

Job Traveler

Job Number: 231340-03



Due Date: 09/11/2023

Sold SMP SUPPLY
To: PO BOX 1675
MONT BELVIEU, TX 77523

Ship PCW
To: 379054 E 1130 RD
Okemah, OK 74859
United States

Order No: 231340

Dated: 07/17/2023

Quote No: 20132

Customer: SMP SUPPLY

PO Num: 88781

Ship Via: MSCHWARTZ@SMP-SUPPLY.CC

Priority: 3 - STANDARD

Part Number: *3TE208Y

Product Code: TEE

Description: TE 20X8 .375 X .322-
WPHY70

Master Job No:

-20F CVN

MSSSP75-14

Total Qty Open: 2 EA

Qty Posted: 0 EA

Qty To Make: 2

Start Date: 08/01/2023

Phone: (713)840-9333

Contact: MICHELLE SCHWARTZ

Fax: (713)840-9339

Job Notes

BCKZ
B10591-2 - TESTING REQ'D
CUT (2) @ 32" EACH FROM 132" CYLINDER
CYLINDERS IN PROCESS ON 231341-01

Routing

Routed By:							Quantity 2		
Step No	Work Cntr / Vendor	Description	Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation		Time	Time	Time	Per Hour	Start	End	Quantity
5	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut					08/01/2023	08/01/2023	2
10	FORGE 8 TRIM	Torch Cut Cut hole					08/02/2023	08/02/2023	2

20	FORGE 12 FORM/PRESS	2000 Ton Press Forming	08/02/2023 08/02/2023	2
				
30	FORGE 8 TRIM	Torch Cut Trim	09/12/2023 09/12/2023	2
				
40	FORGE 7 HEAT TREAT	Heat Treat	02/01/2024 02/01/2024	2
				
50	FORGE 5-6 FORGE BLAST	Forge Shotblast	02/01/2024 02/01/2024	2
				
60	PIPE 13 X RAY	Pipe X Ray	02/01/2024 02/05/2024	2
				
70	E1 MACHINING	E1 Extender	02/05/2024 02/05/2024	2
				
80	M7 SM BULL MACHINING	M7 Small Bullard Machining	02/05/2024 02/06/2024	2
				
90	STAMP 1 STAMP	Stamping	02/06/2024 02/06/2024	2
				
100	INSPECT 1 INSPECTION	Inspection 1	02/06/2024 02/06/2024	2
				



Time per Piece (HR):	0.00	0.00	0.00	0.00
Total Time for Job (HR):	0.00	0.00	0.00	

Materials List

----- Quantity -----					Quantity: 2	
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>	<u>Unit</u>	<u>Description</u>	<u>Sub- Assy</u> <u>Vendor</u>

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCKZ
20X8
.375X.322
WPHY70
231340-03

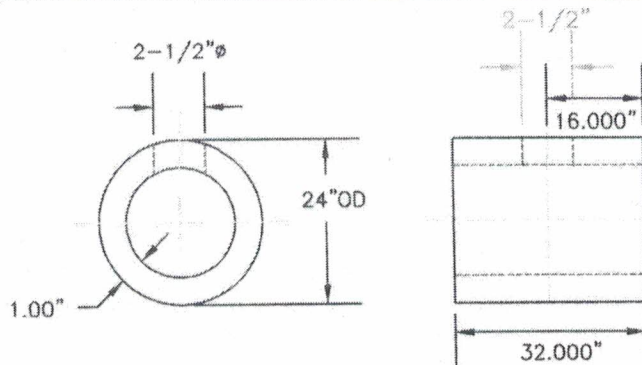
$$20'' \text{ Run Diameter} = 20.456''$$

8" Outlet Diameter = 8.766"

Material Size 24" O.D. x 1.00"W
Length 32.000"

Hole size 2-1/2"

Grind 1/8" radius on hole edges
I.D. & O.D.



valing Data: Oval: HOT Oval width: 19-3/4"±.1/8"

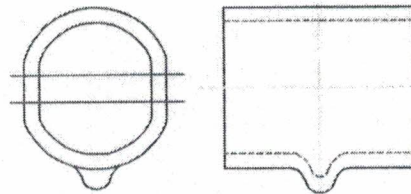
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reform Data:

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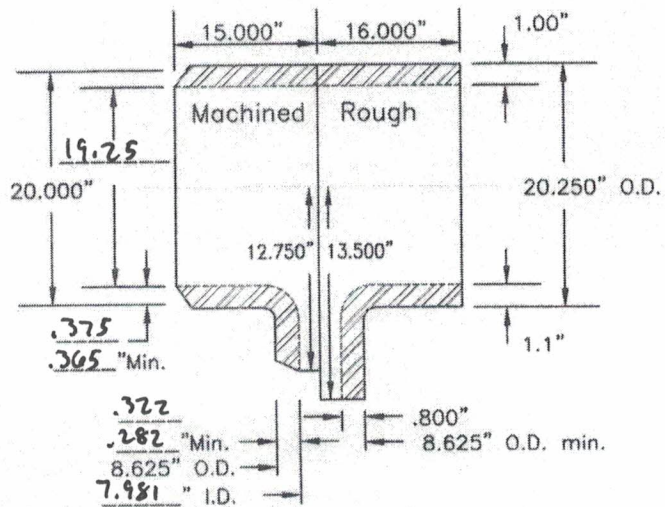
Press: Machine 2000 Ton Set up#None shown Upper Die# 42206
Lower Die# 40378

st Form: Heat to 1650°F.
Quench in 17" of water
Close to 3-3/4" &
Pull 4" plug (2" rod)



2nd Form: Re-heat to 1650°F.
Quench in 14" of water
Close dies to 3/4" &
Pull 6.00" plug (3" plug)

Final Form: Re-heat to 1650°F.
Do not quench
Close dies HOT &
Pull 7-1/4" plug (3" rod)



			DATE: 3/2/10	20" x 8" <u>.375 x .322</u> HIGH YIELD TFF MFG DATA	DWG#
			SCALE: NONE		
			DRAWN BY: J.DAVIDSON		20-8-6
			CHECKED BY: JL		
DESCRIPTION	BY	DATE			

FORM BY EXTRUSION PER CARD: _____

PRE CUT ENDS

IF ORDER SIZE IS LARGER THAN FURNACE LOAD, SERIALIZE UNDER CUTTER STAMP PRIOR TO HEAT TREAT

HEAT TREATMENT PER QCP 8.1 REV.1: (WITH TEST MAT'L B- _____)

HEAT TREAT 1/2 HR @ 1650°F **WATER QUENCH** FURNACE LOAD # _____

TEMPER 1 HR @ 1200 °F - AIR COOL - FURNACE LOAD# _____

SHOTBLAST TO NEAR WHITE FINISH

100% RADIOGRAPH WELD SEAM PER SPEC. XL-RT-100 (LATEST REVISION) _____

MACHINE PER MSS-SP75-14

BORE RUN I.D. STRAIGHT TO: 18.750 + 1/8 -0 19.250
0.375
0.365

BORE OUTLET I.D. STRAIGHT TO: 7.731 ± 1/16 7.981
0.322
0.282

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE