



Due Date: 12/07/2023

Sold CTAP, LLC
To: 2585 TRAILRIDGE DR EAST
LAYFAYETTE, CO 80026

Ship GREENPOINT ENERGY CENTER
To: 287 MASPETH AVE
Brooklyn, NY 11211
United States

Order No: 231773

Customer: CTAP

Ship Via: PPD & ADD

Part Number: *3TE3024Y

Description: TE 30X24 .750 X .688-WPHY65

MATL-3111

Dated: 09/14/2023

PO Num: 161323

Priority: 3 - STANDARD

Product Code: TEE

Master Job No:

Quote No:

Qty To Make: 3

Total Qty Open: 3 EA

Qty Posted: 0 EA

Start Date: 09/26/2023
Contact: RANDY ROOS

Phone: 303-661-9475
Fax:

Job Notes

BCLA
B10596-1
CUT (3) @ 46" EACH FROM 140" CYLINDER; FULL CYLINDER ALLOCATED

Routing

Routed By:

Quantity 3

Step No	Work Cntr / Vendor		Setup	Cycle	Total	Pieces	--- Scheduled ---		Run
<u>Dept</u>	<u>Operation</u>	<u>Description</u>	<u>Time</u>	<u>Time</u>	<u>Time</u>	<u>Per Hour</u>	<u>Start</u>	<u>End</u>	<u>Quantity</u>
10	FORGE 10 CYLINDER CUT	Cylinder Cut Cylinder Cut					09/26/2023	09/26/2023	3
 									
20	FORGE 8 TRIM	Torch Cut Cut hole					10/03/2023	10/03/2023	3
 									
30	FORGE 12 FORM/PRESS	2000 Ton Press Forming					10/03/2023	10/03/2023	3
 									

40	FORGE 8 TRIM	Torch Cut Trim	10/05/2023 10/05/2023	3
				
50	FORGE 7 HEAT TREAT	Heat Treat Heat treat	08/08/2024 08/12/2024	3
				
60	FORGE 5-6 FORGE BLAST	Forge Shotblast Shot blast	08/12/2024 08/12/2024	3
				
70	PIPE 13 X RAY	Pipe X Ray X-ray	08/12/2024 08/12/2024	3
				
80	E1 MACHINING	E1 Extender Expander	08/12/2024 08/12/2024	3
				
90	M1 MACHINING	M1 Big Mill Machining	08/12/2024 08/14/2024	3
				
150	STAMP 1 STAMP	Stamping	08/14/2024 08/14/2024	3
				
160	INSPECT 1 INSPECTION	Inspection 1	08/14/2024 08/14/2024	3
				



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: 3	
					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>
140.00000	654.00000	140.00000	0.00000	EA	0PI3512552	NO SFI
					PI0 35-1.25-Y52	
					Quantities from Bins/Lot Number:	
					BCLA (140.0)	

Marking Information:



FLEET-LINE

MADE IN USA
STEEL FORGINGS

BCLA
30X24
.750X.688
ASTM A633E
WPHY65
231773-03

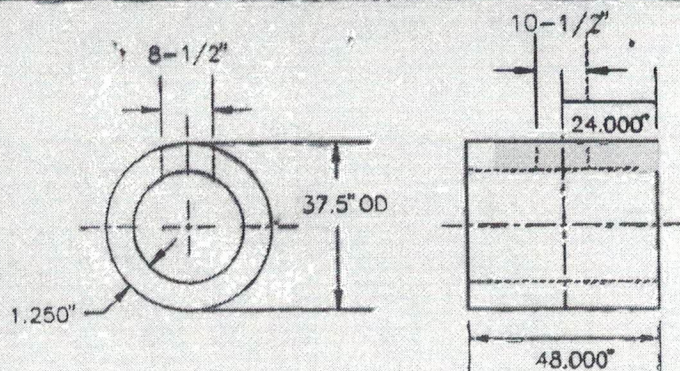
30" Run Diameter = 30.476"

24" Outlet Diameter = 24.567"

Material Size 35" O.D. x 1.250"W
Length 46.000"

Hole size 8-1/2" x 10-1/2" Oval

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



Ovaling Data: Oval: HOT Oval width: 29-1/2" ± .1/4"

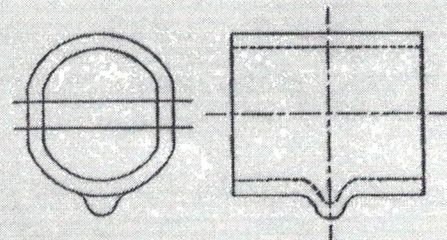
Preform Data:

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

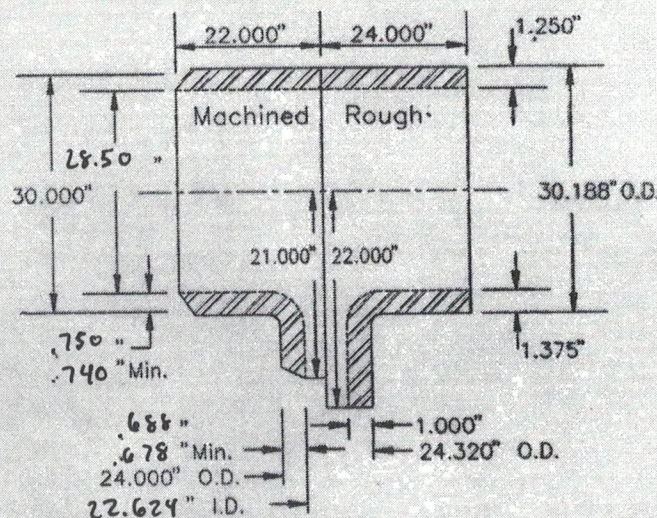
Lower Die# 50088

1st Oper: Heat to 1650°F
Do not quench
Close dies HOT to 8-1/2"
No plug

2nd Oper: Re-heat to 1650°F
Quench in 23" of water
Close dies HOT to 5" &
Pull 14-1/4" plug(4" rod)



3rd Oper: Re-heat to 1650°F
Quench in 19-1/2" of water
Close dies to 1-1/2" &
Pull 18-1/2" plug(4" rod)



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

				DATE:
				SCALE: NONE
				DRAWN BY: J.DAVIDSON
				CHECKED BY:
REV	DESCRIPTION	BY	DATE	

DWG#
30" x 24"
(.150 x .686)
HIGH YIELD
TEE MFG. DATA

30-24-4A

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-SP75-14

BORE RUN I.D. STRAIGHT TO: 27.750 + 1/4 -0 28.500
0.750
0.740

BORE OUTLET I.D. STRAIGHT TO: 22.124 + 1/8 -0 22.624
0.688
0.678

CONDITION GRIND

STAMP PER MSS-SP75-14

SEE QR SHEET

HARDNESS (BASE; 235BHN MAX, EACH PIECE): _____

PAINT

PAINT MARK: _____

END PROTECT/PALLETIZE