

Job Number: 076706-1-1

Job Traveler

Date: 7/10/2019

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Customer: PROCESS FLOW SYSTEMS LTD---502809

0 Part: RPR Scrubber Pump

Description: Process Flow / Marathon Pulp
Worthington 5LFG8
3x4-7

Prod Qty: 1.00 Order Qty: 1.00 Total Qty: 1.00 Start Date: 12/31/2009 Due Date: 12/31/2009 Required Date: 12/31/2009

SUBASSEMBLY COMPONENTS:

Asm	Part Number	Description	Required Qty	from Stock	Whse	Status
1	Dissassembly&Inspect	Dissassembly clean and inspect	1.00	EA	0.00	
2	Shaft	Chrome repair	1.00	EA	0.00	
3	Impellers	Skim rings/balance	1.00	EA	0.00	
4	Diffusers	Skim case hub rings	1.00	EA	0.00	
5	Diffuser Casings	Install new case rings	1.00	EA	0.00	
6	Suction Housing	Installnew ring	1.00	EA	0.00	
7	Discharge Housing	skim balance drum wear face	1.00	EA	0.00	
8	Impeller Spaces	Manufacture	1.00	EA	0.00	
9	Packing Sleeves	Manufacture	1.00	EA	0.00	
10	OE Stuffing Box	Skim bore	1.00	EA	0.00	
11	Restriction Sleeve	Manufacture	1.00	EA	0.00	
12	CE Bearing Spacer	Manufacture	1.00	EA	0.00	
13	Bearing Housings	Sleeve bearing bores	1.00	EA	0.00	
14	Balance Sleeve	Manufacture	1.00	EA	0.00	

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RAW MATERIAL COMPONENTS:

Seq No.	Part Number	Description	Required Qty		Whse	Rel. OP	Status
10	3" dia x 12" lg	CD4	1.00	EA		0	<i>Issued Complete</i>
20	CD4	6-5/8 x 3-3/4" x 6-1/4" lg	1.00	EA		0	<i>Issued Complete</i>
30	CD4	3" Dia x 6" lg	1.00	EA		0	<i>Issued Complete</i>
40	CD4	7-1/4" x 2" x 3-1/2" lg	1.00	EA		0	<i>Issued Complete</i>
50	#10050	EZEE-Sleeves	2.00	EA		0	<i>Issued Complete</i>
60	PO FRT	Shipping Charges	1.00	EA		0	<i>Issued Complete</i>
70	2-1/4" x 23" lg	410 SS	1.00	EA		0	<i>Issued Complete</i>
80	Subcontract	Balance sleeve heat treat to 44Rc	1.00	EA		0	<i>Issued Complete</i>
90	Shipping Box	5' lg x 3' H x 3' W c/w lid and runners	1.00	EA		0	<i>Issued Complete</i>
100	10mm	end mill cutter 2 flute	1.00	EA		0	<i>Issued Complete</i>
110	8mm	end mill cutter 2 flute	2.00	EA		0	<i>Issued Complete</i>
120	Style 1070 "B" Box	35 ft Size 12MM Packing Qu# 0810DC	1.00	EA		0	<i>Issued Complete</i>
130	Pt# 98810A140	7x8MM Keystock	1.00	EA		0	<i>Issued Complete</i>
140	Pt# 90457A170	10MM Keystock	1.00	EA		0	<i>Issued Complete</i>
150	PO FRT	Fuel Surcharge	1.00	EA		0	<i>Issued Complete</i>
160	CON NU 407 M	Bearing	2.00	EA		0	<i>Issued Complete</i>
170	FAG 6407 C3	Bearing	1.00	EA		0	<i>Issued Complete</i>
180	REM KM 07	Lock nut	1.00	EA		0	<i>Issued Complete</i>
190	REM W07	Bearing Lock Washer	1.00	EA		0	<i>Issued Complete</i>
200	5mmx280mm	Viton O-Ring	5.00	EA		0	<i>Issued Complete</i>
210	3MM x 50MM	Viton O-Ring	4.00	EA		0	<i>Issued Complete</i>
220	40627DL	DMR Oil Seal	4.00	EA		0	<i>Issued Complete</i>
230	PO FRT	Shipping Charges	1.00	EA		0	<i>Issued Complete</i>
240	Pt# UT1615	15" Rubber cords	10.00	EA		0	<i>Issued Complete</i>

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	ASM	Shop Production	1.00	1.00	
<i>Assemble pump complete.</i>					

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OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
20	INS	Shop Production	1.00	1.00	CMPL
Final inspection by shop supervisor.					

1 Part: Dissassembly&Inspect **Description:** Dissassembly clean and inspect

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	DAS	Shop Production	1.00	1.00	
Incoming photos Dismantle Clean Parts for Inspection					

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
20	INS	Shop Production	1.00	1.00	
Dimensional Inspection of all components Record 'as found' condition					

101 Part: Shaft **Description:** Chrome repair

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

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OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
5	MCH	Shop Production	1.00	1.00	
Manufacture new shaft as per sample. NOTE: drawing started in folder. Use CD4 shafting.					

201 Part: Impellers **Description:** Skim rings/balance

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	5.00	1.00	
Skim all impeller rings to 4.650" +.000-.002. Skim hub faces parallel minimal clean up.					

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
20	BAL	Shop Production	1.00	1.00	
Assemble impellers onto shaft for balancing. Balance impellers to ISO G 2.5 specs @ 3550 RPM.					

301 Part: Diffusers **Description:** Skim case hub rings

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

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OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	4.00	1.00	
Skim diffuser hub rings (4). Finish ID for all is 2.400" +.002-.000. Hand dress and machine diffuser with test weld. (Diffuser vanes appear good, no welding required.)					

401 Part: Diffuser Casings **Description:** Install new case rings

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	4.00	1.00	
Remove existing casing rings (Large). Manufacture and install new rings as per samples and line bore in casing. Finish ID for all (4) rings is 4.671" +.002-.000. NOTE: Material is CD4.					

501 Part: Suction Housing **Description:** Install new ring

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	1.00	1.00	
Remove existing case ring. Manufacture and install new ring as per sample. Finish ID size is 4.671" +.002-.000.					

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601 Part: Discharge Housing **Description:** skim balance drum wear face

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	1.00	1.00	
Skim balance drum wear face minimal clean up.					

701 Part: Impeller Spaces **Description:** Manufacture

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	4.00	1.00	
Manufacture (4) new impeller spacers as per sample. Finish OD for all (4) is 2.382" +.000-.002 NOTE: material is CD4					

801 Part: Packing Sleeves **Description:** Manufacture

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	2.00	1.00	
Manufacture (2) new packing sleeves as per samples. NOTE: Material is CD4					

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901 Part: OE Stuffing Box

Description: Skim bore

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	1.00	1.00	
Skim Outboard end stuffing box restriction bushing bore to 2.580" +.002-.000.					

1001 Part: Restriction Sleeve

Description: Manufacture

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	1.00	1.00	
Manufacture new restriction sleeve as per sample. Finish OD is 2.562" +.000-.002. Use CD4.					

1101 Part: CE Bearing Spacer

Description: Manufacture

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	1.00	1.00	
Skim CE bearing spacer OD minimal clean up.					

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1201 Part: Bearing Housings

Description: Sleeve bearing bores

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
5	WLD	Shop Production	2.00	1.00	

Weld repair bearing housing spigots. Machine spigots to suit suction and discharge housings with 0.004" clearance.

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	2.00	1.00	

Sleeve both bearing housing bores. Finish ID for both is 3.9370 to 3.9379" Use eze-sleeves.

1301 Part: Balance Sleeve

Description: Manufacture

Prod Qty: 1.00 **Order Qty:** 0.00 **Total Qty:** 0.00 **Start Date:** 12/31/2009 **Due Date:** 12/31/2009 **Required Date:** 12/31/2009

OPERATIONS

Seq No.	Oper.	Description	Oper. Qty	Res.	Status
10	MCH	Shop Production	1.00	1.00	CMPL

Manufacture new roughed out balance sleeve as per sample. Leave wear face 1/8" longer for set up at assembly Use 410 SS material. Balance sleeve to be heat treated to 44 Rc.

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OPERATIONS

Seq No. Oper.		Description	Oper. Qty	Res.	Status
20	HTR	Subcontract	1.00	1.00	
Heat treat balance sleeve to 44 Rc.					

OPERATIONS

Seq No. Oper.		Description	Oper. Qty	Res.	Status
30	MCH	Shop Production	1.00	1.00	
Finish machine balance sleeve as per sample. Leave 1/8" on wear face for final assembly.					