WebAIM Short Form TASK GROUP INSTRUCTION

24-JUN-2025 1555

20.14.15.2.9020 (September 2024) ICN: 3819P22114 KeyOp: A11

TGI NO:	COMPONENT NAME:	TYPE:	PHASE:	REPEAT:	CHG/VER:
	1A MF BLR ECN IN CHK	**V-**	**A**	**0**	**1/2**

SHIP/HULL NO:	SHIP/HULL NAME:	PROJECT:	SYSTEM:	PLANT ID:	CASREP CAT:
LCC-19	**USS BLUE RIDGE**	19P	**25511**		

CU PHASE TITLE: (L75-01) F/O – INSP 1A BLR ECONO OUT FEED WATER SYS LIFT CHECK VLV IN 8-76-0-E

PREPARING ACTIVITY:	STATUS: APP	WORKING STATUS: PKG	
PREPARED BY: IKEDA, KOUTARO	CODE: 232	PHONE: 3152430958	DATE: 24-FEB-2025
APPROVED BY: OZAWA, AKIHITO	CODE: 232	PHONE: 3152432493	DATE: 24-JUN-2025
CONCURRED BY:	CODE:	PHONE:	DATE:

REASON FOR WORK/NEED FOR CHANGE:
EM02L194

JCN:
EM02-L194

SPECIAL REQUIREMENTS:
TGI Short Form

CU PHASE DESCRIPTION:

1. SCOPE/PURPOSE:

1.1 Title: 1A Boiler Economizer Outlet Feed Water System Lift Check Valve; inspect

1.2 Location of Work:

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

1.3 Identification:

1.3.1 Quantity (One EA), 1A Boiler Economizer Outlet Feed Water System Lift Check Valve
Mfr: Anchor/Darling Valve Co.
Size: 5.00-Inch IPS
Body Material: Cast Carbon Steel
Bonnet Type: Pressure Seal (Silver Plate)
Valve No: V12 of Ref. No. 3

ZONE MANAGER:	ZONE:	COMPARTMENT:	LEVEL:	FRAME:	SIDE:
TAKAHASHI, YASUHIKO		8-76-0-E			U

JOB SUMMARY ID:	TOT MAN HR.:	TOT DUR:	TOT JML COST:	PLANNING ACCEPTANCE:
221A1114				

WORK CERTIFICATION SIGNATURES:	DLs													

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

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CU PHASE DESCRIPTION (Cont.)

1.3.1.1 Quantity (One EA), Pressure Seal Ring
Material: ASTM A-29, AISI 1005 through 1012
Remarks: PC No. 5 of Ref. No. 4

1.3.1.2 Quantity (One EA), Label Plate
Material: Alum
Remarks: SKETCH B of Ref. No. 9

1.4 Security Classification: None.

1.5 Initial Condition: None.

1.6 Contractor work start date: 7/21/2026

1.7 Contractor work completion date: 11/21/2027

2. PROCEDURE:

2.1 Accomplish a mechanical inspection of each valve listed in 1.3.1, using Ref. No. 3 through Ref. No. 6 for guidance.

2.1.1 Matchmark each valve part.

2.1.2 Disassemble, clean free of foreign matter (including paint), and inspect each part for defects.

2.1.2.1 The removal of body-bound studs only to determine the condition of threads is not required.

2.1.3 Torque test each body-bound stud in accordance with Section 075-8.6.3.2 (d) of Ref. No. 6.

(V) “TORQUE TEST”

2.1.4 Accomplish liquid penetrant (PT) inspection of seat, disc, and body inlay area in accordance with Ref. No. 7.

2.1.4.1 Acceptance criteria must be in accordance with Paragraph 7 of Ref. No. 8, except hairline cracks in hard-faced seat and disc are acceptable provided each valve does not show evidence of leakage.
(I) “PT INSPECT"

2.1.5 Inspect sealing surfaces of each inlay area and bonnet.

2.1.5.1 Inspect valve body to verify that stainless steel inlay is free of steam cuts and cracks and that diameter of inlay area is round to within 0.003 inch and free of non-design taper. Measure diameter at top and bottom of inlay area in increments of 45 degrees, on each circle. Inlay diameter must not exceed oversize number one diameter, plus 0.002 to 0.005-inch clearance described by Ref. No. 9.

(V) “VISUAL INSPECTION”

2.1.6 Assemble each valve in accordance with Ref. No. 3 and Ref. No. 4.

2.1.6.1 Fabricate and install each new pressure seal ring listed in 1.3.1.1 in accordance with Ref. No. 9, using Ref. No. 10 for guidance.

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CU PHASE DESCRIPTION (Cont.)

2.1.6.2 Accomplish a silver plating of the pressure seal ring listed in 1.3.1.1 in accordance with General Note 4 of Ref. No. 9 and ASTM B 700.

2.1.6.3 Attach a label plate listed in 1.3.1.2 to the valve bonnet indicating the size of seal ring installed, straight or tapered body neck, name of installing activity, and date of installation.

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

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

2.3 Notes:

2.3.1 Planner: Code 232 K. Ikeda, 243-0958
Planner: Code 233 K. Uchimura, 080-9350-1432

2.3.2 Zone Manager (ZM): Code 333 T. Yaginuma, 080-5419-0598

2.3.3 This TGI is response to Boiler Inspection and Repair Management Information System (BIRMIS) for 1A Boiler report dated 17 OCT 2024, Line Item L75-01.

2.3.4 Removal lagging as interference is covered by TGI No. 3819P22101-A01.

2.3.5 JCN EM02-L194 is related to this TGI.

2.4 Government Furnished Material (GFM):

2.4.1 SRF-JRMC will provide GFM listed in Material List.

2.5 SRF-JRMC will provide following service work: (TGI No. 3819P22114-S14).

2.5.1 [C740] Crane and crane rigging service.

2.5.2 [X99E] Utility service, electrical.

2.5.3 [X99M] Utility service, including low pressure air supply, water supply, and steam supply.

2.5.4 [C106.1] Safety inspection for SRF-JRMC employees.

2.5.5 [C106.2] Gas free inspection for SRF-JRMC employees.

2.5.6 [C133] QA inspection for (G) Symbol(s).

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OTHER SPECIAL REQUIREMENTS:
CLEANLINESS FOR PIPING SYSTEM/EQUIPMENT LEVEL II

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	DWG 208-2492086	Feed SUCT & DISCH & TRANS Piping -Plan	H		Y			ALL	
4	DWG 1S-595-5	5"-600# GLOBE LIFT CHECK VALVE CAST CARBON STEEL PRESSURE SEAL TYPE, BUTT WELD E	E		Y			ALL	
5	TM 0948-LP-012-5000	Standard Navy Valves	31		N				
6	TM S9086-CJ-STM-010/CH-075	Fasteners	7		N				
7	TM T9074-AS-GIB-010/271	Requirements for Nondestructive Testing Methods	1		N				
8	MIL MIL-STD-2035	Nondestructive Testing Acceptable Criteria	A		N				
9	DWG 803-6074287	Repair Guide Pressure Seal Valves	A		Y			ALL	
10	DWG 803-5001021	Pressure Seal Rings Standard and Oversize Valves Pressure Seal Class 600 - 1500	E		Y			ALL	

TASK NAME / TASK DESCRIPTION	SHOP/ TSD	TS	SF WC	CREW #	MHRS	RWRK
2.1 OMCH, IMCH, RGRS, ELEC						
2.2 PNTR						
Outside Machinist Work CFM: gasket, fasteners, and misc.						
Electrical Work CFM: silver plating solution and misc,						
Process Funding Document.						
Version-1: modify Procedure 2.5 SRF-JRMC service work. C232 H. Momose, 03/04/2025, -/-/N						
Version-2: change COPY REQD to “Y” for Ref. No. 3, No. 4, No. 9 and No. 10. C232 A. Ozawa, 06/24/2025, -/Y/N						

MATERIAL REFERENCES			
REF NO.	DOCUMENT/DRAWING NUMBER	DOCUMENT/DRAWING TITLE	REV

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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
001			M	BAR, METAL, BAR, METAL, ROUND, 7"DIA, FORGED CARBON STEEL, ASTM A29 (1008), FORGING - OPEN DIE ORIG: C232, K. IKEDA, 243-0958 ORDERED FOR KTR	9B 9510 LL4912661		NA	4	N	50707485	1/FT	