

PPPL NCSX PVVS INSPECTION PLAN


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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Verify Panel Joint Alignment (.02" Max)	VISUAL INSPECTION	MFG CWI						
*		Verify Panel / Rest Stop Position (0 - .09" Gap)	FEELER GAGE	MFG CWI						


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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .188" Upper Half Of Bilateral Tolerance (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max.		QA						

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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

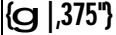
Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .375" vessel profile after root welds are complete	SMX	QA						
*		Magnetic Permeability (1.01 Max)		QA						

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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

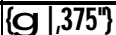
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PPPL NCSX PVVS INSPECTION PLAN

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

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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

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

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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121 Rev: A			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						
*		Magnetic Permeability of Conflat Flange (1.02 Max)		QA						
*		Magnetic Permeability of Weld / Heat Affecte ne (Flange to Tube) (1.2 Max)		QA						

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PPPL NCSX PVVS INSPECTION PLAN

*		(g ,375) Finished part profile		QA					
*		(# d.125"p48" A B C) Port Extension position (after re-attachment)		QA					

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

Part: - - SE121-001P-2 PANEL # 1

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Mag. Permeability Of Raw Plate As Rec'D / Prior To Processing (Record Range)	PERMEABILITY GAG	QA						
				ENG						

Workorder: 64880/1-0 Sub:14 Op:15

Part: - - SE121-001P-2 PANEL # 1

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max. (Panel Blank)	PERMEABILITY GAG	QA						
Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		.375 (tolerance tbd)		QA						
		SURFACE FINISH PER ASTM B 443	PROFILOMETER	QA						

Workorder: 64880/1-0 Sub:14 Op:20

Part: - - SE121-001P-2 PANEL # 1

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT

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PPPL NCSX PVVS INSPECTION PLAN

1*		.08" Max Gap (Part Surface To gauge) (prior to anneal / re-strike)	FEELER GAGE	MFG QA						
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Workorder: 64880/1-0 Sub:14 Op:35

Part: - - SE121-001P-2 PANEL # 1

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

Workorder: 64880/1-0 Sub:14 Op:40

Part: - - SE121-001P-2 PANEL # 1

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG ENG						

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

Part: - - SE121-001P-2 PANEL # 1

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	MFG						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						

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 .08"} .08" Max Gap (Part Surface To gauge)		QA ENG						

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PPPL NCSX PVVS INSPECTION PLAN

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

Part: - - SE121-001P-2 PANEL # 2

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Mag. Permeability Of Raw Plate As Rec'D / Prior To Processing (Record Range)	PERMEABILITY GAG	QA						
				ENG						

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

Part: - - SE121-001P-2 PANEL # 2

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max. (Panel Blank)	PERMEABILITY GAG	QA						
Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		.375 (tolerance tbd)		QA						
		SURFACE FINISH PER ASTM B 443	PROFILOMETER	QA						

Workorder: 64880/1-0 Sub:15 Op:20

Part: - - SE121-001P-2 PANEL # 2

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1*		.08" Max Gap (Part Surface To gauge) (prior to anneal / re-strike)	FEELER GAGE	MFG						
				QA						

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

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PPPL NCSX PVVS INSPECTION PLAN

Part: - - SE121-001P-2 PANEL # 2

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

Workorder: 64880/1-0 Sub:15 Op:40

Part: - - SE121-001P-2 PANEL # 2

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG ENG						

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

Part: - - SE121-001P-2 PANEL # 2

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	MFG						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		.08" Max Gap (Part Surface To gauge)		QA ENG						

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

Part: - - SE121-001P-2 PANEL # 3

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			PERMEABILITY GAG	QA						

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PPPL NCSX PVVS INSPECTION PLAN

	Mag. Permeability Of Raw Plate As Rec'D / Prior To Processing (Record Range)		ENG						
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Workorder: 64880/1-0 Sub:16 Op:15

Part: - - SE121-001P-2 PANEL # 3

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max. (Panel Blank)	PERMEABILITY GAG	QA						
Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		.375 (tolerance tbd)		QA						
		SURFACE FINISH PER ASTM B 443	PROFILOMETER	QA						

Workorder: 64880/1-0 Sub:16 Op:20

Part: - - SE121-001P-2 PANEL # 3

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1*		.08" Max Gap (Part Surface To gauge) (prior to anneal / re-strike)	FEELER GAGE	MFG QA						

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

Part: - - SE121-001P-2 PANEL # 3

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

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Workorder: 64880/1-0 Sub:16 Op:40

Part: - - SE121-001P-2 PANEL # 3

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG ENG						

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

Part: - - SE121-001P-2 PANEL # 3

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

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

Part: - - SE121-001P-2 PANEL # 4

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Mag. Permeability Of Raw Plate As Rec'D / Prior To Processing (Record Range)	PERMEABILITY GAG	QA ENG						

Workorder: 64880/1-0 Sub:17 Op:15

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Part: - - SE121-001P-2 PANEL # 4

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max. (Panel Blank)	PERMEABILITY GAG	QA						
Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		.375 (tolerance tbd)		QA						
		SURFACE FINISH PER ASTM B 443	PROFILOMETER	QA						

Workorder: 64880/1-0 Sub:17 Op:20

Part: - - SE121-001P-2 PANEL # 4

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1*		.08" Max Gap (Part Surface To gauge) (prior to anneal / re-strike)	FEELER GAGE	MFG QA						

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

Part: - - SE121-001P-2 PANEL # 4

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

Workorder: 64880/1-0 Sub:17 Op:40

Part: - - SE121-001P-2 PANEL # 4

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT

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PPPL NCSX PVVS INSPECTION PLAN

1		.08" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG ENG						
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Workorder: 64880/1-0 Sub:17 Op:70

Part: - - SE121-001P-2 PANEL # 4

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

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

Part: - - SE121-001P-2 PANEL # 5

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Mag. Permeability Of Raw Plate As Rec'D / Prior To Processing (Record Range)	PERMEABILITY GAG	QA ENG						

Workorder: 64880/1-0 Sub:18 Op:15

Part: - - SE121-001P-2 PANEL # 5

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max. (Panel Blank)	PERMEABILITY GAG	QA						

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Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		.375 (tolerance tbd)		QA						
		SURFACE FINISH PER ASTM B 443	PROFILOMETER	QA						

Workorder: 64880/1-0 Sub:18 Op:20

Part: - - SE121-001P-2 PANEL # 5

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1*		.08" Max Gap (Part Surface To gauge) (prior to anneal / re-strike)	FEELER GAGE	MFG						
				QA						

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

Part: - - SE121-001P-2 PANEL # 5

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

Workorder: 64880/1-0 Sub:18 Op:40

Part: - - SE121-001P-2 PANEL # 5

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG						
				ENG						

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

Part: - - SE121-001P-2 PANEL # 5

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

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

Part: - - SE121 PORT SUB-ASSEMBLY

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		32 Micro Surface Finish (Interior)	PROFILOMETER	QA						
		1.2 Max Magnetic Permeability (Flange To Tube)	PERMEABILITY GAG	QA						

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

Part: - - PORT EXTENSION WELD BACKING RING

Drawing ID: SE121 Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY 1.01 MAX	ULTRASONIC THICK	QA						

Workorder: 64880/1-0 Sub:26 Op:10

Part: - - SE121-001P-2 TEST PANEL

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
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PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Mag. Permeability Of Raw Plate As Rec'D / Prior To Processing (Record Range)	PERMEABILITY GAG	QA ENG						

Workorder: 64880/1-0 Sub:26 Op:15

Part: - - SE121-001P-2 TEST PANEL

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max.	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:26 Op:20

Part: - - SE121-001P-2 TEST PANEL

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1*		.08" Max Gap (Part Surface To gauge) (prior to anneal / re-strike)	FEELER GAGE	MFG QA						

Workorder: 64880/1-0 Sub:26 Op:35

Part: - - SE121-001P-2 TEST PANEL

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

Workorder: 64880/1-0 Sub:26 Op:40

Part: - - SE121-001P-2 TEST PANEL

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
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NOTE: the recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, title 18, chapter 47.

PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG ENG						

Workorder: 64880/1-0 Sub:26 Op:70

Part: - - SE121-001P-2 TEST PANEL

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

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

Part: - - PORT EXTENSION TUBE (TAKE 2)

Drawing ID: SE121 Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		MAGNETIC PERMEABILITY 1.01 MAX		QA						

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

Part: - - PORT EXTENSION TUBE (TAKE 2)

Drawing ID: SE121 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)	PERMEABILITY GAG	QA						

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PPPL NCSX PVVS INSPECTION PLAN

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

Part: - - PORT EXTENSION TUBE (TAKE 2)

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)	PROFILOMETER	QA						
*		MAGNETIC PERMEABILITY 1.01 MAX (PORT EXTENSION TUBE)	PERMEABILITY GAG	QA						

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