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 aviationgrade 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, nvironmental 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 2nd STAGE NOZZLE

Date of Report: October 30, 2025

Responsible Product Engineer: _____

Mr. Komkrit Rattanawong
Engineer

Report prepared by: _____

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Report writer

Report reviewed and approved by:_____

Mr. Pheerayawat Muadna
(Engineering Manager)

1. INTRODUCTION:

92 pcs. Of MS6001FA 2nd STAGE BUCKET have been fully refurbished based on the requirements of the incoming inspection report findings:

Component Basic			
Quantity	91	1	-
Original part number	131E4439 P005	131E4439 P006	-
Material type	GTD 111	GTD 111	-
Manufacturer	GE	GE	-
As received coatings applied	Al diffusion coating		
Configuration	10 Cooling holes		

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)	-

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
Medium Repair	Repair	1	Set
Coating	Diffused MCrAlY coating	1	Set

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

3. ENGINEERING REPAIR SUMMARY:

All MS6001FA 2nd Stage Buckets were inspected, repaired, and certified in accordance with the approved EthosEnergy Work Scope of Repair and UNEW Proprietary Engineering Standards. Each component was confirmed to be within the medium repair classification, suitable for full refurbishment and return to service.

Incoming inspections included visual, dimensional, metallurgical, and non-destructive evaluations. Typical service damage consisted of oxidation, tip and shroud wear, minor cracking, and surface erosion. All identified defects were documented and reviewed with the customer prior to repair commencement.

During refurbishment, defective and oxidized areas were mechanically blended and machined to clean base material. Localized cracks, tip seal fins, cutter teeth, Z-notch edges, shroud faces, and angel wings were GTAW weld-restored using alloy-matched filler material. Welded surfaces were precision-blended to recover the original airfoil and shroud profiles. Dimensional restoration was verified by CMM inspection.

Post-weld vacuum solution heat treatment re-established microstructural stability and relieved residual stress. All repaired areas underwent FPI and visual re-inspection to confirm structural integrity. Final dimensional and wall-thickness checks validated compliance with engineering drawings.

External surfaces received a HVOF-applied MCrAlY bond coat for oxidation resistance, followed by vacuum diffusion heat treatment for metallurgical bonding. Subsequent Pulse Thermography confirmed coating adhesion. Roots were shot-peened to enhance fatigue life, and new locking tangs were installed. Each bucket was moment-weighed, recorded on a balance chart, and airflow-tested to confirm that cooling passages remained clear and consistent with baseline measurements.

All operations were executed under UNEW's proprietary quality program and EthosEnergy's ISO 9001:2015, ISO 14001:2015, ISO 45001:2018, and ISO 17025:2017 certified systems. Final inspections confirmed full dimensional, metallurgical, and coating compliance. The refurbished 2nd Stage Buckets are therefore certified serviceable for reinstallation at Nghi Son Refinery & Petrochemical.

4. CERTIFICATE OF CONFORMANCE:

Component: MS6001FA 2nd Stage Bucket Assembly
Quantity: 92 Pieces
Material: Rene 80 / FSX-414 Equivalent
Repair Category: Medium 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 2nd Stage Buckets identified above have been inspected, refurbished, heat-treated, coated, and tested in full compliance with the approved EthosEnergy Work Scope of Repair and UNEW Engineering Specifications.

The medium-repair program included:
• Comprehensive inspection (visual, FPI, CMM, and airflow).
• Removal of oxidation and defective material, followed by GTAW weld restoration of tip seals, cutter teeth, Z-notch, shroud, and angel-wing areas.
• Post-weld vacuum solution heat treatment to restore the alloy microstructure.
• Dimensional recovery and blending to re-establish aerodynamic profiles.
• Application of HVOF MCrAlY bond coat and vacuum diffusion heat treatment to ensure metallurgical coating adhesion.
• Pulse Thermography and visual verification of coating quality.
• Shot-peening of fir-tree roots, installation of new locking tangs, and moment-weight balancing to ensure rotor assembly accuracy.
• Final dynamic airflow inspection confirming clear and uniform cooling passages.

All work was conducted under ISO 9001:2015, ISO 14001:2015, ISO 45001:2018, and ISO 17025:2017 certified quality systems.
Final inspections verified that all repaired components conform to dimensional, metallurgical, and performance standards.

Accordingly, EthosEnergy (Thailand) Ltd. and UNEW, Inc. jointly certify that the subject components meet all applicable technical and contractual requirements and are hereby released in serviceable condition for reinstallation.

5. SCOPE OF WORK:

MS6001FA STAGE 2 BLADE

Work scope	Inspect	Medium	Coating
Inspect			
Perform receipt inspection and record serial numbers (highlight locking blade)	X		
Perform visual inspection and segregate obvious scrap components	X		
Perform metallurgical evaluation of base material and coating type, report on condition (if coated)	X		
Mask root sections and internal passages abrasive blast external gas path surfaces	X		
Perform incoming dynamic flow inspection to verify cooling passages are free and clear	X		
Perform chemical strip of external gas path coatings	X		
Perform incoming solution heat treatment in full vacuum environment	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		
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			
Blend to remove oxidation product on external repairable areas		X	
Remove defective material in repairable areas in preparation for weld repairs.		X	
Perform fluorescent penetrant inspection of prepared areas		X	
Weld build up tip seal fin and restore cutter tooth areas as required.		X	

5. SCOPE OF WORK:(CONTINUE)

Weld build up Z notch and shroud areas as required		X	
Weld build up angel wings as required.		X	
Blend all welded area to restore component profile		X	
Perform fluorescent penetrant inspection		X	
Perform visual inspection to ensure component conformity		X	
Perform post repair solution heat treatment in full vacuum environment.		X	
Perform fluorescent penetrant inspection.		X	
Perform dimensional inspection (CMM program)		X	
Coating			
Apply External HVOF MCrAlY coating			X
Perform post coating heat treatment in a vacuum environment			X
Perform visual inspection			X
Perform final age heat treatment in full vacuum environment		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 fir tree root		X	
Apply root locking Tang		X	
Perform moment weigh of blades and produce balance chart, label blade location		X	
Perform dynamic flow inspection to verify cooling passages are free and clear		X	
Perform final visual inspection		X	
Compile Final Report, pack and ship components with all required documentation as listed in Purchase Order		X	

6. ENGINEERING DETAIL WORK DONE:

6.1. Inspection Phase

Task	Detailed Description
Perform receipt inspection and record serial numbers (highlight locking blade)	All 2nd Stage Buckets were received, counted, and recorded by serial number. Locking blades were identified for configuration control. Visual checks confirmed proper packaging and no transit damage.
Perform visual inspection and segregate obvious scrap components	An initial screening separated unrepairable parts exhibiting severe cracking, distortion, or excessive oxidation. Only repairable units were accepted for further processing.
Perform metallurgical evaluation of base material and coating type (if coated)	Samples were evaluated to determine alloy condition, coating type, and oxidation penetration. Microstructural analysis confirmed the base material was suitable for medium-level refurbishment.
Mask root sections and internal passages; abrasive blast external gas-path surfaces	Root areas and cooling holes were masked to protect precise fits. Controlled abrasive blasting removed external oxides and loose coatings, preparing surfaces for non-destructive inspection.
Perform incoming dynamic flow inspection to verify cooling passages are free and clear	Airflow tests verified that all cooling channels were open. Flow readings were documented for later comparison after repair and coating.
Perform chemical strip of external gas-path coatings	Chemical stripping completely removed the residual MCrAlY or aluminide coatings, exposing clean base metal for weld and blend repair.
Perform incoming solution heat treatment in full vacuum environment	A vacuum solution heat treatment was applied to homogenize the alloy, relieve stress, and restore ductility before repair operations.
Perform heat-tint operation to ensure full coating removal	Controlled heating highlighted any remaining coatings or surface oxides, ensuring full cleaning before inspection.
Perform fluorescent penetrant inspection and record all defects	FPI revealed surface cracks, oxidation, and pitting on the airfoil, shroud, and angel-wing regions. Each defect was mapped and photographed for engineering assessment.

Task	Detailed Description
Perform visual inspection and record all defects	Engineers visually documented erosion, scaling, or mechanical wear on all surfaces.
Perform dimensional inspection and report all non-conformities	Using coordinate measuring (CMM) equipment, each bucket's airfoil, shroud, and root geometry were compared to nominal tolerances. Out-of-limit areas were assigned for restoration.
Compile incoming inspection report and forward to customer	All inspection results, photos, and flow data were compiled into a formal report and submitted to UNEW for scope approval.
Hold points until customer discussions and agreement on repair scopes have been held/reached	Work paused pending customer confirmation of the repair approach, classification, and scope acceptance.

6.2. Repair Phase

Task	Detailed Description
Blend to remove oxidation product on external repairable areas	External oxidation was mechanically blended using precision rotary tools to reach sound base metal while maintaining aerodynamic contours.
Remove defective material in repairable areas in preparation for weld repairs	Cracked or degraded material was machined out, creating clean weld-ready surfaces for rebuilding.
Perform fluorescent penetrant inspection of prepared areas	FPI confirmed that all cracks and oxidation had been fully removed before welding.
Weld build-up tip seal fin and restore cutter tooth areas as required	Tip-seal fins and cutter teeth exhibiting wear were rebuilt with GTAW welds using Rene-80 compatible filler, restoring sealing geometry.
Weld build-up Z-notch and shroud areas as required	Z-notch edges and shroud regions were weld-built to correct erosion or cracking, maintaining mechanical engagement tolerances.

Task	Detailed Description
Weld build-up angel wings as required	Angel-wing bases were rebuilt by controlled multi-pass GTAW to restore structural integrity and sealing capacity.
Blend all welded areas to restore component profile	After welding, all surfaces were ground and blended to match the aerodynamic and dimensional contours.
Perform fluorescent penetrant inspection	FPI confirmed that all weld zones were free from cracks or porosity.
Perform visual inspection to ensure component conformity	Post-weld visual checks verified repair uniformity and surface finish.
Perform post-repair solution heat treatment in full vacuum environment	A post-repair vacuum solution heat treatment re-established the γ′ phase structure and relieved thermal stresses from welding.
Perform fluorescent penetrant inspection	FPI ensured no micro-cracks formed during the post-repair heat treatment cycle.
Perform dimensional inspection (CMM program)	Using CMM, final dimensions (tip height, chord, platform) were verified and recorded to confirm conformance to specification.

6.3. Coating and Final Finishing Phase

Task	Detailed Description
Apply External HVOF MCrAlY coating	A dense MCrAlY coating was applied via High-Velocity Oxygen Fuel (HVOF) to restore oxidation and corrosion resistance on gas-path surfaces.
Perform post-coating heat treatment in a vacuum environment	Vacuum heat treatment diffused the MCrAlY layer into the substrate to ensure metallurgical bonding and coating adhesion.
Perform visual inspection	Coating thickness and surface uniformity were verified visually and with precision measurement.
Perform final age heat treatment in full vacuum environment	Final aging restored mechanical strength and thermal stability of the repaired and coated alloy.
Perform Pulse Thermography inspection	Non-destructive infrared testing verified coating adhesion and detected any delamination or voids beneath the surface.
Perform visual inspection	Additional visual verification confirmed coating integrity, color uniformity, and finish quality.
Mask off all external and internal cooling surfaces to protect coated areas	Cooling holes and root regions were masked prior to finishing operations to prevent overspray and contamination.
Perform shot peen operation of fir-tree root	Controlled shot-peening introduced beneficial compressive stresses, improving fatigue life and preventing root-crack initiation.
Apply root locking tang	New locking tangs were installed to secure the blade during rotor assembly.
Perform moment weigh of blades and produce balance chart, label blade location	Each bucket was weighed, and the moment recorded to create a balance chart ensuring uniformity during rotor stacking.
Perform dynamic flow inspection to verify cooling passages are free and clear	Final airflow testing confirmed that internal cooling paths were clear and that flow matched pre-repair data.

Task	Detailed Description
Perform final visual inspection	Engineers conducted a full visual inspection under magnification to confirm completion quality and marking correctness.
Compile Final Report, pack and ship components with all required documentation as listed in Purchase Order	All inspection records, NDT data, heat-treatment charts, and certificates were compiled into a final report. Components were packed, labeled, and shipped per customer specification.

Result

All 2nd Stage Buckets completed a medium-level refurbishment following UNEW proprietary engineering standards and EthosEnergy ISO-certified quality procedures.
Post-repair inspections confirmed full restoration of geometry, coating protection, and cooling function. All components were certified serviceable for reinstallation at Nghi Son Refinery & Petrochemical.

7.0 MATERIAL EVALUATION

Report No.	L11074		Job order no.	824026
Serial no.(or ID)	F2BH028449 (Item# 92)		Cutting location	Shroud
Received status	☑ As-Received ☐ Pre-Weld HT ☐ Post-Weld HT ☐ Other			

Analysis Result

Main composition,%										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	Al diffusion coating
Result	9.2	12.3	60.9	4.6	4.0	3.1	-	-	4.0	Nearest Alloy	GTD111

Microstructure

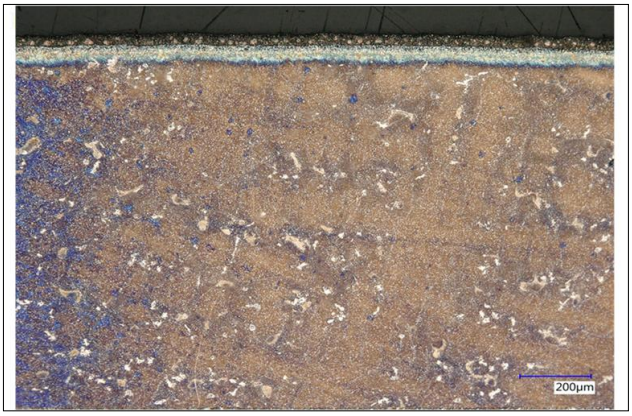


Fig.1 Showing the hot gas path coating and substrate condition.(Etched)

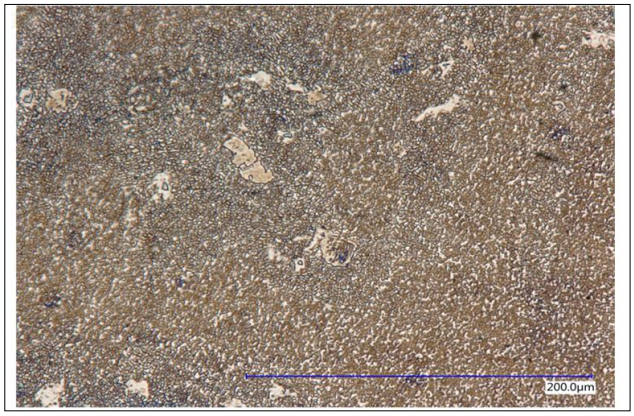


Fig.2 Showing the typical microstructure at higher magnification.(Etched)

The sample was mounted in L11074 to assess if the material would be acceptable for repair. The following was observed. Hot gas path was protected by Al diffusion coating, refer to Fig.1. Base material was confirmed as GTD111 alloy, comprising of fine grain boundary carbide and a gamma matrix with fine gamma prime, primary carbide and dispersed secondary carbide, Fig.2.

Recommendation

Based on the finding above, the base material was considered suitable for repair following coating removal by acid stripping.

8.0 PHOTOGRAPHS

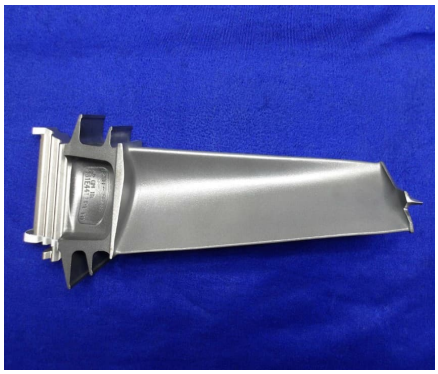


Figure 1. Final inspection.

Figure 2. Final inspection.

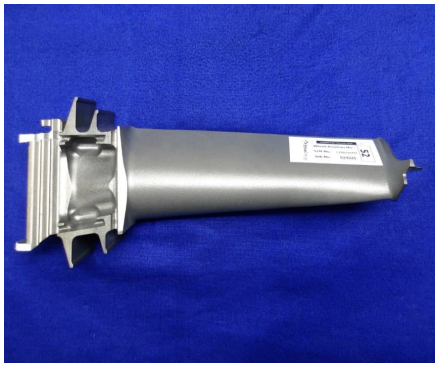


Figure 3. Final inspection.

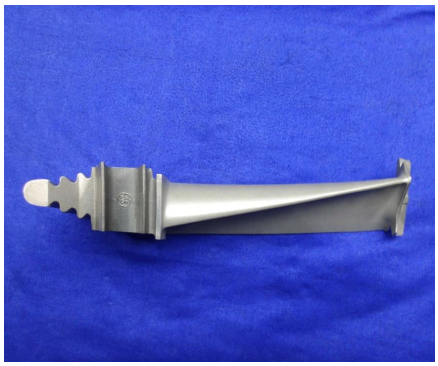


Figure 4. Final inspection.

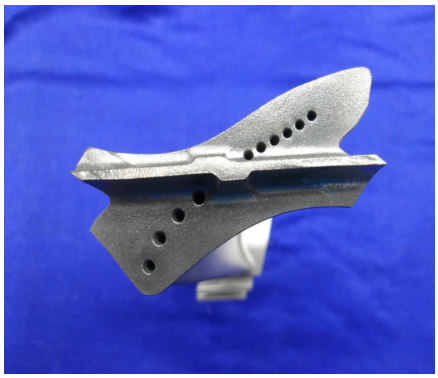


Figure 5. Final inspection.

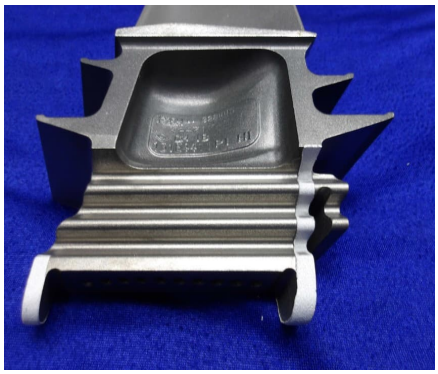
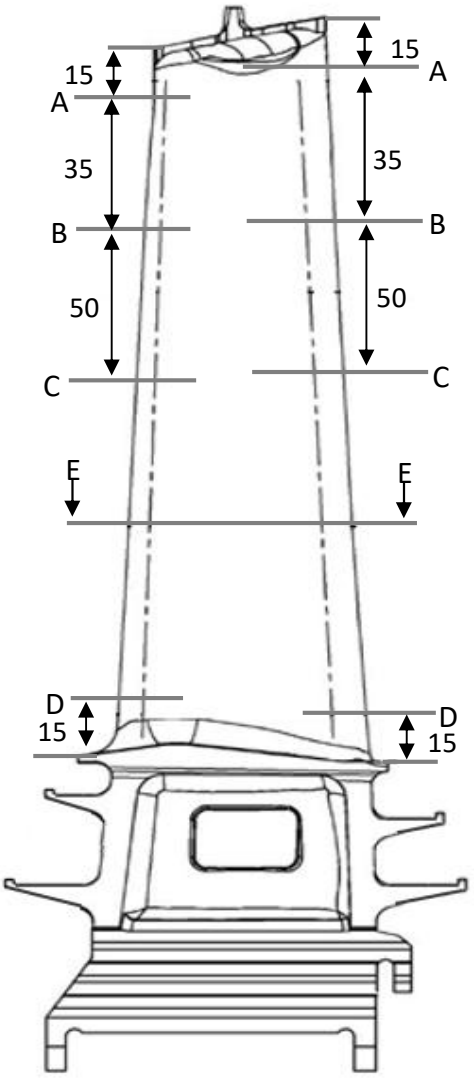
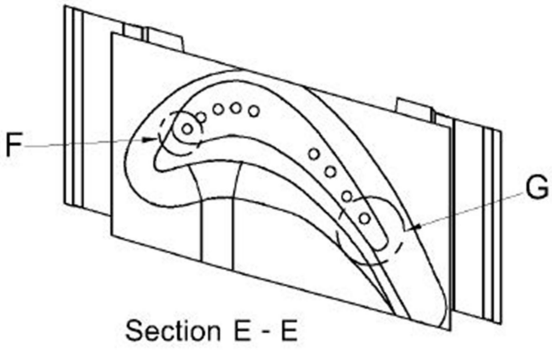


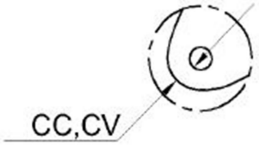
Figure 6. Final inspection.

9.0 THICKNESS RESULTS

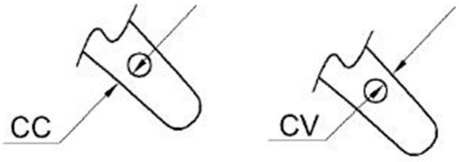




Section E - E



Detail F
Wall thickness leading edge



Detail G
Wall thickness trailing edge

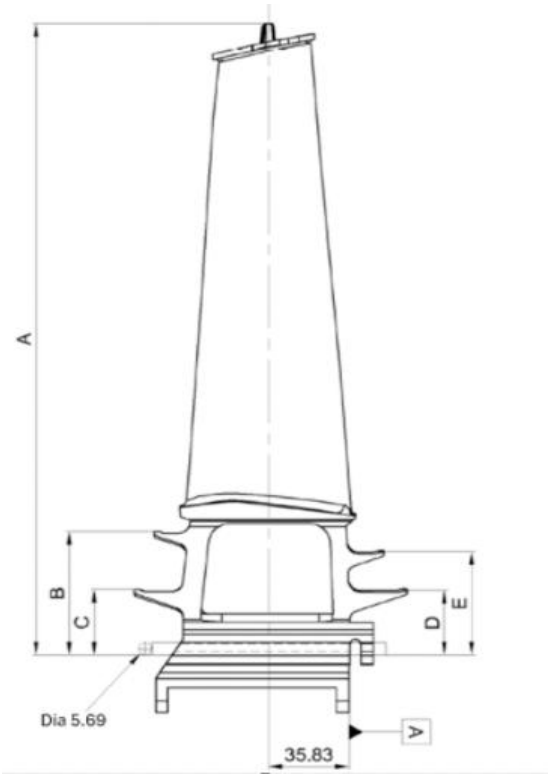
9.0 THICKNESS RESULTS (CONTINUE)

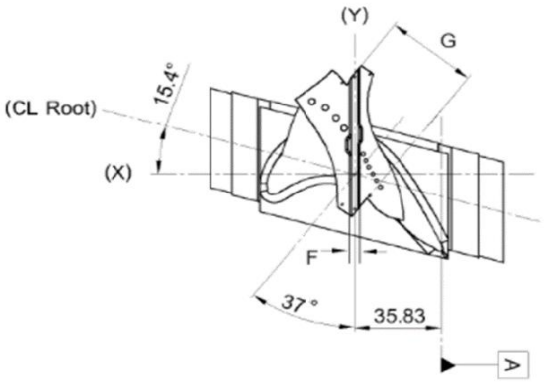
WALL THICKNESS CHECK SHEET													
ITEM	POSITION												RESULT
	LEADING EDGE				TRAILING EDGE								
	A	B	C	D	C/C A	C/C B	C/C C	CC/D	C/V A	C/V B	C/V C	C/V D	
1	1.37	1.39	1.69	2.81	1.34	1.30	1.51	2.12	1.09	0.98	0.90	2.43	ACC
2	1.08	1.35	1.77	2.19	0.87	1.06	0.90	1.26	1.30	0.95	1.19	2.81	ACC
3	1.05	1.20	1.51	2.22	1.10	0.98	1.04	1.50	0.86	0.87	0.88	2.46	ACC
4	1.03	1.31	1.45	2.89	1.03	0.95	0.92	1.52	1.17	1.00	1.16	2.62	ACC
5	1.17	1.23	1.76	2.27	1.04	0.93	1.09	1.50	1.11	0.98	0.92	2.63	ACC
6	1.51	1.35	2.08	2.41	1.07	0.96	1.20	1.36	1.33	1.13	1.15	2.45	ACC
7	1.03	1.49	1.84	2.34	0.85	0.97	0.84	1.31	1.25	1.05	1.29	2.70	ACC
8	1.21	1.11	1.70	2.23	1.21	1.14	1.24	1.95	0.82	0.71	0.89	2.13	ACC
9	1.15	1.44	1.60	2.71	1.27	1.22	1.05	1.83	1.20	1.07	1.33	2.47	ACC
10	1.05	1.28	1.41	2.94	0.93	1.00	1.01	1.86	1.17	0.96	1.05	2.65	ACC
11	1.24	1.32	1.91	2.18	0.92	0.97	0.82	1.23	1.32	1.07	1.29	2.85	ACC
12	1.33	1.53	2.05	2.59	1.43	1.51	1.53	2.05	1.13	0.73	0.95	2.12	ACC
13	1.22	1.39	1.62	1.78	0.83	1.08	1.29	1.88	1.27	1.01	0.95	2.21	ACC
14	1.27	1.22	1.60	2.47	1.26	1.13	1.31	1.90	0.89	0.82	0.71	2.24	ACC
15	1.20	1.17	1.55	2.20	1.15	1.19	1.28	1.97	0.93	0.83	0.76	2.19	ACC
16	1.13	1.29	1.55	2.65	0.88	1.10	0.96	1.25	1.32	1.00	1.10	2.87	ACC
17	1.26	1.17	1.93	2.52	1.30	1.25	1.43	1.97	1.08	1.05	1.02	2.31	ACC
18	1.21	1.40	1.61	2.87	0.78	1.01	0.87	1.37	1.10	1.02	1.27	2.71	ACC
19	1.30	1.07	1.72	1.91	1.12	0.99	1.00	1.62	1.01	0.91	1.00	2.57	ACC
20	1.35	1.28	1.89	2.45	1.36	1.16	1.25	1.85	1.08	1.01	0.99	2.31	ACC
21	1.38	1.34	1.81	2.67	1.15	1.10	1.21	1.77	1.22	1.06	1.15	2.68	ACC
22	1.08	1.45	1.82	2.43	0.96	0.96	0.86	2.45	1.22	1.16	1.46	2.89	ACC
23	1.36	1.22	1.83	2.60	1.28	1.09	1.17	1.89	1.00	1.01	1.04	2.40	ACC
24	1.37	1.35	1.46	2.97	1.20	1.10	1.26	1.88	1.13	1.02	0.95	2.31	ACC
25	1.28	1.40	1.76	2.56	1.08	1.25	1.14	1.65	1.24	0.93	1.22	2.79	ACC
26	1.22	1.20	1.81	2.28	1.14	1.37	1.36	1.82	1.11	0.80	0.94	2.14	ACC
27	1.12	1.36	1.66	2.56	1.11	0.95	0.74	1.54	1.14	1.03	1.47	2.93	ACC
28	1.26	1.12	1.64	2.59	1.11	0.91	0.96	1.56	0.97	1.01	1.08	2.46	ACC
29	1.29	1.40	1.59	2.59	1.19	1.08	1.20	1.89	1.06	0.97	0.98	2.43	ACC
30	1.27	1.26	1.61	2.97	1.28	1.19	1.32	2.05	0.98	0.86	0.86	2.30	ACC
31	1.18	1.54	1.91	2.43	0.91	1.03	0.84	1.27	1.37	1.18	1.44	3.00	ACC
32	1.28	1.53	1.75	2.76	0.84	1.21	1.20	1.56	1.41	1.08	1.15	2.81	ACC
33	1.16	1.35	1.65	2.47	1.24	0.99	1.10	1.35	1.12	1.08	1.09	2.65	ACC
34	1.13	1.28	1.67	2.43	1.33	1.06	1.10	1.80	1.15	1.07	1.12	2.63	ACC
35	1.23	1.25	1.80	2.38	1.31	1.20	1.29	1.96	0.97	0.96	0.97	2.40	ACC
36	1.07	1.36	1.58	2.86	1.01	1.19	1.09	1.63	1.41	1.14	1.25	2.79	ACC
37	1.14	1.34	1.61	2.73	1.38	1.12	1.13	1.74	1.03	1.08	1.13	2.61	ACC
38	1.08	1.49	1.79	2.10	0.94	1.09	0.92	1.43	1.41	1.12	1.36	2.90	ACC
39	1.29	1.19	1.75	2.37	1.29	1.15	1.25	2.06	1.10	1.00	0.94	2.47	ACC
40	1.19	1.40	1.85	2.45	1.35	1.57	1.49	2.16	1.14	0.83	1.03	2.42	ACC
41	1.09	1.48	1.74	2.83	1.12	1.29	1.26	1.97	1.24	0.97	1.15	2.56	ACC
42	1.05	1.37	1.59	2.49	0.88	1.03	0.95	1.49	1.33	1.10	1.26	2.69	ACC
43	1.21	1.31	2.02	2.45	1.31	1.04	1.03	1.57	1.08	1.19	1.35	2.93	ACC
44	1.16	1.59	1.82	2.76	1.08	1.30	1.31	2.06	1.52	1.15	1.38	2.67	ACC
45	1.17	1.55	1.88	2.46	0.89	0.97	1.00	1.58	1.48	1.13	1.41	2.77	ACC
46	1.36	1.31	1.68	2.64	0.96	1.41	1.48	1.98	1.09	0.75	0.73	2.14	ACC
47	1.29	1.42	1.96	2.53	1.17	1.26	0.86	1.05	1.25	1.19	1.61	3.40	ACC

9.0 THICKNESS RESULTS (CONTINUE)

WALL THICKNESS CHECK SHEET													
ITEM	POSITION												RESULT
	LEADING EDGE				TRAILING EDGE								
	A	B	C	D	C/C A	C/C B	C/C C	CC/D	C/V A	C/V B	C/V C	C/V D	
48	1.06	1.45	1.77	2.56	1.07	1.10	1.03	1.82	1.29	1.11	1.33	2.74	ACC
49	1.27	1.24	1.70	2.67	1.33	1.12	1.17	1.95	0.98	1.05	1.02	2.43	ACC
50	1.40	1.19	1.92	2.46	1.31	1.06	1.10	1.63	1.00	1.04	1.14	2.70	ACC
51	1.32	1.26	1.82	2.46	1.15	1.21	1.38	1.88	1.14	1.00	0.88	2.37	ACC
52	1.13	1.42	1.66	2.73	1.03	1.13	1.09	1.79	1.21	1.00	1.12	2.67	ACC
53	1.16	1.30	1.90	2.54	1.00	1.06	0.92	1.42	1.44	1.13	1.37	2.95	ACC
54	1.43	1.47	1.91	2.52	1.24	1.46	1.45	2.06	1.08	0.75	0.83	2.31	ACC
55	1.22	1.52	1.61	2.72	0.98	1.08	0.93	1.28	1.41	1.23	1.43	3.13	ACC
56	1.14	1.39	1.52	2.87	0.75	1.06	0.85	1.26	1.47	1.14	1.43	3.08	ACC
57	1.31	1.32	1.51	2.67	1.35	1.27	1.46	1.99	1.11	0.89	0.86	2.63	ACC
58	1.34	1.37	1.69	3.03	1.20	1.17	1.55	2.19	1.22	1.01	0.88	1.99	ACC
59	1.03	1.30	1.66	2.39	1.35	1.04	1.08	1.77	0.93	1.04	1.12	2.40	ACC
60	1.06	1.41	1.67	2.76	0.97	1.11	1.03	1.51	1.38	1.18	1.31	2.82	ACC
61	1.02	1.36	1.65	2.94	0.88	1.15	1.24	1.97	1.44	1.04	1.11	2.37	ACC
62	1.29	1.59	1.72	3.29	0.85	1.09	1.02	1.30	1.57	1.18	1.36	3.15	ACC
63	1.26	1.43	1.74	2.63	0.97	1.13	1.19	1.83	1.23	0.92	0.95	2.43	ACC
64	1.26	1.35	1.83	2.34	1.54	1.15	1.20	1.78	0.88	0.98	0.97	2.37	ACC
65	1.16	1.42	1.50	2.90	0.97	1.13	1.03	1.70	1.37	1.11	1.38	2.78	ACC
66	1.28	1.36	1.86	2.79	1.26	1.11	1.25	1.71	1.11	1.07	1.13	2.59	ACC
67	1.18	1.49	1.66	2.84	0.97	1.12	0.99	1.38	1.32	1.14	1.44	3.21	ACC
68	1.04	1.39	1.97	2.42	1.10	1.26	1.18	1.76	1.20	0.96	1.19	2.65	ACC
69	1.03	1.36	1.74	2.63	0.89	1.10	1.11	1.75	1.39	1.07	1.19	2.66	ACC
70	1.33	1.22	1.76	2.08	1.38	1.20	1.40	2.02	1.00	0.98	0.93	2.48	ACC
71	1.15	1.34	1.90	2.29	1.25	1.41	1.40	2.20	1.03	0.76	0.83	2.17	ACC
72	1.44	1.33	1.97	2.45	1.09	1.09	1.13	1.46	1.32	1.17	1.19	2.76	ACC
73	1.18	1.47	1.72	2.65	0.84	1.02	1.15	1.65	1.35	1.08	1.20	2.66	ACC
74	1.09	1.40	1.87	2.64	0.99	1.28	1.27	2.06	1.25	1.00	1.09	2.54	ACC
75	1.18	1.22	1.75	2.04	1.31	1.17	1.20	1.91	1.03	0.95	0.91	2.34	ACC
76	1.29	1.34	1.55	2.89	0.99	1.32	1.34	2.23	1.21	1.01	0.98	2.41	ACC
77	1.12	1.41	1.52	2.86	0.88	1.12	1.14	1.41	1.46	1.08	1.25	2.55	ACC
78	1.38	1.26	1.73	2.53	1.23	1.05	1.20	1.70	1.17	1.10	1.12	2.70	ACC
79	1.17	1.40	2.01	2.30	0.99	1.04	0.87	1.32	1.27	1.12	1.31	3.06	ACC
80	1.01	1.19	1.75	2.81	0.82	1.22	1.32	2.01	1.07	1.02	1.13	2.74	ACC
81	1.24	1.47	1.80	2.73	1.02	1.19	1.13	1.82	1.36	1.12	1.20	2.65	ACC
82	1.35	1.39	1.62	2.74	1.16	1.06	1.17	1.80	1.22	1.16	1.10	2.79	ACC
83	1.24	1.48	1.72	2.51	1.42	1.50	1.33	1.95	0.87	0.71	0.95	1.87	ACC
84	1.33	1.27	1.55	2.45	1.17	0.93	1.04	1.48	1.20	1.04	1.06	2.95	ACC
85	1.11	1.45	1.93	2.37	0.85	1.05	1.02	1.49	1.41	1.11	1.27	2.89	ACC
86	1.26	1.17	1.73	2.65	1.24	1.06	1.18	1.97	0.92	0.95	0.97	2.47	ACC
87	1.05	1.59	1.84	2.68	0.90	1.20	1.17	1.81	1.34	1.02	1.17	2.41	ACC
88	1.34	1.19	1.88	2.26	1.16	1.13	1.33	1.69	1.13	0.96	0.92	2.46	ACC
89	1.05	1.41	1.55	3.14	0.88	1.33	1.44	2.06	1.40	0.90	0.91	2.40	ACC
90	1.31	1.36	1.62	2.89	1.38	1.10	1.18	1.86	1.08	1.08	1.05	2.56	ACC
91	1.05	1.35	1.62	2.25	0.90	1.07	0.98	1.97	1.26	1.04	1.09	2.61	ACC
92	1.16	1.38	1.48	1.87	1.06	1.14	1.13	1.80	1.33	1.18	1.32	2.76	ACC

10.0 GENERAL DIMENSION





10.0 GENERAL DIMENSION (CONTINUE)

GENERAL DIMENSION DATA TABLE								
DIMENSIONS (Unit : mm.)								
ITEM	A	B	C	D	E	F	G	RESULT
1	286.57	56.05	29.66	30.85	47.88	2.94	36.55	ACC
2	286.52	56.12	29.69	30.71	47.88	2.36	36.50	ACC
3	286.58	56.10	29.67	30.83	47.81	2.82	36.61	ACC
4	286.51	56.07	29.64	30.93	47.90	2.37	36.64	ACC
5	286.59	56.06	29.62	31.14	47.84	2.86	36.57	ACC
6	286.57	56.08	29.68	30.82	47.78	2.74	36.61	ACC
7	286.52	56.18	29.75	30.82	47.99	2.31	36.59	ACC
8	286.52	56.10	29.67	30.96	47.86	2.34	36.64	ACC
9	286.48	56.15	29.71	30.95	47.91	2.33	36.47	ACC
10	286.45	56.17	29.70	30.84	47.95	2.24	36.55	ACC
11	286.47	56.11	29.70	30.79	47.88	2.34	36.48	ACC
12	286.48	56.14	29.68	30.92	47.93	2.36	36.51	ACC
13	286.49	56.17	29.69	30.87	47.92	2.36	36.58	ACC
14	286.54	56.22	29.82	31.04	47.98	2.81	36.52	ACC
15	286.51	56.08	29.65	30.88	47.85	2.76	36.56	ACC
16	286.47	56.16	29.77	30.97	47.95	2.26	36.62	ACC
17	286.54	56.19	29.77	30.93	47.92	2.86	36.56	ACC
18	286.47	56.14	29.67	30.92	47.92	2.33	36.44	ACC
19	286.56	56.13	29.72	30.99	47.91	2.74	36.64	ACC
20	286.54	56.09	29.68	30.76	47.82	2.92	36.52	ACC
21	286.51	56.10	29.72	30.77	47.90	2.85	36.50	ACC
22	286.52	56.11	29.72	30.80	47.86	2.26	36.58	ACC
23	286.54	56.15	29.72	30.91	47.89	2.83	36.52	ACC
24	286.51	56.15	29.72	30.67	47.92	2.83	36.63	ACC
25	286.52	56.13	29.68	30.72	47.95	2.34	36.56	ACC
26	286.50	56.14	29.70	30.69	47.98	2.34	36.48	ACC
27	286.49	56.15	29.69	30.77	47.88	2.30	36.50	ACC
28	286.55	56.11	29.70	30.71	47.82	2.82	36.67	ACC
29	286.58	56.14	29.72	30.69	47.85	2.92	36.51	ACC
30	286.51	56.11	29.68	30.83	47.88	2.81	36.63	ACC
31	286.50	56.15	29.73	30.72	47.91	2.33	36.58	ACC
32	286.49	56.13	29.75	30.65	47.92	2.34	36.60	ACC
33	286.56	56.19	29.75	30.76	47.89	2.91	36.47	ACC
34	286.52	56.05	29.66	30.89	47.82	2.74	36.65	ACC
35	286.58	56.06	29.64	30.65	47.79	2.86	36.58	ACC
36	286.53	56.10	29.68	30.66	47.87	2.30	36.59	ACC
37	286.57	56.14	29.75	31.21	47.85	2.88	36.56	ACC
38	286.49	56.15	29.67	30.79	47.93	2.38	36.57	ACC
39	286.46	56.12	29.71	30.75	47.89	2.84	36.50	ACC
40	286.46	56.10	29.68	31.06	47.87	2.35	36.55	ACC
41	286.42	56.10	29.63	30.59	47.89	2.30	36.53	ACC
42	286.51	56.14	29.68	30.96	47.92	2.34	36.66	ACC
43	286.50	56.11	29.68	30.99	47.83	2.79	36.55	ACC
44	286.52	56.19	29.79	30.83	47.91	2.35	36.57	ACC
45	286.47	56.18	29.71	30.84	47.96	2.29	36.57	ACC
46	286.51	56.16	29.68	30.61	47.91	2.34	36.57	ACC
47	286.44	56.18	29.73	30.80	47.94	2.38	36.53	ACC

10.0 GENERAL DIMENSION (CONTINUE)

GENERAL DIMENSION DATA TABLE								
DIMENSIONS (Unit : mm.)								
ITEM	A	B	C	D	E	F	G	RESULT
48	286.54	56.25	29.80	30.79	47.90	2.30	36.50	ACC
49	286.56	56.03	29.61	30.74	47.73	2.92	36.53	ACC
50	286.56	56.44	29.71	30.92	47.84	2.70	36.55	ACC
51	286.61	56.36	29.77	30.93	47.78	2.86	36.44	ACC
52	286.46	56.11	29.69	30.89	47.95	2.30	36.55	ACC
53	286.48	56.18	29.78	30.82	47.99	2.35	36.62	ACC
54	286.43	56.19	29.70	30.82	47.95	2.35	36.60	ACC
55	286.42	56.11	29.65	30.73	47.93	2.34	36.51	ACC
56	286.41	56.09	29.69	30.69	47.84	2.30	36.59	ACC
57	286.56	56.12	29.70	30.95	47.87	2.79	36.57	ACC
58	286.55	56.15	29.73	30.80	47.94	2.81	36.47	ACC
59	286.59	56.09	29.68	30.87	47.83	2.82	36.53	ACC
60	286.51	56.11	29.67	30.82	47.94	2.34	36.50	ACC
61	286.51	56.21	29.72	30.76	47.91	2.20	36.55	ACC
62	286.52	56.16	29.66	31.02	47.93	2.41	36.53	ACC
63	286.51	56.05	29.64	30.52	47.80	2.41	36.62	ACC
64	286.55	56.11	29.68	30.82	47.94	2.35	36.46	ACC
65	286.39	56.23	29.78	30.87	47.92	2.25	36.50	ACC
66	286.51	56.16	29.77	30.82	47.97	2.78	36.55	ACC
67	286.40	56.09	29.69	30.94	47.89	2.37	36.57	ACC
68	286.48	56.13	29.66	30.83	47.86	2.27	36.54	ACC
69	286.51	56.14	29.70	30.95	47.94	2.22	36.60	ACC
70	286.63	56.18	29.80	30.67	47.86	2.85	36.57	ACC
71	286.51	56.16	29.74	30.79	48.00	2.33	36.64	ACC
72	286.55	56.21	29.76	31.09	47.96	2.77	36.58	ACC
73	286.50	56.09	29.69	30.92	47.91	2.30	36.62	ACC
74	286.44	56.16	29.73	30.75	47.96	2.32	36.59	ACC
75	286.59	56.15	29.73	30.86	47.83	2.84	36.50	ACC
76	286.50	56.11	29.64	30.78	47.95	2.34	36.50	ACC
77	286.51	56.19	29.73	30.90	47.94	2.34	36.59	ACC
78	286.55	56.11	29.70	31.04	47.87	2.83	36.58	ACC
79	286.52	56.12	29.73	30.75	47.90	2.39	36.62	ACC
80	286.47	56.16	29.66	30.75	47.94	2.29	36.58	ACC
81	286.49	56.11	29.70	30.74	47.85	2.32	36.57	ACC
82	286.51	56.10	29.69	30.81	47.86	2.71	36.60	ACC
83	286.49	56.12	29.65	30.84	47.92	2.24	36.44	ACC
84	286.54	56.16	29.74	30.86	47.90	2.82	36.56	ACC
85	286.49	56.08	29.69	30.79	47.87	2.31	36.62	ACC
86	286.55	56.12	29.72	30.94	47.92	2.87	36.56	ACC
87	286.52	56.22	29.77	30.88	47.98	2.38	36.57	ACC
88	286.54	56.07	29.67	30.93	47.82	2.82	36.57	ACC
89	286.57	56.09	29.76	30.74	47.88	2.34	36.50	ACC
90	286.51	56.10	29.72	30.81	47.83	2.86	36.51	ACC
91	286.52	56.13	29.77	30.88	47.96	2.29	36.58	ACC
92	286.51	56.21	29.70	30.80	47.93	2.29	36.57	ACC

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	131E4439 P006	F2BN006309	GTD 111	47	131E4439 P005	F2BH028431	GTD 111
2	131E4439 P005	F2BH028490	GTD 111	48	131E4439 P005	F2BH028498	GTD 111
3	131E4439 P005	F2BN006376	GTD 111	49	131E4439 P005	F2BN005886	GTD 111
4	131E4439 P005	F2BH028456	GTD 111	50	131E4439 P005	F2BN004618	GTD 111
5	131E4439 P005	F2BN006369	GTD 111	51	131E4439 P005	F2BN006372	GTD 111
6	131E4439 P005	F2BN006373	GTD 111	52	131E4439 P005	F2BH028445	GTD 111
7	131E4439 P005	F2BH028496	GTD 111	53	131E4439 P005	F2BH028508	GTD 111
8	131E4439 P005	F2BH028506	GTD 111	54	131E4439 P005	F2BH028450	GTD 111
9	131E4439 P005	F2BH028452	GTD 111	55	131E4439 P005	F2BH028499	GTD 111
10	131E4439 P005	F2BH028487	GTD 111	56	131E4439 P005	F2BH028421	GTD 111
11	131E4439 P005	F2BH028418	GTD 111	57	131E4439 P005	F2BN004529	GTD 111
12	131E4439 P005	F2BH028422	GTD 111	58	131E4439 P005	F2BN004831	GTD 111
13	131E4439 P005	F2BH028442	GTD 111	59	131E4439 P005	F2BN006320	GTD 111
14	131E4439 P005	F2BN004458	GTD 111	60	131E4439 P005	F2BH028488	GTD 111
15	131E4439 P005	F2BN004826	GTD 111	61	131E4439 P005	F2BH028464	GTD 111
16	131E4439 P005	F2BH028482	GTD 111	62	131E4439 P005	F2BH028454	GTD 111
17	131E4439 P005	F2BN004459	GTD 111	63	131E4439 P005	F2BH028417	GTD 111
18	131E4439 P005	F2BH028419	GTD 111	64	131E4439 P005	F2BN005740	GTD 111
19	131E4439 P005	F2BN004533	GTD 111	65	131E4439 P005	F2BH028462	GTD 111
20	131E4439 P005	F2BN005741	GTD 111	66	131E4439 P005	F2BN004535	GTD 111
21	131E4439 P005	F2BN004828	GTD 111	67	131E4439 P005	F2BH028486	GTD 111
22	131E4439 P005	F2BH028511	GTD 111	68	131E4439 P005	F2BH028495	GTD 111
23	131E4439 P005	F2BN004536	GTD 111	69	131E4439 P005	F2BH028497	GTD 111
24	131E4439 P005	F2BN004463	GTD 111	70	131E4439 P005	F2BN005743	GTD 111
25	131E4439 P005	F2BH028429	GTD 111	71	131E4439 P005	F2BH028475	GTD 111
26	131E4439 P005	F2BH028416	GTD 111	72	131E4439 P005	F2BN004534	GTD 111
27	131E4439 P005	F2BH028468	GTD 111	73	131E4439 P005	F2BH028510	GTD 111
28	131E4439 P005	F2BN004460	GTD 111	74	131E4439 P005	F2BH028476	GTD 111
29	131E4439 P005	F2BN005885	GTD 111	75	131E4439 P005	F2BN006374	GTD 111
30	131E4439 P005	F2BN004464	GTD 111	76	131E4439 P005	F2BH028461	GTD 111
31	131E4439 P005	F2BH028453	GTD 111	77	131E4439 P005	F2BH028493	GTD 111
32	131E4439 P005	F2BH028477	GTD 111	78	131E4439 P005	F2BN004621	GTD 111
33	131E4439 P005	F2BN006311	GTD 111	79	131E4439 P005	F2BH028447	GTD 111
34	131E4439 P005	F2BN004231	GTD 111	80	131E4439 P005	F2BH028425	GTD 111
35	131E4439 P005	F2BN006312	GTD 111	81	131E4439 P005	F2BH028480	GTD 111
36	131E4439 P005	F2BH028448	GTD 111	82	131E4439 P005	F2BN004830	GTD 111
37	131E4439 P005	F2BN005744	GTD 111	83	131E4439 P005	F2BH028407	GTD 111
38	131E4439 P005	F2BH028489	GTD 111	84	131E4439 P005	F2BN004617	GTD 111
39	131E4439 P005	F2BN004829	GTD 111	85	131E4439 P005	F2BH028502	GTD 111
40	131E4439 P005	F2BH028427	GTD 111	86	131E4439 P005	F2BN004461	GTD 111
41	131E4439 P005	F2BH028485	GTD 111	87	131E4439 P005	F2BH028491	GTD 111
42	131E4439 P005	F2BH028458	GTD 111	88	131E4439 P005	F2BN006310	GTD 111
43	131E4439 P005	F2BN004531	GTD 111	89	131E4439 P005	F2BH028507	GTD 111
44	131E4439 P005	F2BH028503	GTD 111	90	131E4439 P005	F2BN005739	GTD 111
45	131E4439 P005	F2BH028420	GTD 111	91	131E4439 P005	F2BH028446	GTD 111
46	131E4439 P005	F2BH028460	GTD 111	92	131E4439 P005	F2BH028449	GTD 111

12.0 DEFECT LEGEND TABLE

DEFECT LEGEND TABLE RECORD SHEET

Information		INSPECTION FINDINGS																																						
Blade Number	Serial Number	Seal fin wear	Seal fin cracks	Seal fin erosion / corrosion	Seal fin FOD / missing material	Cutter teeth wear	Shroud wear	Shroud cracks	Shroud erosion / corrosion	Shroud FOD / missing material	Z-notch wear	Z-notch cracks	Z-notch erosion / corrosion	Z-notch FOD / missing material	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 pitting		Platform cracks	Platform corrosion	Platform FOD/missing material	Shank cracks	Shank FOD / missing material	Shank deform	Pin slot cracks	Pin slot deform	Root wear	Root cracks	Cooling hole check
																			Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.												
1		B	WB			WB					B							WB																				ACC	
2		B				WB					B							WB																				ACC	
3		B				WB		WB			B							WB																				ACC	
4		B				WB		WB			B							WB																				ACC	
5		B				WB					B							WB																				ACC	
6		B				WB					B							WB																				ACC	
7		B				WB					B							WB																				ACC	
8		B				WB					B							WB																				ACC	
9		B				WB					B	WB						WB																				ACC	
10		B	WB			WB		WB			B							WB																				ACC	
11		B				WB		WB			B							WB																				ACC	
12		B				WB					B						WB	WB																				ACC	
13		B				WB		WB			B							WB																				ACC	
14		B				WB					B							WB																				ACC	
15		B				WB					B							WB																				ACC	
16		B				WB					B							WB																				ACC	
17		B				WB					B							WB																				ACC	
18		B				WB		WB			B							WB																				ACC	
19		B				WB		WB			B							WB																				ACC	
20		B				WB					B							WB																				ACC	
21		B				WB					B							WB																				ACC	
22		B				WB					B							WB																				ACC	
23		B				WB					B							WB																				ACC	
24		B				WB					B							WB																				ACC	
25		B				WB					B							WB																				ACC	
26		B				WB					B							WB																				ACC	
27		B				WB					B							WB																				ACC	
28		B				WB		WB			B							WB																				ACC	
29		B				WB					B							WB																				ACC	
30		B				WB		WB			B							WB																	WB			ACC	
31		B				WB					B							WB																				ACC	
32		B				WB					B							WB																				ACC	
33		B	WB			WB		WB			B	WB						WB																				ACC	
34		B				WB					B							WB																				ACC	
35		B				WB					B							WB																				ACC	
36		B				WB					B							WB																				ACC	
37		B				WB					B							WB																				ACC	
38		B				WB		WB			B							WB																				ACC	
39		B				WB		WB			B							WB																				ACC	
40		B				WB					B							WB																				ACC	
41		B				WB					B							WB																				ACC	
42		B				WB		WB			B							WB																				ACC	
43		B	WB			WB					B							WB																				ACC	
44		B				WB		WB			B							WB																				ACC	
45		B				WB					B							WB																				ACC	
46		B				WB		WB			B							WB																				ACC	
47		B				WB					B							WB																				ACC	
48		B	WB			WB					B							WB																				ACC	
49		B				WB					B							WB																				ACC	
50		B				WB		WB			B						WB	WB																				ACC	

12.0 DEFECT LEGEND TABLE (CONTINUE)

DEFECT LEGEND TABLE RECORD SHEET

Information		INSPECTION FINDINGS																																						
Blade Number	Serial Number	Seal fin wear	Seal fin cracks	Seal fin erosion / corrosion	Seal fin FOD / missing material	Cutter teeth wear	Shroud wear	Shroud cracks	Shroud erosion / corrosion	Shroud FOD / missing material	Z-notch wear	Z-notch cracks	Z-notch erosion / corrosion	Z-notch FOD / missing material	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 pitting		Platform cracks	Platform corrosion	Platform FOD/missing material	Shank cracks	Shank FOD / missing material	Shank deform	Pin slot cracks	Pin slot deform	Root wear	Root cracks	Cooling hole check
																			Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.	Loc.	Rep.												
51		B				WB					B							WB																					ACC
52		B				WB					B							WB																					ACC
53		B				WB		WB			B							WB																					ACC
54		B				WB					B							WB																					ACC
55		B				WB		WB			B							WB																					ACC
56		B				WB					B							WB																					ACC
57		B				WB					B							WB																					ACC
58		B				WB					B							WB																					ACC
59		B				WB					B						WB	WB																					ACC
60		B				WB					B							WB																					ACC
61		B				WB					B							WB																					ACC
62		B				WB					B							WB																					ACC
63		B				WB					B							WB																					ACC
64		B				WB					B							WB																					ACC
65		B				WB					B							WB																					ACC
66		B				WB					B							WB																					ACC
67		B				WB					B							WB																					ACC
68		B				WB		WB			B							WB																					ACC
69		B				WB					B							WB																					ACC
70		B				WB					B							WB																					ACC
71		B				WB					B							WB																					ACC
72		B				WB					B							WB																					ACC
73		B				WB					B							WB																					ACC
74		B				WB					B							WB																					ACC
75		B				WB		WB			B							WB																					ACC
76		B				WB					B							WB																					ACC
77		B				WB					B							WB																					ACC
78		B				WB					B							WB																					ACC
79		B				WB		WB			B							WB																					ACC
80		B				WB					B							WB																					ACC
81		B				WB					B							WB																					ACC
82		B				WB					B							WB																					ACC
83		B				WB					B							WB																					ACC
84		B				WB		WB			B						WB	WB																WB					ACC
85		B				WB					B							WB																					ACC
86		B				WB					B							WB																					ACC
87		B				WB					B							WB																					ACC
88		B				WB		WB			B							WB																					ACC
89		B				WB		WB			B							WB																					ACC
90		B				WB					B							WB																					ACC
91		B	WB			WB		WB			B							WB																					ACC
92		B				WB					B							WB																					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.
ACC = Acceptable as is.
REJ = Dimension unacceptable and will require repair or cause of scrap
DT = Performed destructive testing.
REP = Replacement component. (For final Inspection Report)
Loc.= Concave side CC, convex side CV, Leading edge LE, Trailing edge TE
S = Non-Repairable / Scrap.
L = Light repair category
M = Medium repair category
H = Heavy repair category
EX = Salvation repair category

13.0 DEFECT MAP

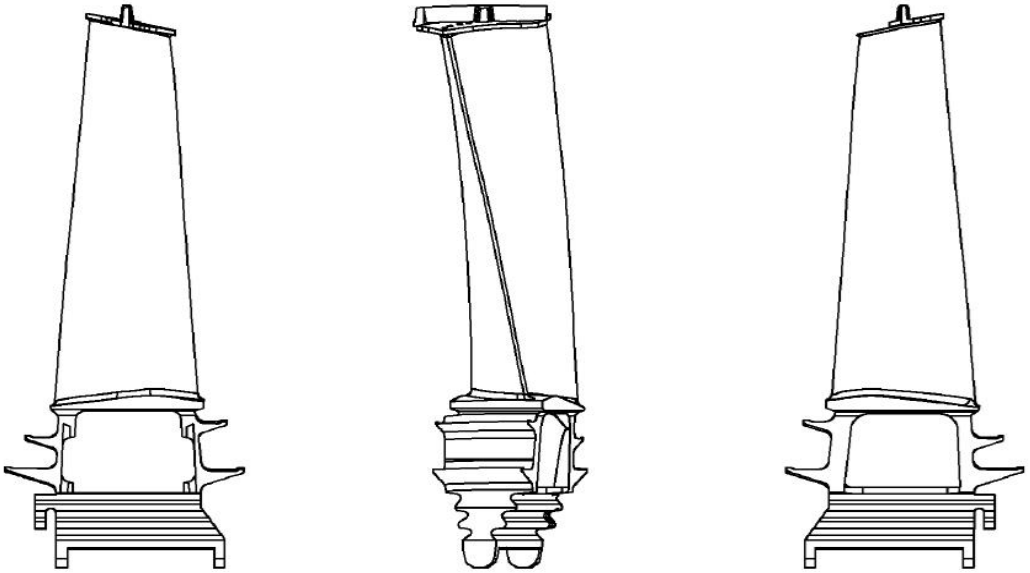
INSPECTION AND PROCESS RECORD SHEET	MS6001FA 2nd STAGE BUCKET	IPRS NO.	3066-40
	PART NUMBER : GEBL02M6FA	REV.	00

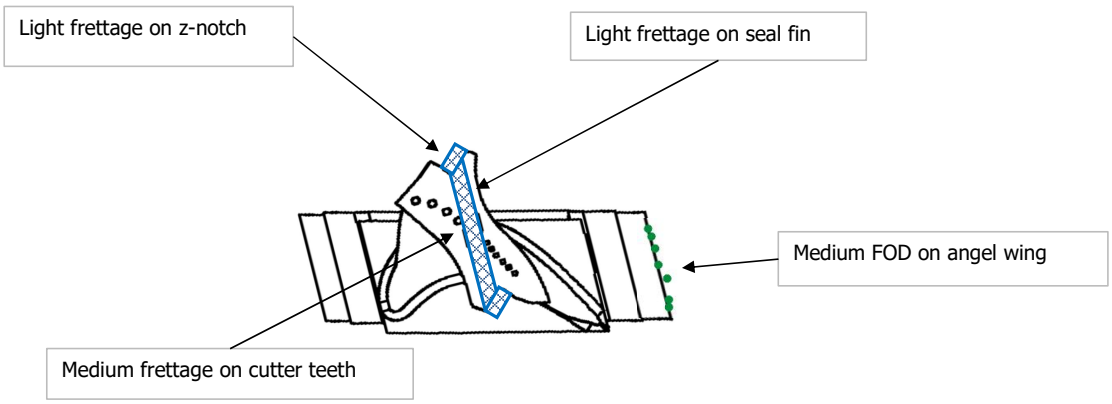
CUSTOMER :	Nghi Son Refinery &	CUSTOMER PO :	PO04102025-HGP
JOB NUMBER :	824026	OP.	230
INSPECTED BY :	Anirut D.	DATE :	09/08/2025

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

TYPICAL DEFECT

(Incoming condition)





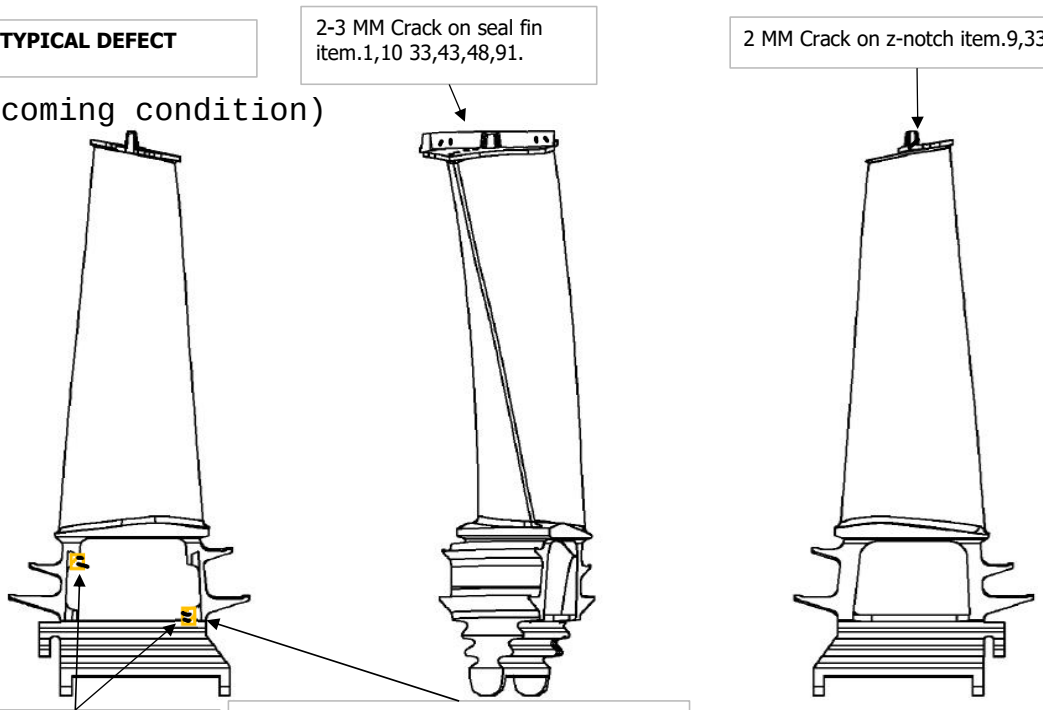
13.0 DEFECT MAP (CONTINUE)

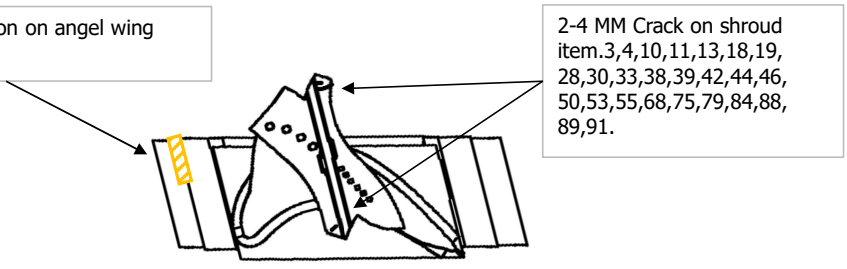
INSPECTION AND PROCESS RECORD SHEET	**MS6001FA 2nd STAGE BUCKET**	**IPRS NO.**	**3066-40**
	PART NUMBER : GEBL02M6FA	**REV.**	**00**
CUSTOMER :	**Nghi Son Refinery &**	**CUSTOMER PO :**	**PO04102025-HGP**
JOB NUMBER :	**824026**	**OP.**	**230**
INSPECTED BY :	**Anirut D.**	**DATE :**	**09/08/2025**

(mm) Crack (mm) Foreign Object Damage (L/M/H) Frettage (L/M/H) Deformation area(mm^2) Corrosion (L/M/H) Missing Material (mm^2)

NON TYPICAL DEFECT

(Incoming condition)





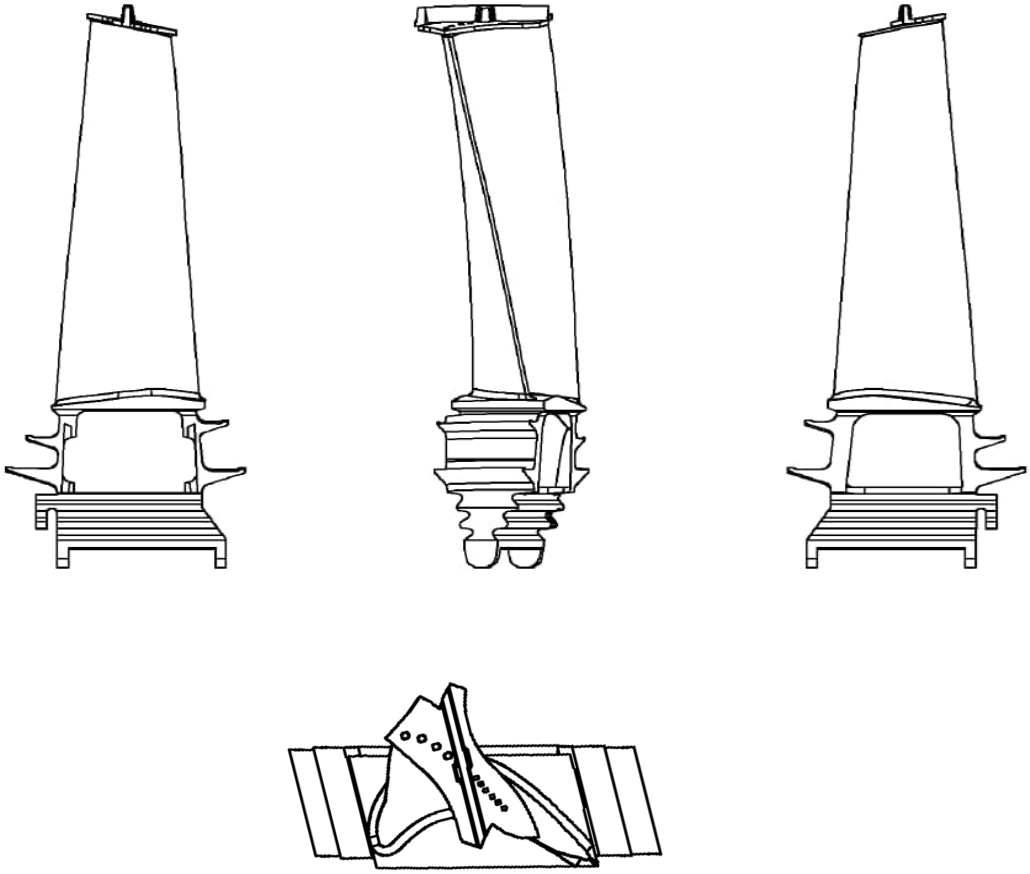
FINAL INSPECTION REPORT

13.0 DEFECT MAP (CONTINUE)

EthosEnergy			
INSPECTION AND PROCESS RECORD SHEET	MS6001FA 2nd STAGE BUCKET	IPRS NO.	3066-40
	PART NUMBER : GEBL02M6FA	REV.	00

CUSTOMER :	Nghi Son Refinery &	CUSTOMER PO :	PO04102025-HGP
JOB NUMBER :	824026	OP.	FINAL
INSPECTED BY :	ANUCHID K.	DATE :	27/09/2025

(mm) Crack (mm) Foreign Object Damage (L/M/H) Frettage (L/M/H) Deformation area(mm^2) Corrosion (L/M/H) Missing Material (mm^2)



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14.0 MOMENT WEIGHT

SCHENCK Balancing and Diagnostic Systems	EthosEnergy (Thailand) Limited 39/9 Sermsuwan Road, Tambon Maptaphut Amphur Muang, Rayong 21150, Thailand Tel: +66 (38) 698900	EthosEnergy
Operator: BucketTH	**BladisNET** Revision 3.0 © 2006 | Schenck RoTec GmbH | Germany	27/09/2025 Page 1

Blade Type: GEBL02M6FA

Engine type:	MS6001FA
Stage:	2
No. of blades:	92
No. of locking blades:	1
Positions of locking blades:	1
Moment of master blade or preload moment:	1587000 gmm
Admissible variation for measurement:	3 digits
Type of matching:	None
Tolerance:	1000 gmm
Predistribution Pattern:	7 - Sequence of Weighing

Blade Set: 824026

Generated by:	Anuchid Klahan
Order:	Nghi Son Refinery
\	
New reduced tolerance:	10 gmm
Matching type:	None
Predistribution Pattern:	7 - Sequence of Weighing
Calculated unbalance:	10 gmm
Calculated Angle:	267 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!

Operator: BucketTH	BladisNET Revision 3.0 © 2006 | Schenck RoTec GmbH | Germany	27/09/2025 Page 2

Blade Type: **GEBL02M6FA**

Blade Set: **824026**

Blade Distribution

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

Pos No.	Moment [gmm]	Serial No.
1	1576200	F2BN006309
2	1585400	F2BH028490
3	1566600	F2BN006376
4	1587400	F2BH028456
5	1572000	F2BN006369
6	1570600	F2BN006373
7	1588600	F2BH028496
8	1577600	F2BH028506
9	1580200	F2BH028452
10	1577200	F2BH028487
11	1575600	F2BH028418
12	1575400	F2BH028422
13	1588000	F2BH028442
14	1572400	F2BN004458
15	1572200	F2BN004826
16	1584600	F2BH028482
17	1570400	F2BN004459
18	1591000	F2BH028476
19	1573000	F2BN004533
20	1580800	F2BN005741
21	1576200	F2BN004828
22	1576200	F2BH028511
23	1574000	F2BN004536
24	1570800	F2BN004463
25	1587000	F2BH028429
26	1573000	F2BH028416

Operator: BucketTH	BladisNET Revision 3.0 © 2006 | Schenck RoTec GmbH | Germany	27/09/2025 Page 3

Blade Type: **GEBL02M6FA**

Blade Set: **824026**

Blade Distribution

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

Pos No.	Moment [gmm]	Serial No.
27	1581000	F2BH028468
28	1571600	F2BN004460
29	1568600	F2BN005885
30	1571800	F2BN004464
31	1585800	F2BH028453
32	1578400	F2BH028477
33	1579200	F2BN004535
34	1576200	F2BN004231
35	1575000	F2BN006312
36	1578600	F2BH028448
37	1580400	F2BN005744
38	1585800	F2BH028489
39	1574800	F2BN004829
40	1581200	F2BH028427
41	1580000	F2BH028485
42	1590000	F2BH028458
43	1576600	F2BN004531
44	1586600	F2BH028503
45	1563600	F2BH028420
46	1587000	F2BH028460
47	1577000	F2BN005743
48	1575000	F2BH028498
49	1570800	F2BN005886
50	1568400	F2BN004618
51	1570800	F2BN006372
52	1574800	F2BH028445

Operator: BucketTH QC 26	**BladisNET** Revision 3.0 © 2006 | Schenck RoTec GmbH | Germany	27/09/2025 Page 4

Blade Type: **GEBL02M6FA**

Blade Set: **824026**

Blade Distribution

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

Pos No.	Moment [gmm]	Serial No.
53	1583800	F2BH028508
54	1582800	F2BH028450
55	1589600	F2BH028499
56	1563200	F2BH028421
57	1571800	F2BN004529
58	1575600	F2BN004831
59	1570400	F2BN006320
60	1586200	F2BH028488
61	1585800	F2BH028464
62	1585200	F2BH028454
63	1578600	F2BH028417
64	1575600	F2BN005740
65	1580600	F2BH028462
66	1573200	F2BN006311
67	1578600	F2BH028486
68	1587600	F2BH028495
69	1586400	F2BH028497
70	1576800	F2BH028431
71	1578200	F2BH028475
72	1576400	F2BN004534
73	1577400	F2BH028510
74	1564200	F2BH028419
75	1567000	F2BN006374
76	1587800	F2BH028461
77	1586000	F2BH028493
78	1571400	F2BN004621

Operator: BucketTH QC 26	**BladisNET** Revision 3.0 © 2006 | Schenck RoTec GmbH | Germany	27/09/2025 Page 5

Blade Type: **GEBL02M6FA**

Blade Set: **824026**

Blade D stribution

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

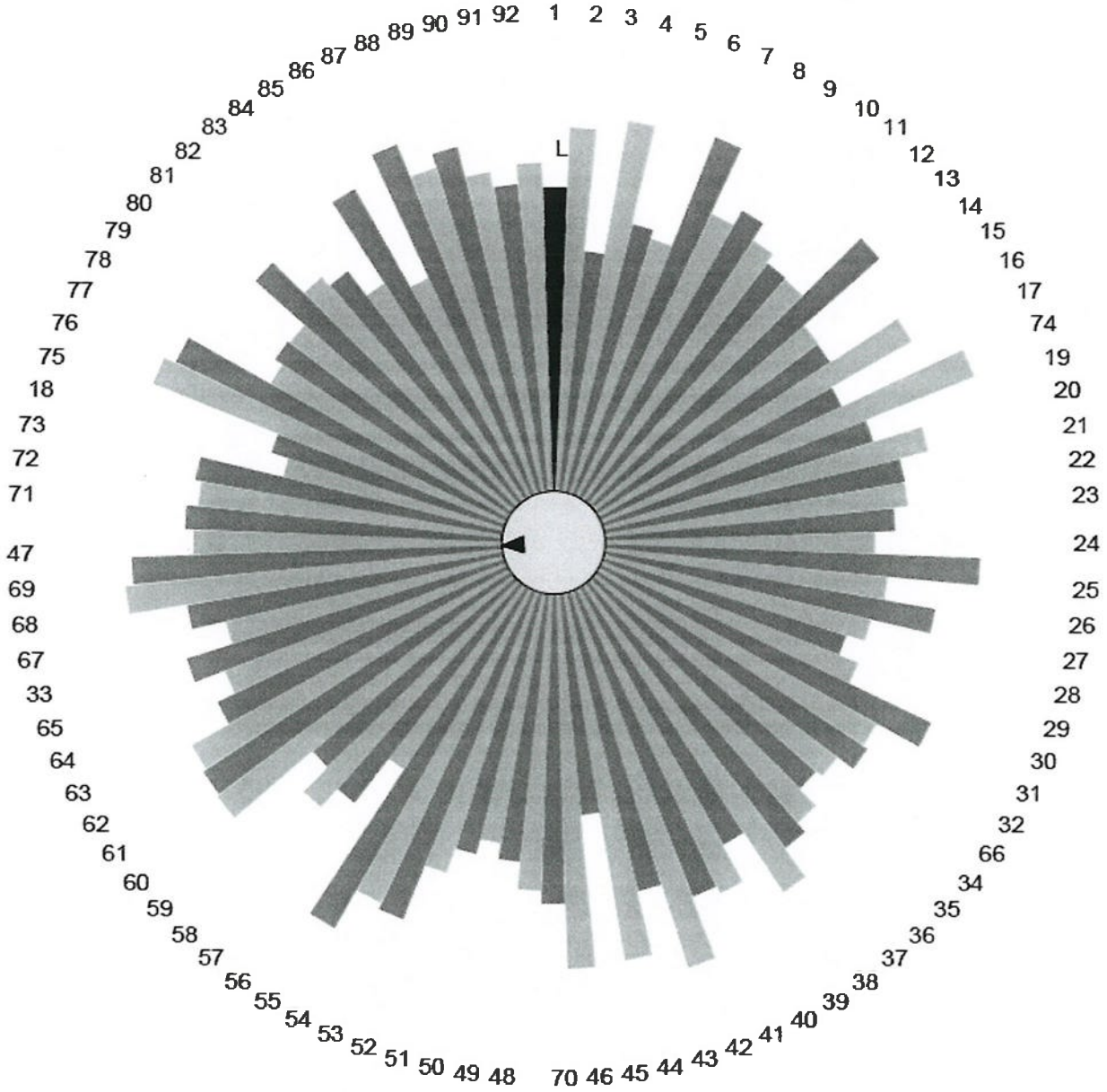
Pos No.	Moment [gmm]	Serial No.
79	1572800	F2BH028447
80	1572400	F2BH028425
81	1582600	F2BH028480
82	1575800	F2BN004830
83	1574000	F2BH028107
84	1569200	F2BN004617
85	1584000	F2BH028502
86	1566600	F2BN004461
87	1587400	F2BH028491
88	1582000	F2BN006310
89	1584200	F2BH028507
90	1579400	F2BN005739
91	1577000	F2BH028446
92	1580000	F2BH028449

Operator: BucketTH	BladisNET Revision 3.0 © 2006 | Schenck RoTec GmbH | Germany	27/09/2025 Page 6

Blade Type: **GEBL02M6FA**

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

Blade Set: **824026**



Predistribution Pattern:	7 - Sequence of Weighing
Calculated Unbalance:	10 gmm
Calculated Angle:	267 deg
State of Blade Set:	In Tolerance (1000 gmm)
	In reduced Tolerance (10 gmm)