

PVVS PRELIMINARY 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 INSPECTIO	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	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" Preliminary Welding Under Stiffeners	SMX	QA						
		Magnetic Permeability (1.01 Max)		QA						

Workorder: 64880/1-0 Sub:1 Op:60

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

**PVVS PRELIMINARY 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
		G  ,375) After Welding Stiffeners	SMX	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 Inconel 625 Material Weld Zones (1.01 Max)		QA						
		Magnetic Permeability of Conflat Flange (1.0 Max)		QA						
		Magnetic Permeability of Weld / Heat Affected Zone (Flange to Tube) (1.2 Max)		QA						

Workorder: 64880/1-0 Sub:3 Op:30

**Part: - - LEAVE UNRELEASED!!!! SE121-001P-3 & -4 INTERIOR STIFFENERS**

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)		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		QA						

**PVVS PRELIMINARY INSPECTION PLAN**

	As Rec'D / Prior To Processing (Record Range)		ENG						
	Mag. Permeability Of Panel After Cutting And Cleanup (Record Range)		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.		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
1		.08" Max Gap (Part Surface To Standard)	FEELER GAGE	MFG ENG						

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

**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
1		.08" Max Gap (Part Surface To Standard)	FEELER GAGE	MFG ENG						

**Workorder: 64880/1-0 Sub:14 Op:60**

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
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**PVVS PRELIMINARY INSPECTION PLAN**

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		.08" Max Gap (Panel / Profile Gage)	FEELER GAGE	QA 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		MFG						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						

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.		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 Standard)	FEELER GAGE	MFG ENG						

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
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**PVVS PRELIMINARY INSPECTION PLAN**

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

Workorder: 64880/1-0 Sub:15 Op:60

**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
		.08" Max Gap (Panel / Profile Gage)	FEELER GAGE	QA 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		MFG						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						

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.		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		
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**PVVS PRELIMINARY INSPECTION PLAN**

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

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

**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 Standard)	FEELER GAGE	MFG ENG						

Workorder: 64880/1-0 Sub:16 Op:60

**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
		.08" Max Gap (Panel / Profile Gage)	FEELER GAGE	QA 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		MFG						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						

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

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

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

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max.		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 Standard)	FEELER GAGE	MFG ENG						

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

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 Standard)	FEELER GAGE	MFG ENG						

Workorder: 64880/1-0 Sub:17 Op:60

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
		.08" Max Gap (Panel / Profile Gage)	FEELER GAGE	QA ENG						

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		MFG						

**PVVS PRELIMINARY INSPECTION PLAN**

		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
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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.		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 Standard)	FEELER GAGE	MFG ENG						

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

**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 Standard)	FEELER GAGE	MFG ENG						

Workorder: 64880/1-0 Sub:18 Op:60

**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
		.08" Max Gap (Panel / Profile Gage)	FEELER GAGE	QA ENG						



**PVVS PRELIMINARY INSPECTION PLAN**

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

**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		MFG						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						

**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)		QA						

**Workorder: 64880/1-0 Sub:21 Op:20**

**Part: - - PORT EXTENSION TUBE**

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 1.02 Max		QA						

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

**Part: - - WELD DISTORTION TESTING**

**PVVS PRELIMINARY 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
		Magnetic Permeability Of Plate Prior To Cutting (1.01 Max)		QA						
		Magnetic Permeability Of Plate After Cutting (1.01 Max)		QA						

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

**Part: - - WELD DISTORTION TESTING**

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 Weld Zone (1.01		QA						
		Magnetic Permeability Of Heat Affected Zon 01 Max)		QA						