TITLE:

Machining Process

Employee's Name: _____

TASK NUMBER AND DESCRIPTION

Subtask 1: Machining Process

INSTRUCTIONS FOR TRAINER

Check off each subtask as the employee successfully completes the task. Fill in your initials, the date, and the conditions under which the employee performed the subtask. Place an "A" if the actual task was performed and an "S" if the task was performed in simulation.

Subtask 1: Machining Process

Subtask 1 Validation – Acceptance Criteria Below Met

Date	Initial	Conditions
_____	_____	_____

_____1. Check the size of tubing/ casing and check/ verify condition of the pipe.

_____2. Select a program that correlates to what is being cut.

_____3. Check the tools and inserts on the turret to verify they are in optimal condition.

_____4. Move the tubing/ casing onto conveyer by hand or crane.

a. Move pipe into machine using rollers.

b. Raise the steady rest to support pipe.

c. Lower the rollers of the conveyer down.

_____5. Once part is in machine close back chuck to secure pipe in place.

_____6. Tighten the front chuck using speed ratchet.

_____7. Indicate part on the threads while part is spinning.

a. Spin the part inside machine.

b. Verify it's not hitting against any part of machine.

c. Verify part is secured and straight.

_____8. Before running double check the program and reverify part is secure in the chuck.

_____9. Start the program.

a. Adjust the speed for correctness.

b. Monitor the tools.

_____10. Check on the part during optional stops

_____11. When finished debur the sharp edges from the part.

a. Visually inspect the threads.

b. Gauge the part.

_____12. Place thread protector on pin side to protect the threads from possible damage.

a. Open front chuck.

b. Open the back chuck.

c. Remove the pipe out of the machine using rollers.

d. Remove thread protector.

_____13. Transfer pipe by hand or crane.

a. To bucking unit for prep for coupler or

b. Send to outbound rack for loader operator for storage.

Post Verification:

Performance Standards

All forms, dates, and signatures required for these tasks must be thoroughly and accurately completed. End state conditions described in the procedure must be within acceptable ranges. All applicable standard operating procedures must be followed. All software security and guidelines, rules, or regulations must be observed.

Post Verification – Acceptance Criteria Below Met [√]

Date	Initial	Conditions
_____	_____	_____

_____1. All forms, dates, and signatures required for these tasks must be thoroughly and accurately completed.
_____2. End state conditions described in the procedure must be within acceptable ranges
_____3. All applicable standard operating procedures must be followed.
_____4. All software security and publishing guidelines, rules, or regulations must be observed.
_____5. Performed the task in a timely manner.

QUALIFICATIONS RECORD

All Acceptance Criteria met and competency in the Task successfully demonstrated:

Trainee _____ Trainer _____ Date _____