.26	85.06	29.72	1.36	ACC
87	209.32	82.43	34.20	84.94	29.84	1.21	ACC
88	209.37	82.48	34.27	84.98	29.71	1.08	ACC
89	209.40	82.47	34.28	85.07	29.76	1.01	ACC
90	209.34	82.33	34.14	84.88	29.70	1.21	ACC
91	209.33	82.42	34.22	84.97	29.78	1.41	ACC
92	209.31	82.39	34.23	85.06	29.71	1.25	ACC

FINAL INSPECTION REPORT

	1.3 PR.	1.5 PR.	1.7 PR.	1.3 PR.	1.5 PR.	1.7 PR.
1	0.009	0.012	0.015	0.008	0.010	0.013
2	0.009	0.012	0.016	0.009	0.011	0.013
3	0.009	0.012	0.014	0.008	0.011	0.013
4	0.009	0.012	0.015	0.008	0.010	0.012
5	0.009	0.012	0.014	0.007	0.010	0.012
6	0.009	0.012	0.014	0.007	0.010	0.012
7	0.009	0.012	0.016	0.009	0.010	0.011
8	0.009	0.013	0.015	0.008	0.010	0.013
9	0.009	0.013	0.015	0.008	0.010	0.013
10	0.009	0.012	0.015	0.008	0.011	0.013
12	0.009	0.012	0.015	0.008	0.010	0.013
13	0.010	0.013	0.016	0.007	0.010	0.012
14	0.009	0.012	0.015	0.007	0.010	0.012
15	0.009	0.012	0.014	0.008	0.010	0.013
16	0.009	0.012	0.014	0.008	0.010	0.013
17	0.009	0.012	0.015	0.008	0.010	0.013
18	0.009	0.012	0.015	0.008	0.011	0.013
19	0.009	0.012	0.015	0.008	0.010	0.013
20	0.009	0.012	0.015	0.007	0.009	0.011
21	0.009	0.011	0.014	0.008	0.010	0.013
22	0.008	0.012	0.014	0.009	0.012	0.014
23	0.009	0.012	0.015	0.008	0.010	0.013
24	0.009	0.013	0.015	0.008	0.011	0.013
25	0.009	0.012	0.014	0.007	0.010	0.012
26	0.009	0.012	0.015	0.008	0.011	0.013
27	0.009	0.012	0.015	0.008	0.010	0.013
28	0.009	0.012	0.015	0.008	0.011	0.013
29	0.009	0.012	0.015	0.008	0.010	0.013
30	0.009	0.012	0.015	0.008	0.010	0.013
31	0.009	0.012	0.014	0.008	0.010	0.012
32	0.009	0.012	0.015	0.008	0.010	0.012
33	0.009	0.012	0.015	0.008	0.011	0.013
34	0.009	0.012	0.015	0.007	0.010	0.013
35	0.009	0.012	0.015	0.008	0.011	0.013
36	0.009	0.012	0.014	0.007	0.010	0.012
37	0.010	0.013	0.016	0.008	0.010	0.011
38	0.009	0.012	0.015	0.008	0.011	0.013
39	0.009	0.011	0.014	0.007	0.010	0.012
40	0.009	0.012	0.015	0.008	0.011	0.013
41	0.009	0.012	0.015	0.008	0.011	0.013
42	0.009	0.012	0.015	0.008	0.011	0.013
43	0.009	0.012	0.015	0.008	0.011	0.013
44	0.009	0.012	0.014	0.007	0.010	0.012

FINAL INSPECTION REPORT

	1.3 PR.	1.5 PR.	1.7 PR.	1.3 PR.	1.5 PR.	1.7 PR.
45	0.009	0.012	0.015	0.008	0.010	0.013
46	0.009	0.012	0.014	0.008	0.010	0.013
47	0.009	0.012	0.015	0.008	0.011	0.013
48	0.009	0.012	0.015	0.008	0.011	0.013
49	0.010	0.013	0.016	0.008	0.011	0.014
50	0.010	0.013	0.016	0.008	0.010	0.013
51	0.009	0.012	0.015	0.008	0.010	0.013
52	0.009	0.012	0.015	0.008	0.010	0.013
53	0.009	0.012	0.015	0.008	0.011	0.013
54	0.010	0.013	0.016	0.008	0.011	0.013
55	0.009	0.012	0.014	0.008	0.010	0.013
56	0.010	0.013	0.016	0.008	0.011	0.013
57	0.009	0.013	0.015	0.007	0.010	0.012
58	0.009	0.012	0.015	0.008	0.011	0.013
59	0.009	0.012	0.015	0.008	0.010	0.013
60	0.009	0.012	0.015	0.008	0.011	0.013
61	0.009	0.012	0.015	0.008	0.010	0.013
62	0.009	0.012	0.015	0.008	0.010	0.013
63	0.009	0.013	0.015	0.008	0.011	0.013
64	0.009	0.012	0.015	0.008	0.011	0.013
65	0.009	0.012	0.015	0.007	0.010	0.012
66	0.009	0.012	0.015	0.008	0.011	0.014
67	0.009	0.012	0.015	0.008	0.011	0.014
68	0.009	0.013	0.015	0.008	0.010	0.013
69	0.009	0.012	0.015	0.008	0.011	0.013
70	0.009	0.012	0.015	0.008	0.010	0.013
71	0.009	0.013	0.015	0.009	0.012	0.014
72	0.009	0.012	0.015	0.008	0.011	0.013
73	0.009	0.012	0.015	0.008	0.011	0.013
74	0.009	0.012	0.015	0.008	0.010	0.013
75	0.009	0.013	0.015	0.008	0.010	0.012
76	0.009	0.012	0.014	0.008	0.011	0.013
77	0.009	0.012	0.015	0.008	0.010	0.013
78	0.009	0.012	0.014	0.007	0.010	0.012
79	0.009	0.012	0.014	0.008	0.011	0.013
80	0.010	0.013	0.016	0.009	0.012	0.015
81	0.009	0.012	0.015	0.008	0.011	0.013
82	0.009	0.012	0.014	0.008	0.011	0.013
83	0.010	0.012	0.016	0.008	0.010	0.012
84	0.009	0.012	0.015	0.008	0.010	0.013
85	0.008	0.012	0.014	0.007	0.010	0.012
86	0.009	0.013	0.015	0.008	0.011	0.013
87	0.010	0.013	0.016	0.008	0.011	0.013
88	0.009	0.013	0.015	0.008	0.011	0.013
89	0.009	0.013	0.015	0.008	0.011	0.013
90	0.009	0.013	0.016	0.009	0.012	0.014
91	0.009	0.013	0.016	0.008	0.011	0.013
92	0.010	0.012	0.016	0.008	0.011	0.013

FINAL INSPECTION REPORT

11.0 SERIAL NUMBER CORRELATION

Incoming inspection part number correlation sheet. This sheet not to be used for blade assembly or positioning
Reference final inspection report moment weigh report for position during assembly.

CORRELATION SHEET							
Item	Part number	Serial number	Material	Item	Part number	Serial number	Material
1	323E2149 G002	J1AJ023559	GTD111	47	323E2149 G001	J1AJ024294	GTD111
2	323E2149 G001	J1AJ024349	GTD111	48	323E2149 G001	J1AJ024289	GTD111
3	323E2149 G001	J1AJ024280	GTD111	49	323E2149 G001	J1AJ024138	GTD111
4	323E2149 G001	J1AJ024185	GTD111	50	323E2149 G001	J1AJ024092	GTD111
5	323E2149 G001	J1AJ024222	GTD111	51	323E2149 G001	J1AJ024313	GTD111
6	323E2149 G001	J1AJ024184	GTD111	52	323E2149 G001	J1AJ024382	GTD111
7	323E2149 G001	J1AJ024106	GTD111	53	323E2149 G001	J1AJ024099	GTD111
8	323E2149 G001	J1AJ023639	GTD111	54	323E2149 G001	J1AJ024319	GTD111
9	323E2149 G001	J1AJ023794	GTD111	55	323E2149 G001	J1AJ024328	GTD111
10	323E2149 G001	J1AJ024042	GTD111	56	323E2149 G001	J1AJ024062	GTD111
11	323E2149 G001	J1AJ024187	GTD111	57	323E2149 G001	J1AJ024028	GTD111
12	323E2149 G001	J1AJ024100	GTD111	58	323E2149 G001	J1AJ024105	GTD111
13	323E2149 G001	J1AJ024242	GTD111	59	323E2149 G001	J1AJ024247	GTD111
14	323E2149 G001	J1AJ024200	GTD111	60	323E2149 G001	J1AJ024115	GTD111
15	323E2149 G001	J1AJ024285	GTD111	61	323E2149 G001	J1AJ024343	GTD111
16	323E2149 G001	J1AJ024057	GTD111	62	323E2149 G001	J1AJ024195	GTD111
17	323E2149 G001	J1AJ024226	GTD111	63	323E2149 G001	J1AJ024084	GTD111
18	323E2149 G001	J1AJ024346	GTD111	64	323E2149 G001	J1AJ024272	GTD111
19	323E2149 G001	J1AJ024386	GTD111	65	323E2149 G001	J1AJ024236	GTD111
20	323E2149 G001	J1AJ024231	GTD111	66	323E2149 G001	J1AJ024090	GTD111
21	323E2149 G001	J1AJ024248	GTD111	67	323E2149 G001	J1AJ024284	GTD111
22	323E2149 G001	J1AJ024189	GTD111	68	323E2149 G001	J1AJ023929	GTD111
23	323E2149 G001	J1AJ024293	GTD111	69	323E2149 G001	J1AJ023747	GTD111
24	323E2149 G001	J1AJ024301	GTD111	70	323E2149 G001	J1AJ023643	GTD111
25	323E2149 G001	J1AJ024148	GTD111	71	323E2149 G001	J1AJ022175	GTD111
26	323E2149 G001	J1AJ024255	GTD111	72	323E2149 G001	J1AJ024286	GTD111
27	323E2149 G001	J1AJ024072	GTD111	73	323E2149 G001	J1AJ024271	GTD111
28	323E2149 G001	J1AJ024252	GTD111	74	323E2149 G001	J1AJ024412	GTD111
29	323E2149 G001	J1AJ024238	GTD111	75	323E2149 G001	J1AJ023943	GTD111
30	323E2149 G001	J1AJ024049	GTD111	76	323E2149 G001	J1AJ024311	GTD111
31	323E2149 G001	J1AJ024314	GTD111	77	323E2149 G001	J1AJ023865	GTD111
32	323E2149 G001	J1AJ024219	GTD111	78	323E2149 G001	J1AJ024210	GTD111
33	323E2149 G001	J1AJ024339	GTD111	79	323E2149 G001	J1AJ024246	GTD111
34	323E2149 G001	J1AJ024173	GTD111	80	323E2149 G001	J1AJ018499	GTD111
35	323E2149 G001	J1AJ024362	GTD111	81	323E2149 G001	J1AJ024205	GTD111
36	323E2149 G001	J1AJ024160	GTD111	82	323E2149 G001	J1AJ024075	GTD111
37	323E2149 G001	J1AJ024136	GTD111	83	323E2149 G001	J1AJ024307	GTD111
38	323E2149 G001	J1AJ024050	GTD111	84	323E2149 G001	J1AJ024230	GTD111
39	323E2149 G001	J1AJ024086	GTD111	85	323E2149 G001	J1AJ024167	GTD111
40	323E2149 G001	J1AJ024209	GTD111	86	323E2149 G001	J1AJ024273	GTD111
41	323E2149 G001	J1AJ024083	GTD111	87	323E2149 G001	J1AJ023872	GTD111
42	323E2149 G001	J1AJ024304	GTD111	88	323E2149 G001	J1AJ024260	GTD111
43	323E2149 G001	J1AJ024298	GTD111	89	323E2149 G001	J1AJ024071	GTD111
44	323E2149 G001	J1AJ024229	GTD111	90	323E2149 G001	J1AJ022167	GTD111
45	323E2149 G001	J1AJ024147	GTD111	91	323E2149 G001	J1AJ022430	GTD111
46	323E2149 G001	J1AJ024182	GTD111	92	323E2149 G001	J1AJ024361	GTD111

FINAL INSPECTION REPORT

12.0 DEFECT LEGEND TABLE

DEFECT LEGEND TABLE RECORD SHEET																																					
Information		INSPECTION FINDINGS																																			
Blade Number	Serial Number	Squealer Tip wear	Squealer Tip cracks	Squealer Tip corrosion	Squealer Tip FOD / missing material	Tip cap crack	Tip cap corrosion	Angel wing wear	Angel wing cracks	Angel wing deformation	Angel wing FOD / missing material	A/F cracks		A/F erosion /corrosion		A/F missing material		A/F FOD		A/F porosity pitting		Platform cracks	Platform corrosion	Platform FOD	Shank cracks	Shank FOD / missing material	Pin slot wear	Pin slot cracks	Pin slot deform	Root wear	Root cracks	Pin ball check	Cooling hole check				
												Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.																
1		B		WM/TPR				B																										ACC	ACC		
2		B		WM/TPR				B																											ACC	ACC	
3		B		WM/TPR				B				TE	B																						ACC	ACC	
4		B		WM/TPR				B																											ACC	REJ	
5		B		WM/TPR				B																											ACC	ACC	
6		B		WM/TPR				B				TE	B																						ACC	ACC	
7		B	WB/TPR	WM/TPR				B																												ACC	ACC
8		B		WM/TPR				B																												ACC	ACC
9		B	WB/TPR	WM/TPR				B																												ACC	ACC
10		B		WM/TPR				B																												ACC	ACC
11		B		WM/TPR				B																												ACC	ACC
12		B		WM/TPR				B																												ACC	ACC
13		B		WM/TPR				B																												ACC	ACC
14		B		WM/TPR				B																												ACC	ACC
15		B		WM/TPR				B																												ACC	ACC
16		B		WM/TPR				B																												ACC	ACC
17		B		WM/TPR				B																												ACC	ACC
18		B		WM/TPR				B																												ACC	ACC
19		B		WM/TPR				B				TE	B																							ACC	ACC
20		B		WM/TPR				B																												ACC	ACC
21		B		WM/TPR				B																												ACC	ACC
22		B		WM/TPR				B																												ACC	ACC
23		B		WM/TPR				B																												ACC	ACC
24		B		WM/TPR				B																												ACC	ACC
25		B		WM/TPR				B																												ACC	ACC
26		B		WM/TPR				B																												ACC	ACC
27		B		WM/TPR				B																												ACC	ACC
28		B	WB/TPR	WM/TPR				B				TE	B																							ACC	ACC
29		B		WM/TPR				B																												ACC	ACC
30		B		WM/TPR				B																												ACC	ACC
31		B		WM/TPR				B																												ACC	ACC
32		B		WM/TPR				B																												ACC	ACC
33		B		WM/TPR				B																												ACC	ACC
34		B	WB/TPR	WM/TPR				B				TE	B																							ACC	ACC
35		B		WM/TPR				B																												ACC	ACC
36		B		WM/TPR				B																												ACC	ACC
37		B		WM/TPR				B																												ACC	ACC
38		B		WM/TPR				B																												ACC	ACC
39		B		WM/TPR				B																												ACC	ACC
40		B	WB/TPR	WM/TPR				B																												ACC	ACC
41		B		WM/TPR				B																												ACC	ACC
42		B		WM/TPR				B																												ACC	ACC
43		B	WB/TPR	WM/TPR				B																												ACC	ACC
44		B		WM/TPR				B				TE	B																							ACC	ACC
45		B		WM/TPR				B				TE	B																							ACC	ACC
46		B		WM/TPR				B																												ACC	ACC
47		B		WM/TPR				B																												ACC	ACC
48		B		WM/TPR				B																												ACC	ACC
49		B		WM/TPR				B																												ACC	ACC
50		B		WM/TPR				B																												ACC	ACC

FINAL INSPECTION REPORT

12.0 DEFECT LEGEND TABLE (CONTINUE)

DEFECT LEGEND TABLE RECORD SHEET																																		
Information		INSPECTION FINDINGS																																
Blade Number	Serial Number	Squealer Tip wear	Squealer Tip cracks	Squealer Tip corrosion	Squealer Tip FOD / missing material	Tip erp crack	Tip erp corrosion	Angel wing wear	Angel wing cracks	Angel wing deformation	Angel wing FOD / missing material	A.F. cracks		A.F. erosion /corrosion		A.F. missing material		A.F. FOD		A.F. porosity pitting		Platform cracks	Platform corrosion	Platform FOD	Shank cracks	Shank FOD / missing material	Pin slot wear	Pin slot cracks	Pin slot deform	Root wear	Root cracks	Pin ball check	Cooling hole check	
		Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Platform cracks	Platform corrosion	Platform FOD	Shank cracks	Shank FOD / missing material	Pin slot wear	Pin slot cracks	Pin slot deform	Root wear	Root cracks	Pin ball check	Cooling hole check	
51		B		WM/TPR				B				TE	B																			ACC	ACC	
52		B		WM/TPR				B																									ACC	ACC
53		B		WM/TPR				B																									ACC	ACC
54		B		WM/TPR				B				TE	B																				ACC	ACC
55		B		WM/TPR				B																									ACC	ACC
56		B		WM/TPR				B																									ACC	ACC
57		B		WM/TPR				B																									ACC	ACC
58		B		WM/TPR				B																									ACC	ACC
59		B		WM/TPR				B																									ACC	ACC
60		B		WM/TPR				B				TE	B																				ACC	ACC
61		B		WM/TPR				B																									ACC	ACC
62		B		WM/TPR				B																									ACC	ACC
63		B		WM/TPR				B																									ACC	ACC
64		B		WM/TPR				B																									ACC	ACC
65		B		WM/TPR				B																									ACC	ACC
66		B		WM/TPR				B				TE	B																				ACC	ACC
67		B		WM/TPR				B																									ACC	ACC
68		B		WM/TPR				B	WB	WM																							ACC	ACC
69		B		WM/TPR				B																									ACC	ACC
70		B		WM/TPR				B		WM																							ACC	ACC
71		B		WM/TPR				B				TE	B																				ACC	ACC
72		B		WM/TPR				B				TE	B																				ACC	ACC
73		B		WM/TPR				B																									ACC	ACC
74		B	WB/TPR	WM/TPR				B		WM																							ACC	ACC
75		B		WM/TPR				B	WB	WM																							ACC	ACC
76		B		WM/TPR				B		WM		TE	B																				ACC	ACC
77		B	WB/TPR	WM/TPR				B																									ACC	ACC
78		B		WM/TPR				B																									ACC	ACC
79		B	WB/TPR	WM/TPR				B																									ACC	ACC
80		B		WM/TPR				B																									ACC	REJ
81		B		WM/TPR				B																									ACC	ACC
82		B		WM/TPR				B																									ACC	ACC
83		B	WB/TPR	WM/TPR				B																									ACC	ACC
84		B		WM/TPR				B																									ACC	ACC
85		B		WM/TPR				B																									ACC	ACC
86		B		WM/TPR				B																									ACC	ACC
87		B		WM/TPR				B																									ACC	ACC
88		B		WM/TPR				B																									ACC	ACC
89		B		WM/TPR				B																									ACC	ACC
90		B		WM/TPR				B																									ACC	ACC
91		B		WM/TPR				B				TE	B																				ACC	ACC
92		B		WM/TPR	WB			B																									ACC	ACC

P = Planishing to be reclaimed to the profile.

B = Blend repair to be performed in accordance with the location blend limits.

WB = Weld and Blend to be performed based on the *AREA* limits and defects detected.

WM = Weld and Machining to be performed to build material dimensions and restore original dimensions and contours.

WE = Welding and Electric discharge machining (EDM) to be performed to build material dimensions and restore original dimensions.

TPR = Transient Phase Restoration to be performed based on the defects detected.

WD = Weld and Drilling to be performed to build material dimensions and restore original dimensions.

REJ = Dimension unacceptable and will require repair or cause of scrap

M/B = Machining and Blend repair.

R = Replace new Installation

Loc. = Concave side CC, convex side CV, Leading edge LE, Trailing

Non-Repairable / Scrap.

L = Light repair category

M = Medium repair category

H = Heavy repair category

EX = Salvation repair category

ACC = Acceptable as is.

DT = Performed destructive testing.

REP = Replacement component. (For final Inspection Report)

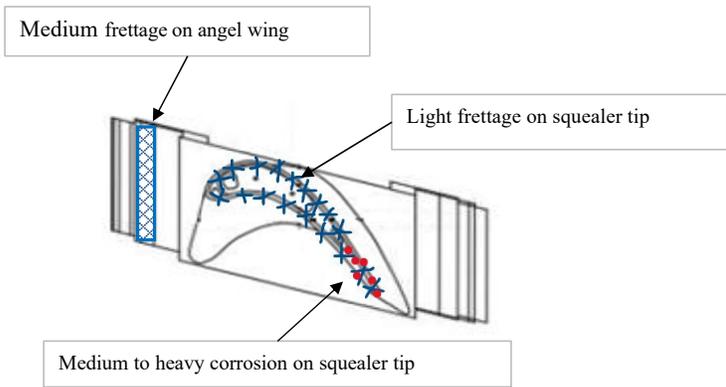
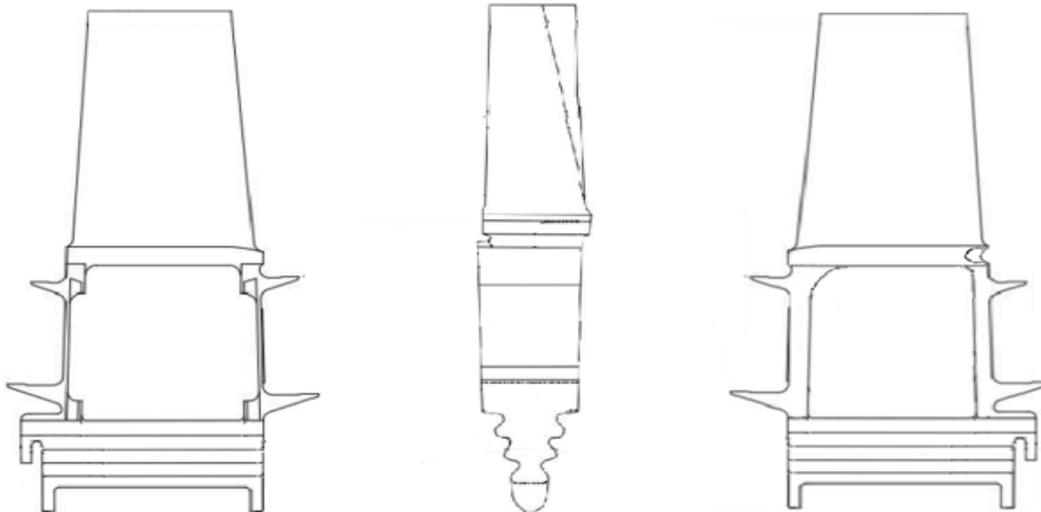
FINAL INSPECTION REPORT

13.0 DEFECT MAP

INSPECTION AND PROCESS RECORD SHEET	MS6001FA 1st SATGE BUCKET		IPRS NO. 3065-40
	PART NUMBER : GEBL01M6FA		REV. 00
CUSTOMER :	Nghi Son Refinery &	CUSTOMER PO :	PO04102025-HGP
JOB NUMBER :	824025	OP.	240
INSPECTED BY :	Anirut D.	DATE :	07/08/2025
Crack (mm)	Foreign Object Damage (L/M/H)	Frettage (L/M/H)	Deformation area(mm ²)
		Corrosion (L/M/H)	Missing Material (mm ²)

TYPICAL DEFECT

(Incoming condition)

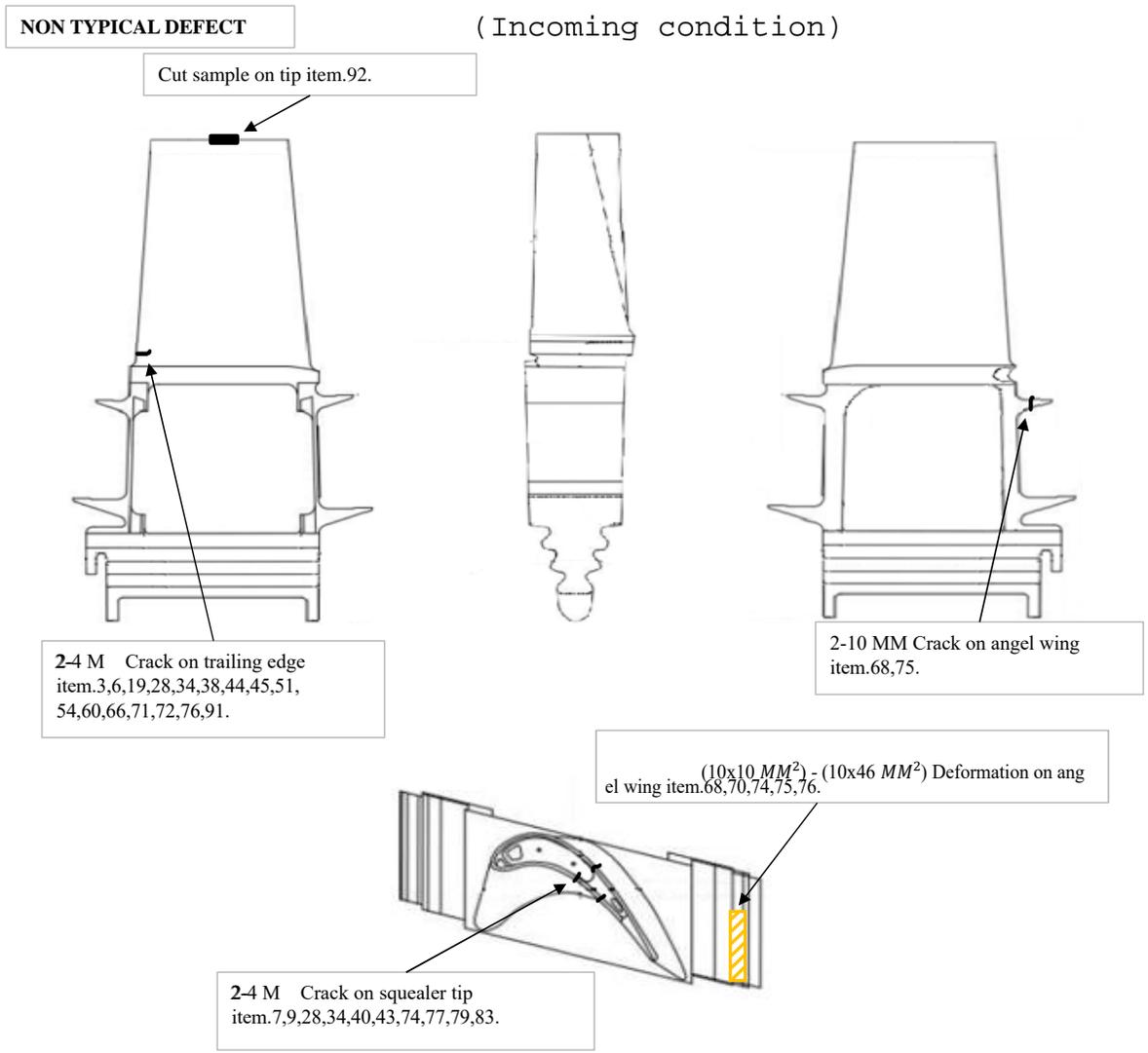


FINAL INSPECTION REPORT

13.0 DEFECT MAP (CONTINUE)

INSPECTION AND PROCESS RECORD SHEET	MS6001FA 1st SATGE BUCKET		IPRS NO. 3065-40
	PART NUMBER : GEBL01M6FA		REV. 00
CUSTOMER :	Nghi Son Refinery &	CUSTOMER PO :	PO04102025-HGP
JOB NUMBER :	824025	OP.	240
INSPECTED BY :	Anirut D.	DATE :	07/08/2025

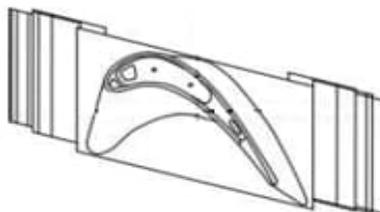
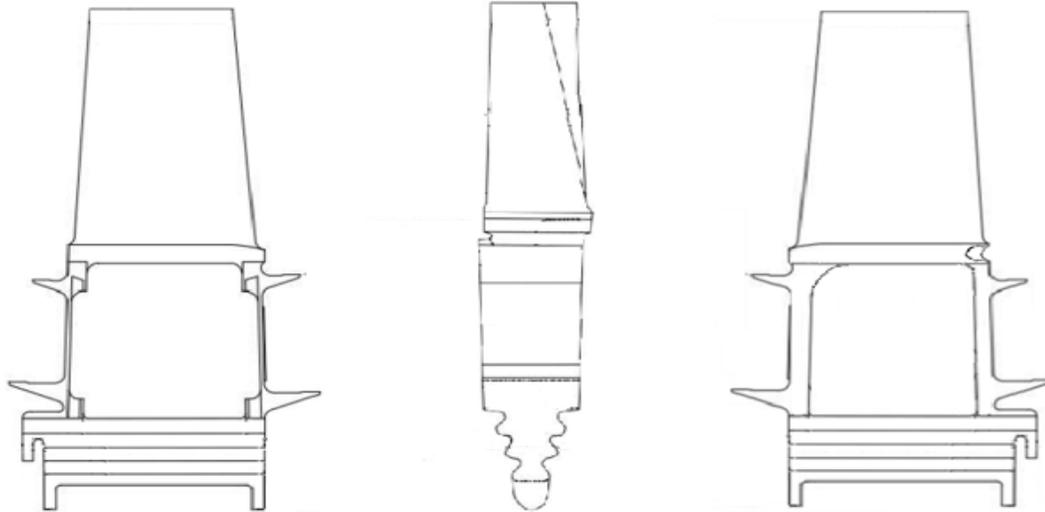
mm Crack (mm)
 Foreign Object Damage (L/M/H)
 Fretage (L/M/H)
 Deformation area(mm²)
 Corrosion (L/M/H)
 Missing Material (mm²)



FINAL INSPECTION REPORT

13.0 DEFECT MAP (CONTINUE)

INSPECTION AND PROCESS RECORD SHEET	MS6001FA 1st SATGE BUCKET		I PRS NO.	3065-40	
	PART NUMBER : GEBL01M6FA		REV.	00	
CUSTOMER :	Nghi Son Refinery &	CUSTOMER PO :	PO04102025-HGP		
JOB NUMBER :	824025	OP.	FINAL		
INSPECTED BY :	Supasit K.	DATE :	13-Oct-25		
Crack (mm)	Foreign Object Damage (L/MH)	Fretage (L/MH)	Deformation area(mm ²)	Corrosion (L/MH)	Missing Material (mm ²)



FINAL INSPECTION REPORT

14.0 MOMENT WEIGHT

<p>SCHENCK Balancing and Diagnostic Systems</p>	<p>EthosEnergy (Thailand) Limited 39/9 Sermsuwan Road, Tambon Maptaphut Amphur Muang, Rayong 21150, Thailand Tel: +66 (38) 698900</p>	
<p>Operator: BucketTH </p>	<p>BladisNET Revision 3.0 © 2006 Schenck RoTec GmbH Germany</p>	<p>13/10/2025 Page 1</p>

Blade Type: GEBL01M6FA

Engine type:	MS6001FA
Stage:	1
No. of blades:	92
No. of locking blades:	1
Positions of locking blades:	1
Moment of master blade or preload moment:	1785600 gmm
Admissible variation for measurement:	3 digits
Type of matching:	None
Tolerance:	1000 gmm
Predistribution Pattern:	7 - Sequence of Weighing

Blade Set: 824025

Generated by:	Supasit k.
Order:	Nghi Son Refinery
New reduced tolerance:	10 gmm
Matching type:	None
Predistribution Pattern:	7 - Sequence of Weighing
Calculated unbalance:	8 gmm
Calculated Angle:	236 deg

State:
Blade Predistribution optimized.
Set in tolerance.
Set in reduced tolerance.

Caution:
Buckets/Blades need to be installed by
"Pos. No." in order to minimize any
vibration issues!

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Blade Type: **GEBL01M6FA**

Blade Set: **824025**

Blade Distribution

Caution:

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Pos No.	Moment [gmm]	Serial No.
🔒 1	1787600	J1AJ023559
2	1790000	J1AJ024349
3	1795800	J1AJ024280
4	1802400	J1AJ024185
5	1793400	J1AJ024222
6	1801800	J1AJ024184
7	1796200	J1AJ024106
8	1797000	J1AJ023639
9	1788000	J1AJ023794
10	1802400	J1AJ024042
11	1788400	J1AJ024138
12	1793400	J1AJ024100
13	1805200	J1AJ024242
14	1799000	J1AJ024200
15	1809200	J1AJ024285
16	1802600	J1AJ024057
17	1791600	J1AJ024226
18	1785600	J1AJ024346
19	1800800	J1AJ024386
20	1771000	J1AJ022175
21	1788800	J1AJ024248
22	1782800	J1AJ024189
23	1790800	J1AJ024293
24	1798600	J1AJ024301
25	1792200	J1AJ024148
26	1785000	J1AJ024255

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Blade Type: **GEBL01M6FA**

Blade Set: **824025**

Blade Distribution

Caution:
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 vibration issues!

Pos No.	Moment [gmm]	Serial No.
27	1788200	J1AJ024072
28	1790800	J1AJ024252
29	1800800	J1AJ024238
30	1787600	J1AJ024049
31	1796400	J1AJ024314
32	1780200	J1AJ024219
33	1783200	J1AJ024339
34	1795800	J1AJ024362
35	1794600	J1AJ024173
36	1801200	J1AJ024160
37	1785800	J1AJ024136
38	1803200	J1AJ024050
39	1796600	J1AJ024209
40	1797000	J1AJ024086
41	1799200	J1AJ024083
42	1788800	J1AJ024304
43	1784200	J1AJ024298
44	1772800	J1AJ024229
45	1791200	J1AJ024147
46	1799200	J1AJ024182
47	1793600	J1AJ024294
48	1792800	J1AJ024289
49	1803400	J1AJ024187
50	1796200	J1AJ024092
51	1798400	J1AJ024313
52	1785400	J1AJ024382

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Blade Set: **824025**

Blade Distribution

Caution:
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 "Pos. No." in order to minimize any
 vibration issues!

Pos No.	Moment [gmm]	Serial No.
53	1796400	J1AJ024099
54	1789200	J1AJ024328
55	1789400	J1AJ024319
56	1783800	J1AJ024062
57	1791400	J1AJ024028
58	1780000	J1AJ024105
59	1795600	J1AJ024307
60	1792400	J1AJ024115
61	1797600	J1AJ024343
62	1797600	J1AJ024195
63	1795000	J1AJ024084
64	1800000	J1AJ024272
65	1786200	J1AJ024236
66	1792000	J1AJ024090
67	1795600	J1AJ024284
68	1786600	J1AJ023929
69	1783400	J1AJ023747
70	1800600	J1AJ023643
71	1827800	J1AJ024231
72	1787400	J1AJ024286
73	1801600	J1AJ024271
74	1789800	J1AJ024412
75	1803800	J1AJ023943
76	1805400	J1AJ024311
77	1795600	J1AJ023865
78	1797800	J1AJ024210

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Blade Type: GEBL01M6FA

Blade Set: 824025

Blade Distribution

Caution:

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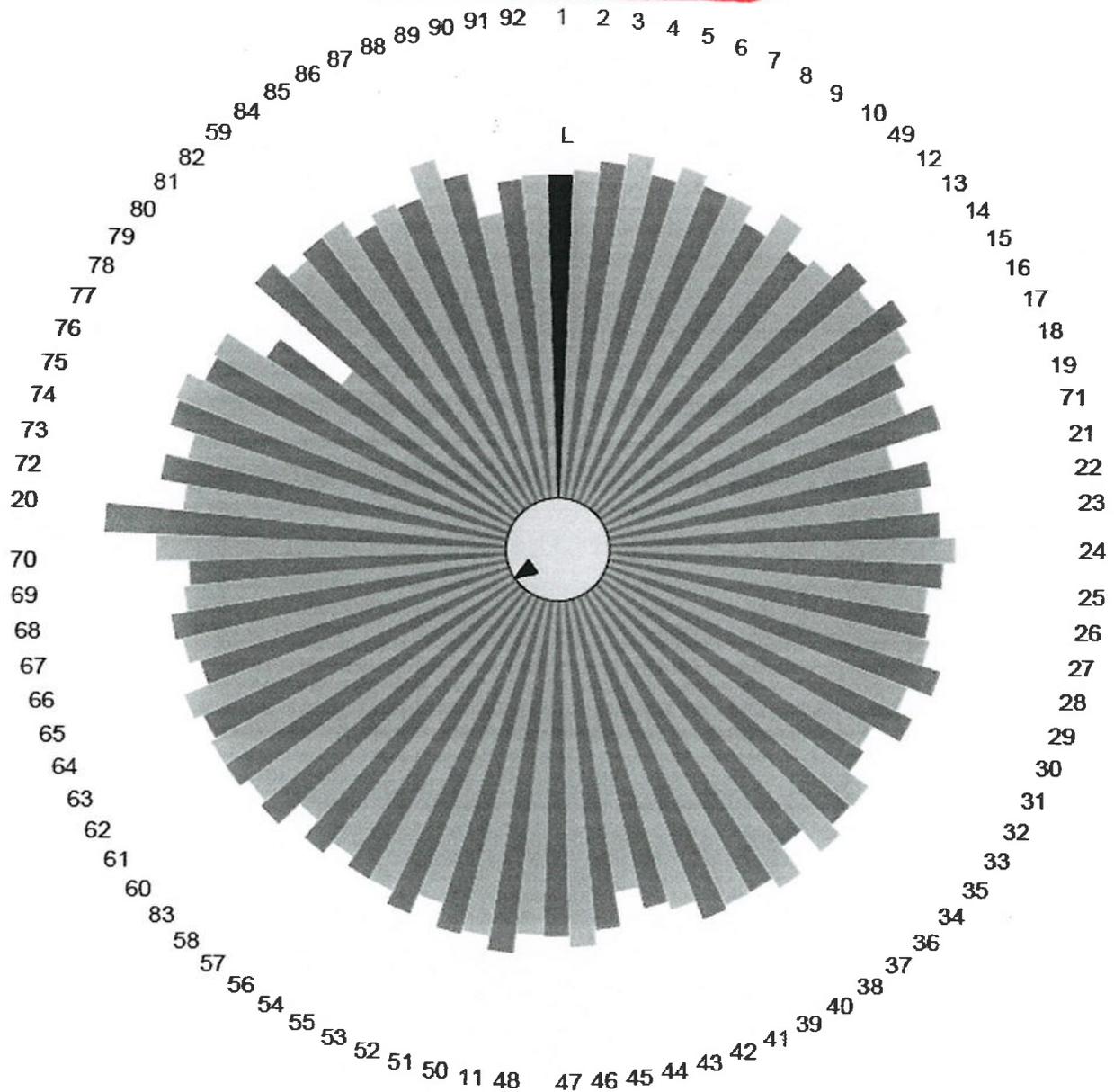
Pos No.	Moment [gmm]	Serial No.
79	1773600	J1AJ024246
80	1733000	J1AJ018499
81	1802400	J1AJ024205
82	1791800	J1AJ024075
83	1796000	J1AJ024247
84	1796600	J1AJ024230
85	1786200	J1AJ024167
86	1791600	J1AJ024273
87	1788800	J1AJ023872
88	1805600	J1AJ024260
89	1794000	J1AJ024071
90	1770000	J1AJ022167
91	1786200	J1AJ022430
92	1787800	J1AJ024361

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Blade Type: **GEBL01M6FA**

Caution:
Buckets/Blades need to be installed by
"Pos. No." in order to minimize any
vibration issues!

Blade Set: **824025**



Predistribution Pattern:	7 - Sequence of Weighing
Calculated Unbalance:	8 gmm
Calculated Angle:	236 deg
State of Blade Set:	In Tolerance (1000 gmm)
	In reduced Tolerance (10 gmm)