

Job Traveler

Job Number: 231618-03



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:** *3TE30Y**Product Code:** TEE**Description:** TE 30 .750-WPHY60**Master Job No:**

-20 CVN

MSSSP75-19

Total Qty Open: 5 EA**Qty Posted:** 0 EA**Qty To Make:** 5**Start Date:** 09/04/2023**Phone:****Contact:** RONNIE RUZICKA**Fax:**

Job Notes

BCMS
B10719-1 - TESTING REQ'D
CUT (5) @ 49" EACH FROM (2) 150" CYLINDERS
DO NOT ADD SCRAP

Routing

Routed By:**Quantity 5**

Step No Dept	Work Cntr / Vendor Operation	Description	Setup Time	Cycle Time	Total Time	Pieces Per Hour	--- Scheduled --- Start End		Run Quantity
10	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut					09/04/2023	09/04/2023	5
20	FORGE 8 TRIM	Torch Cut Cut hole					10/03/2023	10/03/2023	5
30	FORGE 12 FORM/PRESS	2000 Ton Press Forming					10/03/2023	10/03/2023	5

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40	FORGE 8 TRIM	Torch Cut Trim	10/03/2023 10/04/2023	5
				
50	FORGE 7 HEAT TREAT	Heat Treat Heat treat	07/01/2024 07/02/2024	5
				
60	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	07/02/2024 07/02/2024	5
				
70	PIPE 13 X RAY	Pipe X Ray X-ray	07/02/2024 07/03/2024	5
				
80	E1 MACHINING	E1 Extender Expander	07/03/2024 07/03/2024	5
				
90	M1 MACHINING	M1 Big Mill Machining	07/03/2024 07/08/2024	5
				
150	STAMP 1 STAMP	Stamping	07/08/2024 07/08/2024	5
				
160	INSPECT 1 INSPECTION	Inspection 1	07/08/2024 07/08/2024	5
				



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: 5	
					Sub-	
<u>Needed</u>	<u>On Hand</u>	<u>Posted</u>	<u>Short</u>	<u>Unit</u>	<u>Description</u>	<u>Assy</u> <u>Vendor</u>
250.00000	952.00000	250.00000	0.00000	EA	0PI37512552	NO SFI
					PI0 37.5-1.25-Y52	
					Quantities from Bins/Lot Number:	
					BCMS (150.0)	
					BCMS (100.0)	

Marking Information:



FLEET-LINE

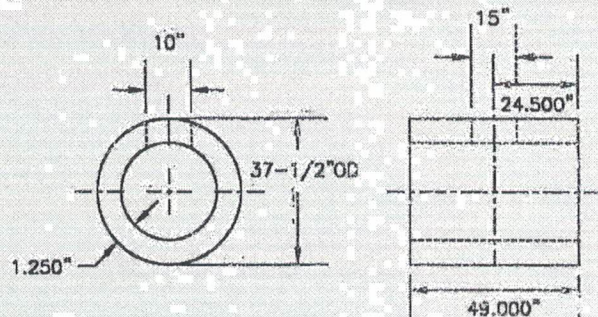
MADE IN USA
STEEL FORGINGS

BCMS
30X30
.750X.750
WPHY60
231618-03

30" Run Diameter = 30.476"
 30" Outlet Diameter = 30.633"

Material Size 37-1/2" O.D. x 1.250" PLT.
 Length 49.000"

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

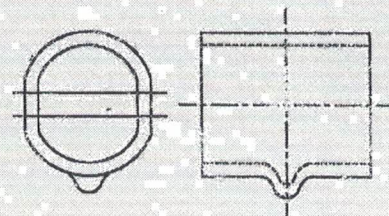


Ovaling Data: Oval: HOT Oval width: 29-3/4" ± 1/4"

Preform Data:

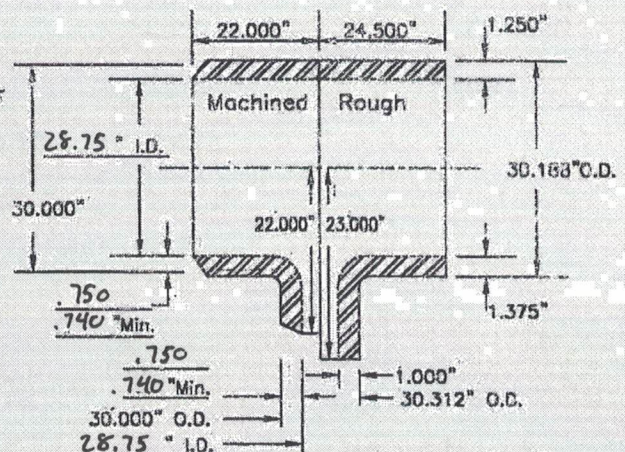
Press: Machine 2000 Ton Set up#10138 Upper Die# 50037
 Lower Die# 50041

1st Oper: Heat to 1650°F
 Quench in 27" of water
 Close dies HOT to 8-1/2"
 Pull 18-5/8" plug(4" rod)



2nd Oper: Re-heat to 1650°F
 Quench in 23-1/2" of water
 Close dies to 5-1/2" &
 Pull 23-1/8" plug(4" rod)

3rd Oper.: Re-heat to 1650°F
 Quench in 20-1/2" of water
 Close dies HOT to 2" and
 Pull 26.485" plug(6" rod)



Final Oper: Re-heat to 1650°F
 Do not quench
 Close dies HOT &
 Pull 28.280" plug(6" rod)

				DATE: 11-11-99	30" x 30" .750 x .750 HIGH YIELD TEE MFG. DATA	DWG#
				SCALE: NONE		30-30-4 (.751" thru .833" bevel (hk.)
				DRAWN BY: J.D.		
				CHECKED BY: Bull		
REV	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 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

0.750

BORE RUN I.D. STRAIGHT TO: 27.750 + 1/4 -0 28.500

0.740

0.750

BORE OUTLET I.D. STRAIGHT TO: 27.750 + 1/4 -0 28.500

0.740

CONDITION GRIND

STAMP PER MSS-SP75-19

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE