

Job Traveler

Job Number: 231347-02



Due Date: 09/12/2023

Sold FLOW-ZONE, LLC
To: 3504 DWAYNE ROAD
ROSHARON, TX 77583

Ship FLOW-ZONE - ROSHARON
To: 3504 DWAYNE RD
Rosharon, TX 77583
United States

Order No: 231347

Dated: 07/18/2023

Quote No: 19835

Customer: FLOW-Z134580

PO Num: 9299274

Ship Via:

Priority: 3 - STANDARD

Part Number: *3CR3024Y

Product Code: CONCENTRIC REDUCER

Description: CR 30X24 .625 X .562-
WPHY65

Master Job No:

MSSSP75-19

Total Qty Open: 2 EA

Qty Posted: 0 EA

Qty To Make: 2

Start Date: 08/15/2023

Phone:

Contact: JUAN MALAVE

Fax:

Job Notes

BCJL
B10439
USE (2) ALREADY AT 25.5"
NOT IN SHOPTECH INVENTORY
QR CODE

Routing

Routed By:

Quantity 2

Step No	Work Cntr / Vendor		Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
Dept	Operation	Description	Time	Time	Time	Per Hour	Start	End	Quantity
10	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut					08/15/2023	08/15/2023	2



20	FORGE 4 HAMMER	Large Hammer Hammer					08/23/2023	08/24/2023	2
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30	FORGE 7 HEAT TREAT	Heat Treat Heat Treat					02/14/2024	02/15/2024	2
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40	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot Blast in Forge	02/15/2024	02/15/2024	2
					
50	PIPE 13 X RAY	Pipe X Ray X-ray weld	02/15/2024	02/15/2024	2
					
60	E1 MACHINING	E1 Extender Expander	02/15/2024	02/15/2024	2
					
70	M1 MACHINING	M1 Big Mill Machining	02/15/2024	02/19/2024	2
					
80	STAMP 1 STAMP	Stamping Stamping	02/19/2024	02/19/2024	2
					
90	INSPECT 1 INSPECTION	Inspection 1 Inspection	02/19/2024	02/19/2024	2
					
100	SHIPPING SHIPPING	Shipping Shipping	02/19/2024	02/19/2024	2
					
Time per Piece (HR): 0.000.000.000.00 Total Time for Job (HR): 0.000.000.00					

Materials List

					Quantity: 2
-----Quantity----- Needed On Hand Posted Short Unit Description					Sub-Assy Vendor

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCJL
30X24
.625X.562
WPHY65
231347-02

FORM BY HAMMER

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

24 in. (SMALL) END-STRAIGHT BORE I.D. TO 22.376 ± 1/16

(FACE, TAPER BORE, AND BEVEL)

CONDITION GRIND

STAMP PER MSS-SP75-14

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE