ID	Task Name	Duration		December				January
1	Kick-off Meeting	1 day	23 24 25 26 27 28 29 30	1 2 3 4 5 6	7 8 9 10 11 12 13 1	14 15 16 17 18 19 20	21 22 23 24 25 26 27 28 29 30 31	1 2 3 4 5 6 7 8
2	Forming Evaluation	7 days		<u> </u>				
4	Generate BOM for die rib assemblies and PVVS Segments and Order     Buterial Delivery for Die Enclosures and PVVS Segments	1 day 30 days						
5	1.9 Fabricate Die A Rib Assembly	33.5 days				1.9 Fabricate D	ie A Rib Assembly	
6	1.9.3 5 axis waterjet cut die ribs for Die A 1.9.7 Inspection of Die Ribs using CMM	19 days 6 days						
8	Drill and Tap Holes in Die Ribs	3 days						
9	1.9.8 Machine complete 3 wall enclosure for Die A	6 days						
10	Machine Rib Reinforcements/Braces for Die A  1.9.14 Assemble die and inspect	2 days 2 days						
12	1.9.17 Lightly tack weld Scab plate, test form, inspect, full tack/plug weld and inspect	2 days						
13	1.9.23 locate/place ref points on die rib assembly	0.5 days						
15	1.9.24 Final Machine precision locking device for press  1.10 Form Segment A	1 day 9.5 days						
16	1.10.1 Plasma Cut to Pre-cut Segment Oversized	1 day						
17	1.10.3 Form Segment and stress relieve with Male / Female Die Inspect Segment using CMM	2 days 1 day						
19	1.10.5 Locate and Place Ref points on segment with CMM	1 day						
20	1.10.7 Stress Relieve if Necessary	1 day						
21	Scribe/Mark Segment Edges using CMM/Model and machine to size     1.10.12 Inspect with CMM and Inspect Segment Thickness	1 day 0.5 days						
23	Machine to size	2 days						
24	1.11 Repeat 1.9 and 1.10 for segment B	23.5 days						
25 26	Order Die Enclosure Material and cut to rough size  1.9.3 5 axis wateriet cut die ribs for Die B	5 days 10 days						
27	1.9.7 Inspection of Die Ribs using CMM	3 days						
28	Drill and Tap Holes in Die Ribs	3 days						
30	1.9.8 Machine complete 3 wall enclosure for Die B     Machine Rib Reinforcements/Braces for Die B	6 days						
31	1.9.14 Assemble die and inspect	2 days						
32	1.9.17 Lightly tack weld Scab plate, test form, inspect, full tack/plug weld and inspect     1.9.23 locate/place ref points on die rib assembly	2 days						
34	1.9.24 Final Machine precision locking device for press	0.5 days 1 day						
35	1.11 Repeat 1.9 and 1.10 for segment C	15.5 days						
36	1.9.3 5 axis waterjet cut die ribs for Die C  1.9.7 Inspection of Die Ribs using CMM	5 days 1 day						
38	Drill and Tap Holes in Die Ribs	3 days						
39	1.9.8 Machine complete 3 wall enclosure for Die C	6 days						
40	Machine Rib Reinforcements/Braces for Die C 1.9.14 Assemble die and inspect	1 day 2 days						
42	1.9.17 Lightly tack weld Scab plate, test form, inspect, full tack/plug weld and inspect	2 days						
43	1.9.23 locate/place ref points on die rib assembly	0.5 days						
44	1.9.24 Final Machine precision locking device for press 1.10 Form Segment B	1 day 9.5 days						
46	1.10.1 Plasma Cut to Pre-cut Segment Oversized	1 day						
47	1.10.3 Form Segment and stress relieve with Mail/Female Die	2 days						
48	Inspect Segment using CMM  1.10.5 Locate and Place Ref points on segment with CMM	1 day						
50	1.10.7 Stress Relieve if Necessary	1 day						
51 52	1.10.8 Scribe/Mark Segment Edges using CMM/Model and machine to size     1.10.12 Inspect with CMM and Inspect Segment Thickness	1 day 0.5 days						
53	Machine to size	2 days						
54	1.10 Form Segment C	9.5 days						
55 56	1.10.1 Plasma Cut to Pre-cut Segment Oversized     1.10.3 Form Segment and stress relieve with Mail/Female Die	1 day 2 days						
57	Inspect Segment using CMM	1 day						
58	1.10.5 Locate and Place Ref points on segment with CMM	1 day						
60	Stress Relieve if Necessary     Scribe/Mark Segment Edges using CMM/Model and machine to size	1 day						
61	1.10.12 Inspect with CMM and Inspect Segment Thickness	0.5 days						
62	Machine to size	2 days						
	Assemble Jigs and Figuring for Assembly  Weld Segments	2 days 5 days						
65	2.4 Mount A and B Segments together, inspect then tack , then inspect with CMM	1 day						
66	2.10 Full weld of segments     2.10 Inspect weld, inspect with CMM, grind welds and polish	1 day						
68	2.14 Inspect with CMM for distortion	1 day						
69 70	Weld Segment C in place	1 day						
71	Z.15 Clean and Surface Finish , and inspect     Machine port extension tube	1 day						
	3.9 Mount and tack weld tube and inspect before full weld	0.5 days						
73	3.19 Install and inspect flange then leak check 3.26 Cut off port extension and inspect	0.5 days 0.5 days						
75	3.28 Cut hole in PVVS and inspect	0.5 days						
	3.32 Stitch weld port reinforcement and port extension and inspect	0.5 days						
77	PVVS final inspections	1 day						
79	Parallel Port Process Development project	26 days						
80	Purchase Material for skin Purchase material for port	7 days						
82	Purchase material for port  Locate 2 axis bending	8 days 6 days						
83	Press	4 days						
84 85	Digitize with Faro Fab Port	2 days 3 days						
86	Digitize Port	1 day						
87	Design of Off-normal configurations (port to surface)	3 days						
88 89	Develop model of port  Weld port to surface	2 days 4 days						
90	design/build fixturing	2 days						
91	check location with Faro Arm prior to Weld	1 day						
92	weld Inspect configuration	1 day						
94	Cut/remove port per procedure	3 days						
Project: 03-8083 schedule Task Project Summary Rolled Up Spitk Rolled Up Progress Project Summary External Milestone Date: Sun 1/25/04 Spit Milestone Rolled Up Milestone Rolled Up Milestone Milestone Rolled Up Milestone Rolled								
Date:	Split Mestone	Rolled Up Task	Rolled Up I		External Tasks	External Milestone	Deadine	
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