

Quality Assurance Documentation for Part ID: SE121-001P - Item: 22

Workorder: 64880/1-0 Sub:1 Op:10

Part: SE121-001P - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Verify Panel Joint Alignment Panel #1 to Panel #2 Joint (.02" Max)		MFG						
(10)				CWI						
*		Verify Panel Joint Alignment Panel #2 to Panel #3 Joint (.02" Max)		MFG						
(11)				CWI						
*		Verify Panel Joint Alignment Panel #3 to Panel #4 Joint (.02" Max)		MFG						
(12)				CWI						
*		Verify Panel Joint Alignment Panel #4 to Panel #5 Joint (.02" Max)		MFG						
(13)				CWI						
*		Verify Panel Joint Alignment Panel #5 to Panel #1 Joint (.02" Max)		MFG						
(14)				CWI						
*		Verify Panel / Rest Stop Position Panel #1 (0 - .09" Gap)		MFG						
(20)				CWI						
*		Verify Panel / Rest Stop Position Panel #2 (0 - .09" Gap)		MFG						
(21)				CWI						
*		Verify Panel / Rest Stop Position Panel #3 (0 - .09" Gap)		MFG						
(22)				CWI						
*		Verify Panel / Rest Stop Position Panel #4 (0 - .09" Gap)		MFG						
(23)				CWI						

INSPECTION DATA CHECKLIST

*	(24)	Verify Panel / Rest Stop Position Panel #5 (0 - .09" Gap)		MFG					
*	(30)	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		CWI					
*	(40)	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		CWI					
*	(50)	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		CWI					
*	(60)	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		CWI					
*	(70)	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		CWI					



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P - Item: 23

Workorder: 64880/1-0 Sub:1 Op:20

Part: SE121-001P - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		{g ,188"} Upper Half Of Bilateral Tolerance (tack welded vessel)		QA						
(10)										
*		Magnetic Permeability 1.01 Max. Record range (high / low)		QA						
(20)										

Quality Assurance Documentation for Part ID: SE121-001P - Item: 24

Workorder: 64880/1-0 Sub:1 Op:30

Part: SE121-001P - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		CWI						
(10)										
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		CWI						
(20)										
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		CWI						
(30)										
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		CWI						
(40)										
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		CWI						
(50)										



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P - Item: 25

Workorder: 64880/1-0 Sub:1 Op:40

Part: SE121-001P - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		{g ,375"} vessel profile after root welds are complete		QA						
(10)										
*		Magnetic Permeability (1.01 Max)		QA						
(20)										

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P - Item: 26

Workorder: 64880/1-0 Sub:1 Op:70

Part: SE121-001P - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		CWI						
(10)										
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		CWI						
(20)										
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		CWI						
(30)										
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		CWI						
(40)										
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		CWI						
(50)										



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P - Item: 27

Workorder: 64880/1-0 Sub:1 Op:80

Part: SE121-001P - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		{g ,375"} Welded vessel profile		QA						
(10)										
*		Magnetic Permeability (1.01 Max)		QA						
(20)										

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 1 - Item: 32

Workorder: 64880/1-0 Sub:14 Op:10

Part: SE121-001P-2 PANEL 1 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		Magnetic Permeability 1.0 Max. (Panel Blank)		QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581			A
(10)								09-25-03			
*		.375 (+.040/-0) (Panel Blank)		QA		J-160	.412	085			A
(20)								10-02-03			
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)		QA		VISUAL	GOOD	085			A
(30)								10-02-03			



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 1 - Item: 33

Workorder: 64880/1-0 Sub:14 Op:35

Part: SE121-001P-2 PANEL 1 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

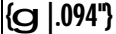
Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY OF ANNEALE		QA		J-1143	1.008-1.009	522		
(10)		1.01 MAX						10-29-03		

A

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 1 - Item: 34

Workorder: 64880/1-0 Sub:14 Op:70

Part: SE121-001P-2 PANEL 1 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
(10)		Magnetic Permeability 1.01 Max								
*				QA						
(20)		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)								
*				QA						
(30)		 .094" .094" Max Gap (Part Surface To gauge)		ENG						

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 2 - Item: 39

Workorder: 64880/1-0 Sub:15 Op:10

Part: SE121-001P-2 PANEL 2 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		Magnetic Permeability 1.0 Max. (Panel Blank)		QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581			A
(10)								09-25-03			
*		.375 (+.040/-0) (Panel Blank)		QA		J-160	.405	085			A
(20)								10-02-03			
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)		QA		VISUAL	GOOD	085			A
(30)								10-02-03			



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 2 - Item: 40

Workorder: 64880/1-0 Sub:15 Op:35

Part: SE121-001P-2 PANEL 2 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

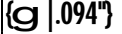
Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY OF ANNEALE		QA						
(10)		1.01 MAX								

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 2 - Item: 41

Workorder: 64880/1-0 Sub:15 Op:70

Part: SE121-001P-2 PANEL 2 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
(10)		Magnetic Permeability 1.01 Max								
*				QA						
(20)		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)								
*				QA						
(30)		 .094" .094" Max Gap (Part Surface To gauge)		ENG						

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 3 - Item: 46

Workorder: 64880/1-0 Sub:16 Op:10

Part: SE121-001P-2 PANEL 3 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		Magnetic Permeability 1.0 Max. (Panel Blank)		QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581			A
(10)								09-25-03			
*		.375 (+.040/-0) (Panel Blank)		QA		J-160	.381	085			A
(20)								10-02-03			
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)		QA		VISUAL	GOOD	085			A
(30)								10-02-03			



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 3 - Item: 47

Workorder: 64880/1-0 Sub:16 Op:35

Part: SE121-001P-2 PANEL 3 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT


Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY OF ANNEALE		QA						
(10)		1.01 MAX								

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 3 - Item: 48

Workorder: 64880/1-0 Sub:16 Op:70

Part: SE121-001P-2 PANEL 3 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
(10)		Magnetic Permeability 1.01 Max								
*				QA						
(20)		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)								
*				QA						
(30)		 .094" .094" Max Gap (Part Surface To gauge)		ENG						

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 4 - Item: 53

Workorder: 64880/1-0 Sub:17 Op:10

Part: SE121-001P-2 PANEL 4 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		Magnetic Permeability 1.0 Max. (Panel Blank)		QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581			A
(10)								09-25-03			
*		.375 (+.040/-0) (Panel Blank)		QA		J-160	.396	085			A
(20)								10-02-03			
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)		QA		VISUAL	GOOD	085			A
(30)								10-02-03			



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 4 - Item: 54

Workorder: 64880/1-0 Sub:17 Op:35

Part: SE121-001P-2 PANEL 4 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY OF ANNEALE		QA						
(10)		1.01 MAX								

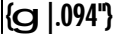


INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 4 - Item: 55

Workorder: 64880/1-0 Sub:17 Op:70

Part: SE121-001P-2 PANEL 4 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
(10)		Magnetic Permeability 1.01 Max								
*				QA						
(20)		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)								
*				QA						
(30)		 .094" .094" Max Gap (Part Surface To gauge)		ENG						

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 5 - Item: 60

Workorder: 64880/1-0 Sub:18 Op:10

Part: SE121-001P-2 PANEL 5 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		Magnetic Permeability 1.0 Max. (Panel Blank)		QA		J-1143	TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581			A
(10)								09-25-03			
*		.375 (+.040/-0) (Panel Blank)		QA		J-160	.415	085			A
(20)								10-02-03			
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)		QA		VISUAL	GOOD	085			A
(30)								10-02-03			



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 5 - Item: 61

Workorder: 64880/1-0 Sub:18 Op:35

Part: SE121-001P-2 PANEL 5 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY OF ANNEALE		QA						
(10)		1.01 MAX								

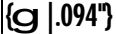


INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-2 PANEL 5 - Item: 62

Workorder: 64880/1-0 Sub:18 Op:70

Part: SE121-001P-2 PANEL 5 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
(10)		Magnetic Permeability 1.01 Max								
*				QA						
(20)		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)								
*				QA						
(30)		 .094" .094" Max Gap (Part Surface To gauge)		ENG						



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-3 - Item: 65

Workorder: 64880/1-0 Sub:29 Op:10

Part: SE121-001P-3 - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-002P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA			MAX. RECORDING OF P ERM. OF PLATE 1.002 , 12 PLCS. RANDOMLY CHECKED.	581		
(10)		MAGNETIC PERMEABILITY 1.01 MAX						09-17-03		

A



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-3 - Item: 66

Workorder: 64880/1-0 Sub:29 Op:30

Part: SE121-001P-3 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-002P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY 1.01 MAX (AFTER ROLLING / PRIOR TO WELDING)		QA			21 RANDOM LOCATION , HIGH=1.007, LOW=1 .006	581 09-22-03		

A



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-3 - Item: 67

Workorder: 64880/1-0 Sub:29 Op:50

Part: SE121-001P-3 - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		CWI						
(10)										
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		CWI						
(20)										
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		CWI						
(30)										
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		CWI						
(40)										
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		CWI						
(50)										



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-001P-3 - Item: 68

Workorder: 64880/1-0 Sub:29 Op:70

Part: SE121-001P-3 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121 Rev: --		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		32 MICRO-INCH RA SURFACE FINISH (PORT EXTENSION TUBE)		QA						
(10)										
*		MAGNETIC PERMEABILITY 1.01 MAX (PORT EXTENSION TUBE)		QA						
(20)										



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-003P - Item: 76

Workorder: 64880/1-0 Sub:1 Op:90

Part: SE121-003P - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-002P Rev: --		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		CWI						
(10)										
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		CWI						
(20)										
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		CWI						
(30)										
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		CWI						
(40)										
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		CWI						
(50)										

Quality Assurance Documentation for Part ID: SE121-003P - Item: 77

Workorder: 64880/1-0 Sub:1 Op:100

Part: SE121-003P - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-002P Rev: --		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		{g ,375"} Profile at / near Port Extension		QA						
(10)										
*		Magnetic Permeability (1.01 Max) (Port Stub / Port Extension)		QA						
(20)										
*		32 MICRO-INCH RA SURFACE FINISH (PORT EXTENSION INTERIOR)		QA						
(30)										



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-003P - Item: 78

Workorder: 64880/1-0 Sub:1 Op:115

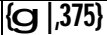

Part: SE121-003P - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-003P Rev: --		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		CWI						
(10)										
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		CWI						
(20)										
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		CWI						
(30)										
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		CWI						
(40)										
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		CWI						
(50)										

Quality Assurance Documentation for Part ID: SE121-003P - Item: 79

Workorder: 64880/1-0 Sub:1 Op:120

Part: SE121-003P - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-003P Rev: --		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability of all Inconel 625 Material And Weld Zones (1.01 Max)		QA						
(10)										
*		Magnetic Permeability of Conflat Flange (1.02 Max)		QA						
(20)										
*		Magnetic Permeability of Weld / Heat Affected Zone (Flange to Tube) (1.2 Max)		QA						
(30)										
*		 ,375 Finished part profile		QA						
(40)										
*		 d.125"p48" A B C Port Extension position (after re-attachment)		QA						
(50)										

Quality Assurance Documentation for Part ID: SE121-003P-4 - Item: 82

Workorder: 64880/1-0 Sub:25 Op:20

Part: SE121-003P-4 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-003P Rev: --		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		CWI						
(10)										
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		CWI						
(20)										
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		CWI						
(30)										
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		CWI						
(40)										
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		CWI						
(50)										



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE121-003P-4 - Item: 83

Workorder: 64880/1-0 Sub:25 Op:40

Part: SE121-003P-4 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-003P Rev: --		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
(10)		MAGNETIC PERMEABILITY 1.01 MAX								
*				QA						
(20)		CLEANLINESS PER PP475								

Quality Assurance Documentation for Part ID: SE212-003P-3 - Item: 84

Workorder: 64880/1-0 Sub:19 Op:10

Part: SE212-003P-3 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-002P Rev: --		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		CWI						
(10)										
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		CWI						
(20)										
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		CWI						
(30)										
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		CWI						
(40)										
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		CWI						
(50)										

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE212-003P-3 - Item: 85

Workorder: 64880/1-0 Sub:19 Op:20

Part: SE212-003P-3 - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-002P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		32 Micro Surface Finish (Interior)		QA						
(10)										
*		1.2 Max Magnetic Permeability (Flange To Tube)		QA						
(20)										