WebAIM Short Form TASK GROUP INSTRUCTION

06-MAR-2025 1251

20.14.15.2.9020 (September 2024) ICN: 3819P22115 KeyOp: A14

TGI NO:	COMPONENT NAME:	TYPE:	PHASE:	REPEAT:	CHG/VER:
	1B BOILER	**BO**	**A**	**10**	**0/0**

SHIP/HULL NO:	SHIP/HULL NAME:	PROJECT:	SYSTEM:	PLANT ID:	CASREP CAT:
LCC-19	**USS BLUE RIDGE**	19P	**22111**		

CU PHASE TITLE: *(BIRMIS) F/O - INSPECT AND REPAIR SIDE WALL SLIDING FEET AND CASING 1B BOILER

PREPARING ACTIVITY:	STATUS: APP	WORKING STATUS:

PREPARED BY:	CODE:	PHONE:	DATE:
IZUMI, NORIAKI	234	3152432243	27-FEB-2025
APPROVED BY:	CODE:	PHONE:	DATE:
HARADA, HIDEO	234	3152435176	28-FEB-2025
CONCURRED BY:	CODE:	PHONE:	DATE:

REASON FOR WORK/NEED FOR CHANGE:
EM02L192

JCN:
EM02-L192

SPECIAL REQUIREMENTS:
TGI Short Form

CU PHASE DESCRIPTION:

1. SCOPE/PURPOSE:

1.1 Title: 1B Boiler Side Wall Header Sliding Feet and Outer Casing Bolted Joint Gasket; inspect and repair

1.2 Location of Work:

1.2.1 Fire Room (8-76-0-E)

1.3 Identification:

1.3.1 Quantity (One Lot), Casing, Around Front and Rear Foundation, Side Wall, 1B boiler

1.3.2 Quantity (2 EA), Silding Feet, Sidewall Header, 1B Boiler
Foundation Material: Steel, MIL-S-22698
Remarks: see Sketch Enclosure-02 for details of sheet metal pan

1.3.2.1 Quantity (8 EA), Fastener

ZONE MANAGER:	ZONE:	COMPARTMENT:	LEVEL:	FRAME:	SIDE:
KANKE, KOUHEI		8-76-0-E			U

JOB SUMMARY ID:	TOT MAN HR.:	TOT DUR:	TOT JML COST:	PLANNING ACCEPTANCE:
221A1115				

WORK CERTIFICATION SIGNATURES:	DLs													

COMPLETION OF WORK REVIEW:	BADGE NO:	SHOP/CODE:	PHONE:	DATE:
RECORDS REVIEW:	BADGE NO:	SHOP/CODE:	PHONE:	DATE:

TGI NO:	COMPONENT NAME: 1B BOILER	TYPE: BO	PHASE: A	REPEAT: 10	CHG/VER: 0/0

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CU PHASE DESCRIPTION (Cont.)

Bolt: Heavy HEX Head, 2-1/2-8UN-2A X 8-1/2 LG, CHROME MOLY Steel , ASTM A193, GR B7
Nut: JAM Heavy HEX Head, 2-1/2-8UN-2B, ALLOY Steel, ASTM A194, GR 4
Washer: Steel, 5” OD X 2-5/8 ID X 0.28 Inch Thickness Max, FF-W-92, GR 1, CL A,TY A

1.3.2.2 Quantity (2 EA), Injection Fitting

Material: 1/8 IPS Thead Fitting, MIL-F-3541 TY 3

1.4 Security Classification: None.

1.5 Initial Condition:

1.5.1 Potential Lead Control

1.6 Contractor Start Date: 7/21/2026

1.7 Contractor Work Completion Date: 11/21/2027

2. PROCEDURE:

2.1 Accomplish a visual inspection of the current ship condition to identify and designate each area requiring repair of interior and exterior of each casing listed in 1.3.1, using Enclosure-01 for guidance.

2.1.1 Submit one legible copy, in hard copy or approved transferrable media, of a report listing results of the requirement of 2.1 to the SUPERVISOR.

2.2 Accomplish solvent cleaning for front and rear side of the sliding feet listed in 1.3.2 accordance with Ref. No. 3.

2.2.1 Fabricate and install each sheet metal pan around sliding feet for solvent cleaning.

2.2.1.1 Accomplish the requirements of 009-12 of Ref. No. One, including Table 2, Column(s) A and D, Lines One through 7.

2.2.1.2 Template exact size, configuration, and location from existing shipboard conditions.

2.2.2 Fill the metal pan with solvent, and allow it to stand from several days.

2.2.3 Darin the solvent and remove each sheet metal pan installed after completion of the solvent cleaning.

2.3 Remove existing and install each new fastener listed in 1.3.2.1 in accordance with Ref. No. 4.

2.3.1 Accomplish the requirements of 009-12 of Ref. No. One, including Table 2, Column(s) A, Lines One through 7.

2.4 Install each new injection fitting listed in 1.3.2.2 in accordance with Ref. No. 4.

2.4.1 Chase and tap each exposed threaded area.

2.5 Accomplish the requirements of 009-32 of Ref. No. One for each new and disturbed surface.

2.6 Notes:

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CU PHASE TITLE: *(BIRMIS) F/O - INSPECT AND REPAIR SIDE WALL SLIDING FEET AND CASING 1B BOILER

CU PHASE DESCRIPTION (Cont.)

2.6.1 Planner: Code 234 N. Izumi, 243-2243

2.6.2 Work Integration Manager (WIM): Code 333 T. Yaginuma, 080-5419-0598

2.6.3 Lubrication and demonstration for injection of new grease into sliding feet will be accomplished by Ship's Force post this repair work.

2.6.4 This TGI is response to Boiler Inspection and Repair Management Information System (BIRMIS) for 1B Boiler report dated 17 OCT 2024, Line item "E11-01 and E2-01".

2.6.5 JCN EM02-L192 is related to this TGI.

2.7 Government Furnished Material (GFM):

2.7.1 SRF-JRMC will provide GFM listed in the Material List.

2.8 SRF-JRMC will provide the following service work: (TGI No: 3819P22115S14)

2.8.1 [C740] Crane and crane rigging service.

2.8.2 [X99E] Provide utility service, electrical.

2.8.3 [X99M] Provide utility service, including low pressure air supply, water supply, and steam supply.

2.8.4 [C106.1] Provide safety inspection for SRF-JRMC employees.

2.8.5 [C106.2] Provide gas free inspection for SRF-JRMC employees.

2.8.6 [C133] Provide QA inspection for (G) symbols.

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OTHER SPECIAL REQUIREMENTS:
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Ref. No.	Document/Drawing Number	DOCUMENT/DRAWING TITLE	REV	CHG NO.	CPY REQ	PARAGRAPH	SECT	PG	CHPT
1	NSI FY-25	NAVSEA Standard Items	-	ORG	N				
2	LI FY-25	Local Standard Items	-	ORG	N				
3	TM S9086-GY-STM-010/CH-221	Boilers	8		N				
4	DWG 803-2145500	CHOCK FOR BOILER FOUNDATION ACCETABLE METHOD OF FITTING	E		Y			ALL	

TASK NAME / TASK DESCRIPTION	SHOP/ TSD	TS	SF WC	CREW #	MHRS	RWRK
2.1 BLRM HRs	22/KE	PC				N
2.2 BLRM HRs, WELD HRs, QA HRs	22/KE	PC				N
2.3 BLRM HRs, WELD HRs, QA HRs	22/KE	PC				N
2.4 BLRM HRs	22/KE	PC				N
2.5 PNTR HRs, QA HRs	22/KE	PC				N
Boiler Work CFM for Marine Chemist cost, firewatch cost, Lead, Grinding Abrasive, gas and welding rod, paint and other consumable material (MISC).	22/MQ	CS				N
Process Funding Document	10/CT	OM				N

MATERIAL REFERENCES

REF NO.	DOCUMENT/DRAWING NUMBER	DOCUMENT/DRAWING TITLE	REV
1	245500		

ICN: 3819P22115	KEY OP: A14

MATERIAL LIST

ITEM NO.	PC NO.	REF NO.	M / C	DESCRIPTION	STOCK NUMBER	GENERIC MATL TYPE	LVL	QA	HAZ MAT	DOC NO.	QTY REQD/ UNIT	QTY USED/ UNIT

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001	4	1	M	BOLT, HEAVY HEX HEAD, BOLT, HEAVY HEXAGON HEAD, 2-1/2"-8UNC-2A X 8-1/2" LENGTH, MATERIAL: CHROMIUM MOLYBDENUM VANADIUM, SPEC: ASTM A193 GRADE B7, ASME-B18.2.1. DWG: 803-2145500, PC.4, C234 N. IZUMI, 243-2243 ORDERED FOR KTR	9B 5306 LL9310715		NA	4	N		10/EA	
002			M	NUT, JAM, HEAVY HEX , JAM NUT, HEAVY HEXAGON HEAD, 2-1/2"-8UNC-2B, MATERIAL: ALLOY STEEL, ASTM A194, GRADE 4. ASME B18.2.2 USE FOR BOLT, HEAVY HEXAGON HEAD, 2-1/2"-8UN-2A X 8-1/2"LENGTH, CHROMIUM MOLYBDENUM VANADIUM ASTM A193, GRADE B7, ASME-B18.2.1. C234 N. IZUMI, 243-2243 ORDER FOR KTR	9B 5310 LL9310714		NA	4	N		10/EA	
003			M	WASHER,FLAT, C234 N.IZUMI, 243-2243 ORDER FOR KTR WASHER, STEEL, FF-W-92 GR 1, CL A, TY A DWG: 2145500 PC NO. 6	9B 5310 009960138		NA	4	N	50595334	20/EA	
004			M	SHIM, 0.006 THK, SHIM, 0.006 THK (SST) (ASTM A-167) USING FOR SLIDING FEET FASTENERS C234 N. IZUMI, 243-2243 ORDER FOR KTR	9B 5365 LL9008056		NA	4	N		10/EA	
005			M	CLEANING COMPOUND,S, C234 N. IZUMI, 243-2243 ORDER FOR KTR SOLVENT "140F" FEDERAL SPECIFICATION P-D-680, TYPE II	9B 6850 002745421		NA	4	Y	50595345	6/CN	
006			M	GREASE,SILICONE INS, C234 N. IZUMI, 243-2243 ORDER FOR KTR SILICON GREASE (HIGH TEMPERATURE) 14-OZ CARTRIDGE	9B 9150 010809652		NA	4	Y	50595346	10/CA	
007			M	SHEET,METAL, CRES 316L, 4' X 8' X 1/8" THK ORDER FOR KTR ORIG: C234 N. IZUMI, 243-2243 USING FOR FAB PAN	9B 9515 002044595		NA	4	N	50595347	1/SH	

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MATERIAL LIST

ITEM NO.	PC NO.	REF NO.	M / C	DESCRIPTION	STOCK NUMBER	GENERIC MATL TYPE	LVL	QA	HAZ MAT	DOC NO.	QTY REQD/ UNIT	QTY USED/ UNIT
008			M	PLATE,METAL, C234 N. IZUMI, 243-2243 4 X 8 ORDERED FOR 41B	9B 9515 002044622		NA	4	N	50595354	32/SF	
009			M	RUBBER SHEET,SOLID,, RUBBER GASKET, UNAFLEX, TYPE 96, THK 1/8" OEDERED FOR KTR, ORG: C234 N. IZUMI, 243-2243 USING FOR FAB PAN	9B 5330 014905014		NA	4	N	50595348	1/RO	
010			M	FITTING,LUBRICATION, C234 N.IZUMI, 243-2243 ORDER FOR KTR LUBRICATION FITTING, 1/8 IPS, 65 DEGREES, MIL-F-3541 TY 3, USING FOR INJECTION FITTING OF SLIDING FEET	9B 4730 001720031		NA	4	N	50595349	1/PG	
011			M	TUBE,METALLIC, C234 N. IZUMI, 243-2243 TUBGING 3/8 OD, 0.035" WALL THKS, CRES304, MIL-T-8506, ORDER FOR KTR	9B 4710 009753819		NA	4	N	50595350	5/FT	
012			M	TUBE, TUBE, METAL, SIZE; 1/4"OD X 0.049"THK, MATL: CRES 316, ASTM-A269 GR TP316, SEAMLESS 5FT / 1EA RQRD. C234 N. IZUMI, 243-2243 ORDER FOR KTR	9B 4710 LL9307315		NA	4	N		5/FT	
013			M	UNION,PIPE, ORDER FOR KTR ORIG: C234 N. IZUMI	9B 4730 008397477		NA	4	N	50595335	10/EA	
014			M	ADAPTER,STRAIGHT, MALE CONNECTOR, FLARELESS X NPTF, SPEC: MIL-DTL-18866, TUBE SIZE: 3/8" OD, THREAD SIZE: 1/8" NPT-27, MATL: STAINLESS STEEL, PRESSURE CLASS: 6000 PSI, NSN: 4730-01-219-7749(SMIC: X3), ORDER FOR KTR ORIG: C234 N. IZUMI	9B 4730 LL9310712		NA	4	N		10/EA	
015			M	ELBOW,PIPE TO TUBE, ORDER FOR KTR ORIG: C234, N. IZUMI	9B 4730 001764511		NA	4	N	50595336	10/EA	
016			M	NIPPLE,TUBE, ORDER FOR KTR ORIG: C234, N. IZUMI	9B 4730 008716937		NA	4	N	50595337	10/EA	

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	1B BOILER	**BO**	**A**	**10**	**0/0**

SHIP/HULL NO:	SHIP/HULL NAME:	PROJECT:	SYSTEM:	PLANT ID:	CASREP CAT:
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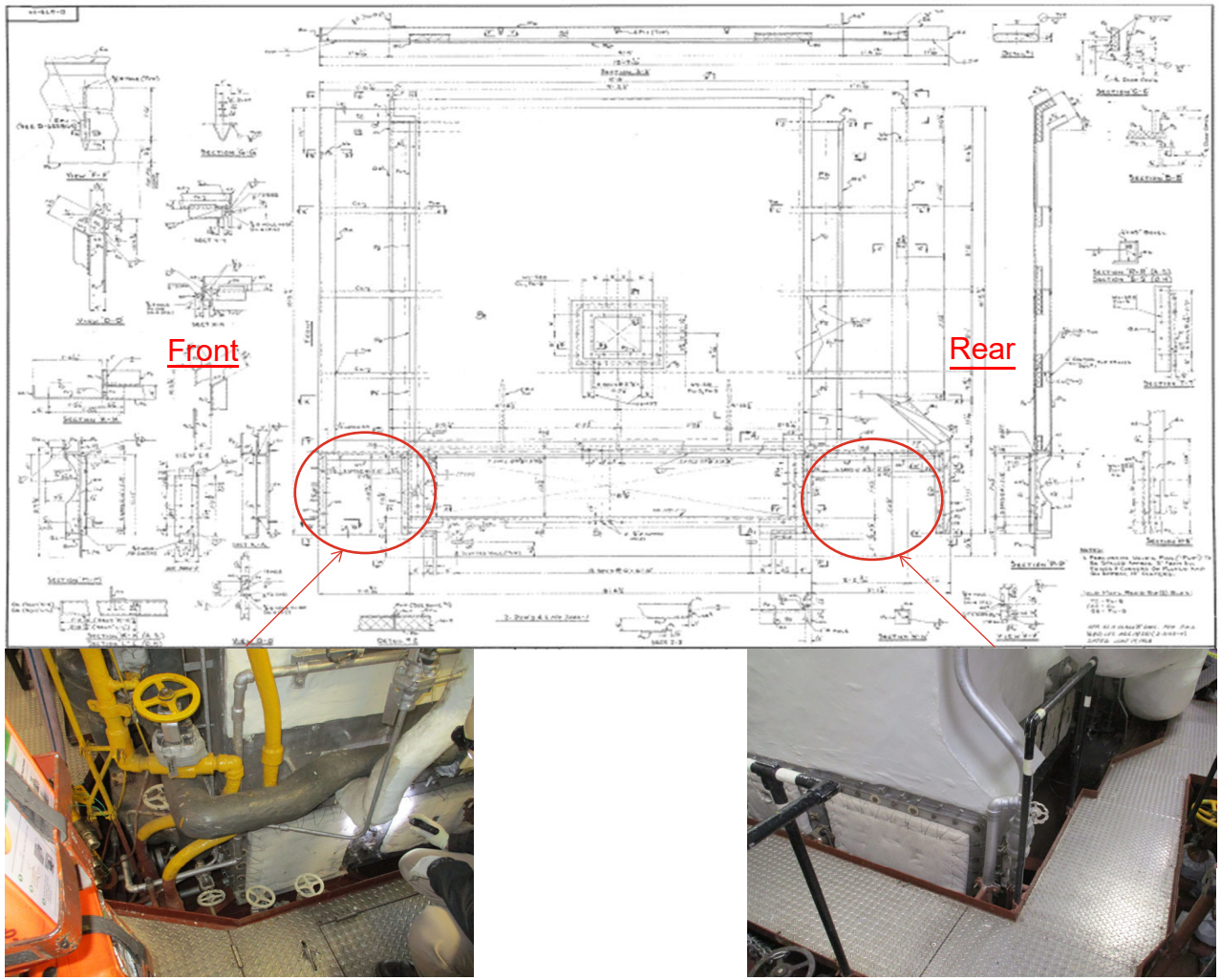
MATERIAL LIST

ITEM NO.	PC NO.	REF NO.	M / C	DESCRIPTION	STOCK NUMBER	GENERIC MATL TYPE	LVL	QA	HAZ MAT	DOC NO.	QTY REQD/ UNIT	QTY USED/ UNIT
017			M	PLATE,METAL, C234 N. IZUMI ORDER FOR KTR PLATE,METAL, 7FTX10FT X 1/4 THK	9B 9515 009526280		NA	4	N	50595338	1/PM	
018			M	PLATE,METAL, PLATE, 3/8 THK,, C-STL, ASTM A36, ORIG: C234	9B 9515 009173655		NA	4	N	50595339	1/PM	
019			M	PLATE,METAL, ORIG: C234 N. IZUMI ORDER FOR KTR PLATE, 1/2 THK, C-STL, ASTM A36,	9B 9515 009695124		NA	4	N	50595340	1/PM	
020			M	BOLT,MACHINE, C234 N.IZUMI, 243-2243 ORDER FOR KTR SCREW, HEX CAP, 5/8-11UNC X 1” LG, ALLOY STL, MIL-DTL-1222, TY I, GR 5	9B 5306 002270547		NA	4	N	50595351	50/EA	
021			M	SCREW,CAP,HEXAGON H, C234 N.IZUMI 243-2243 ORDER FOR KTR MATERIAL: 5/8" X 1-1/4", GR5	9B 5305 012001432		NA	4	N	50595341	50/EA	
022			M	SCREW,CA, SIZE: 5/8"-11, 1-1/2"L, MTL: STL ORDERED FOR KTR ORIG: C234 N. IZUMI	9B 5305 007245910		NA	4	N	50595342	50/EA	
023			M	WASHER,FLAT, ORIG: 234 N. IZUMI ORDERED FOR KTR	9B 5310 009517209		NA	4	N	50595343	1/HD	
024			M	WASHER,FLAT, ORIG: C234 N. IZUMI ORDER FOR KTR	9B 5310 014282155		NA	4	N	50595344	100/EA	

ATTACHMENT LIST

TITLE	FILE NAME	SAVED DATE
ENCLOSURE-01	3819P22115A14-Sketch-01.pdf	28-FEB-2025 0000
ENCLOSURE-02	3819P22115A14-Sketch-02.pdf	28-FEB-2025 0000



SKETCH

ENCLOSURE-01

3819P22115A14

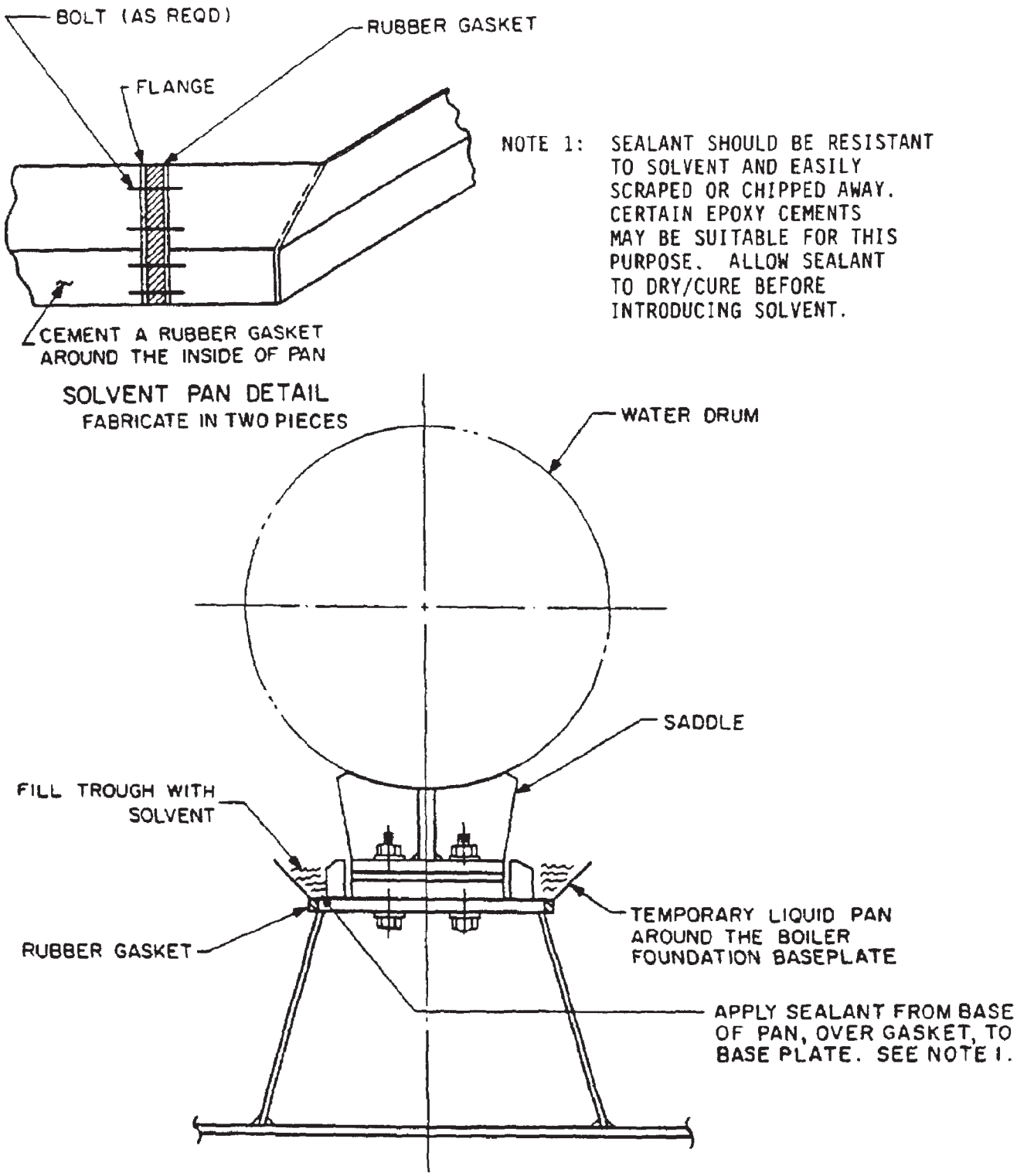


Figure 12-4. Typical Pan Installation for Solvent Soak

SKETCH

3819P2215A14 ENCLOSURE-02 SHEET 1OF 1