

Job Traveler

Job Number: 231618-01



Due Date: 11/09/2023

Sold To: SPACE CITY DISTRIBUTION
2205 Kansas Ave
Dickinson, TX 77539
United States

Ship To: SPACE CITY DISTRIBUTION
2328 W BELFORT AVE
HOUSTON, TX 77054
United States

Order No: 231618**Dated:** 08/23/2023**Quote No:** 19574**Customer:** SPACE CITY**PO Num:** P-230602-3-2**Ship Via:** SFI SET UP TRUCK PP&A**Priority:** 3 - STANDARD**Part Number:** *3TE24Y**Product Code:** TEE**Description:** TE 24 .688 -WPHY60**Master Job No:**

-20 CVN

MSSSP75-19

Total Qty Open: 1 EA**Qty Posted:** 0 EA**Qty To Make:** 1**Start Date:** 09/04/2023**Phone:****Contact:** RONNIE RUZICKA**Fax:**

Job Notes

BCIR
B10754
CUT (1) @ 38.5" FROM 40" PIECE; FULL PIECE ALLOCATED

Routing

Routed By:**Quantity 1**

Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- Start End		Run Quantity
5	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut					09/04/2023	09/04/2023	1



10	FORGE 8 TRIM	Torch Cut Cut hole					09/21/2023	09/21/2023	1
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20	FORGE 12 FORM/PRESS	2000 Ton Press Forming					09/21/2023	09/25/2023	1
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30	FORGE 8 TRIM	Torch Cut Trim	09/25/2023 09/25/2023	1
				
40	FORGE 7 HEAT TREAT	Heat Treat	01/30/2024 01/30/2024	1
				
50	FORGE 5-6 FORGE BLAST	Forge Shotblast	01/30/2024 01/30/2024	1
				
60	PIPE 13 X RAY	Pipe X Ray	01/30/2024 01/30/2024	1
				
70	E1 MACHINING	E1 Extender	01/30/2024 01/30/2024	1
				
80	M7 SM BULL MACHINING	M7 Small Bullard Machining	01/30/2024 01/31/2024	1
				
90	STAMP 1 STAMP	Stamping	01/31/2024 01/31/2024	1
				
100	INSPECT 1 INSPECTION	Inspection 1	01/31/2024 01/31/2024	1
				



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: 1

Quantity							
Needed	On Hand	Posted	Short	Unit	Description	Sub- Assy	Vendor
40.00000	860.00000	40.00000	0.00000	EA	0PI2912552	NO	SFI

PI0 29-1.25-Y52
Quantities from Bins/Lot Number:
BCIR/221363-01 (40.0)

Marking Information:



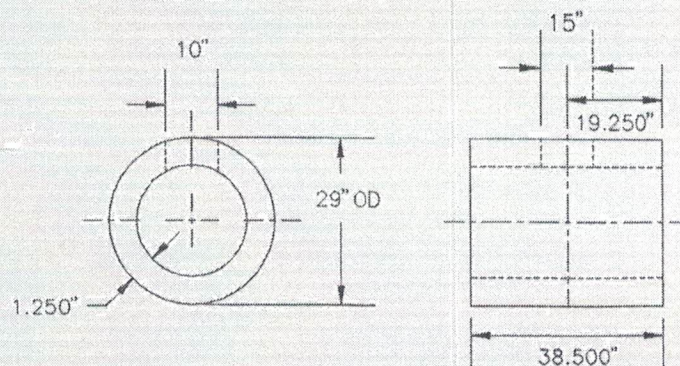
FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCIR
24X24
.688X.688
WPHY60
231618-01

24" Run Diameter = 24.430"
 24" Outlet Diameter = 24.375"

Material Size 29" O.D. x 1.250"W
 Length 38.500"



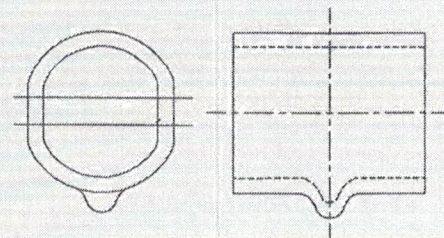
Hole size 10" x 15"
 Grind 1/8" radius on hole edges
 I.D. & O.D.

Ovaling Data: Oval: HOT Oval width: 23-1/2" ± .1/4"

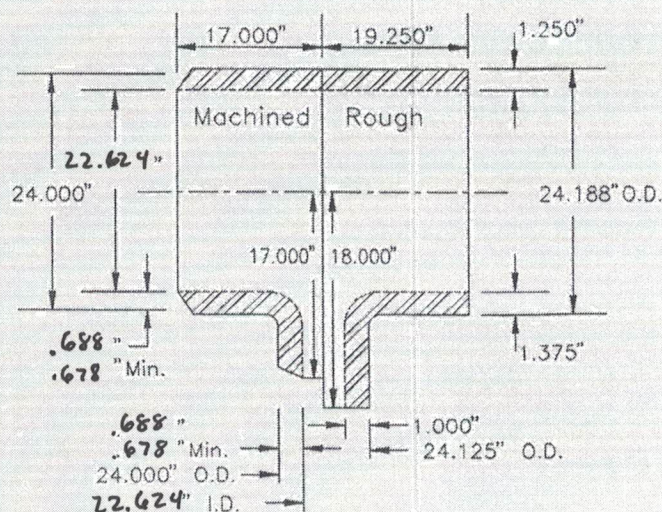
Preform Data:
 Press: Machine 2000 Ton Set up#10362 Upper Die# 50145
 Lower Die# 40312

1st Oper: Heat to 1650°F.
 Quench in 20" of water
 Close dies to 5" &
 Pull 17-3/8" plug (4" rod)

2nd Oper: Heat to 1650°F.
 Quench in 16" of water
 Close dies to 2" &
 Pull 20.00" plug (4" rod)



Final Oper: Re-heat to 1650°F
 Do not quench
 Close dies HOT & countersink
 Pull 22-1/4" plug(4" rod)



				DATE:	24" x 24" (.688 x .688)	DWG# 24-24-5A
				SCALE: NONE		
				DRAWN BY: J.DAVIDSON		
				CHECKED BY:		
					HIGH YIELD	
REV	DESCRIPTION	BY	DATE		TEE MFG. DATA	

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 3/4 HR @ 1650°F **WATER QUENCH** FURNACE LOAD # _____

TEMPER 1 1/4 HR @ 1100 °F - AIR COOL - FURNACE LOAD# _____

SHOTBLAST TO NEAR WHITE FINISH

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

MACHINE PER MSS-SP75-19

0.688

BORE RUN I.D. STRAIGHT TO: 22.124 + 1/8 -0 22.624

0.678

0.688

BORE OUTLET I.D. STRAIGHT TO: 22.124 + 1/8 -0 22.624

0.678

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE