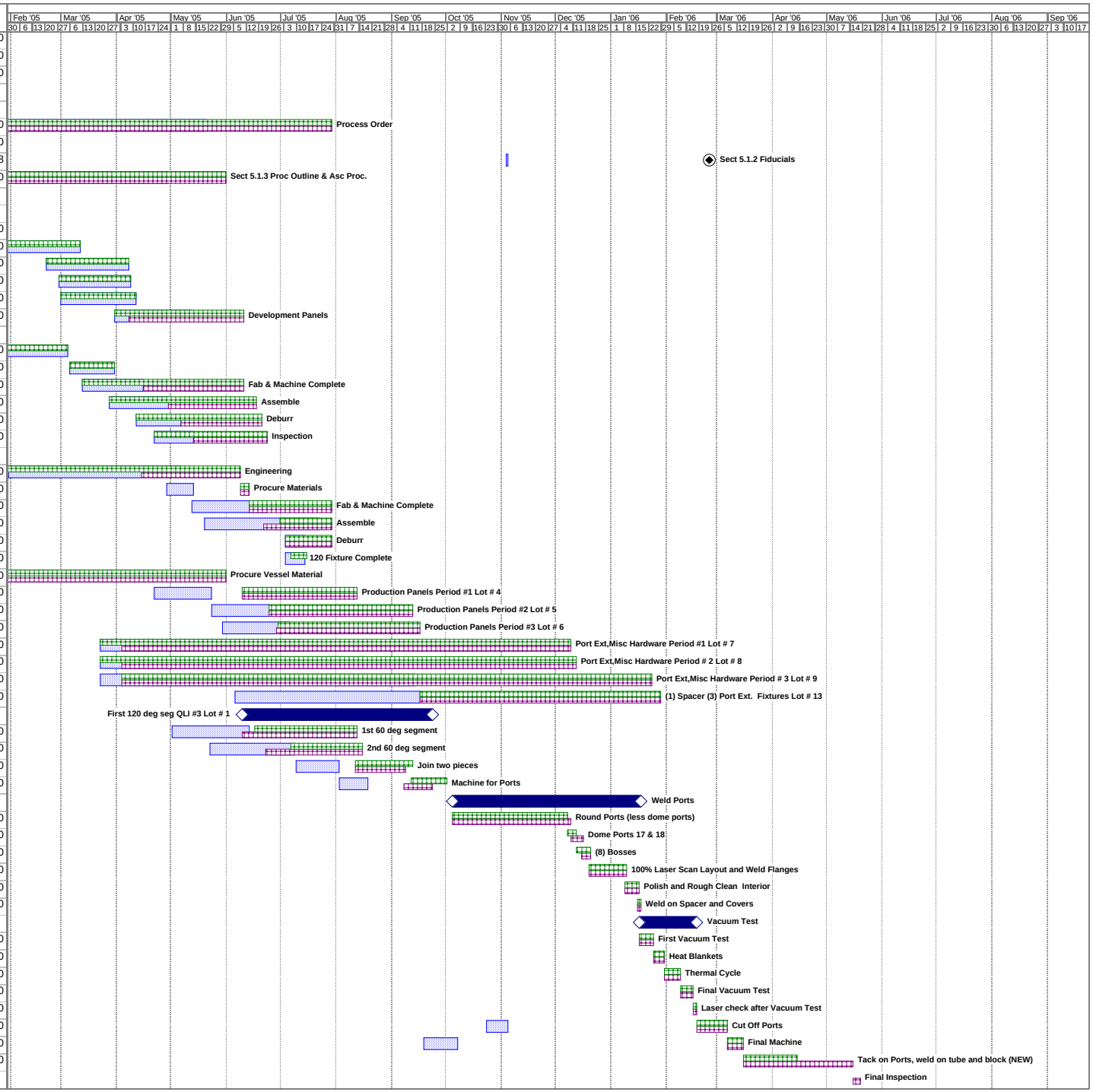
NCSX VVSA for PPPL
Subcontract S005243-F
MTM WO# 65678

ID	Task Name	% Comp
1	Submit Proposal	100
2	Teleconference to discuss Proposal	100
3	Receive Order	100
4	**WO# 65678 PPPL VVSA Lot # 14**	
5	**Start Up/Engineering QLI#1**	
6	Process Order	100
7	Sect 5.1 Segmentation Scheme	100
8	Sect 5.1.2 Fiducials	98
9	Sect 5.1.3 Proc Outline & Asc Proc.	100
10	**Special Tooling QLI# 2**	
11	**Dies & Gages Lot # 10**	
12	Engineering	100
13	Procure Materials	100
14	Machine Complete	100
15	Deburr	100
16	Inspection	100
17	Development Panels	100
18	**Fixtures (2) 60 degree Lot # 11**	
19	Engineering	100
20	Procure Materials	100
21	Fab & Machine Complete	100
22	Assemble	100
23	Deburr	100
24	Inspection	100
25	**Fixture (3) 120 degree Lot # 12**	
26	Engineering	100
27	Procure Materials	100
28	Fab & Machine Complete	100
29	Assemble	100
30	Deburr	100
31	Inspection	100
32	Procure Vessel Material	100
33	Production Panels Period #1 Lot # 4	100
34	Production Panels Period #2 Lot # 5	100
35	Production Panels Period #3 Lot # 6	100
36	Port Ext,Misc Hardware Period #1 Lot # 7	100
37	Port Ext,Misc Hardware Period # 2 Lot # 8	100
38	Port Ext,Misc Hardware Period # 3 Lot # 9	100
39	(1) Spacer (3) Port Ext. Fixtures Lot # 13	100
40	**First 120 deg seg QLI #3 Lot # 1**	
41	1st 60 deg segment	100
42	2nd 60 deg segment	100
43	Join two pieces	100
44	Machine for Ports	100
45	**Weld Ports**	
46	Round Ports (less dome ports)	100
47	Dome Ports 17 & 18	100
48	(8) Bosses	100
49	100% Laser Scan Layout and Weld Flanges	100
50	Polish and Rough Clean Interior	100
51	Weld on Spacer and Covers	100
52	**Vacuum Test**	
53	First Vacuum Test	100
54	Heat Blankets	100
55	Thermal Cycle	100
56	Final Vacuum Test	100
57	Laser check after Vacuum Test	100
58	Cut Off Ports	100
59	Final Machine	100
60	***Tack on Ports, weld on tube and block (NEW)***	40
61	Final Inspection	

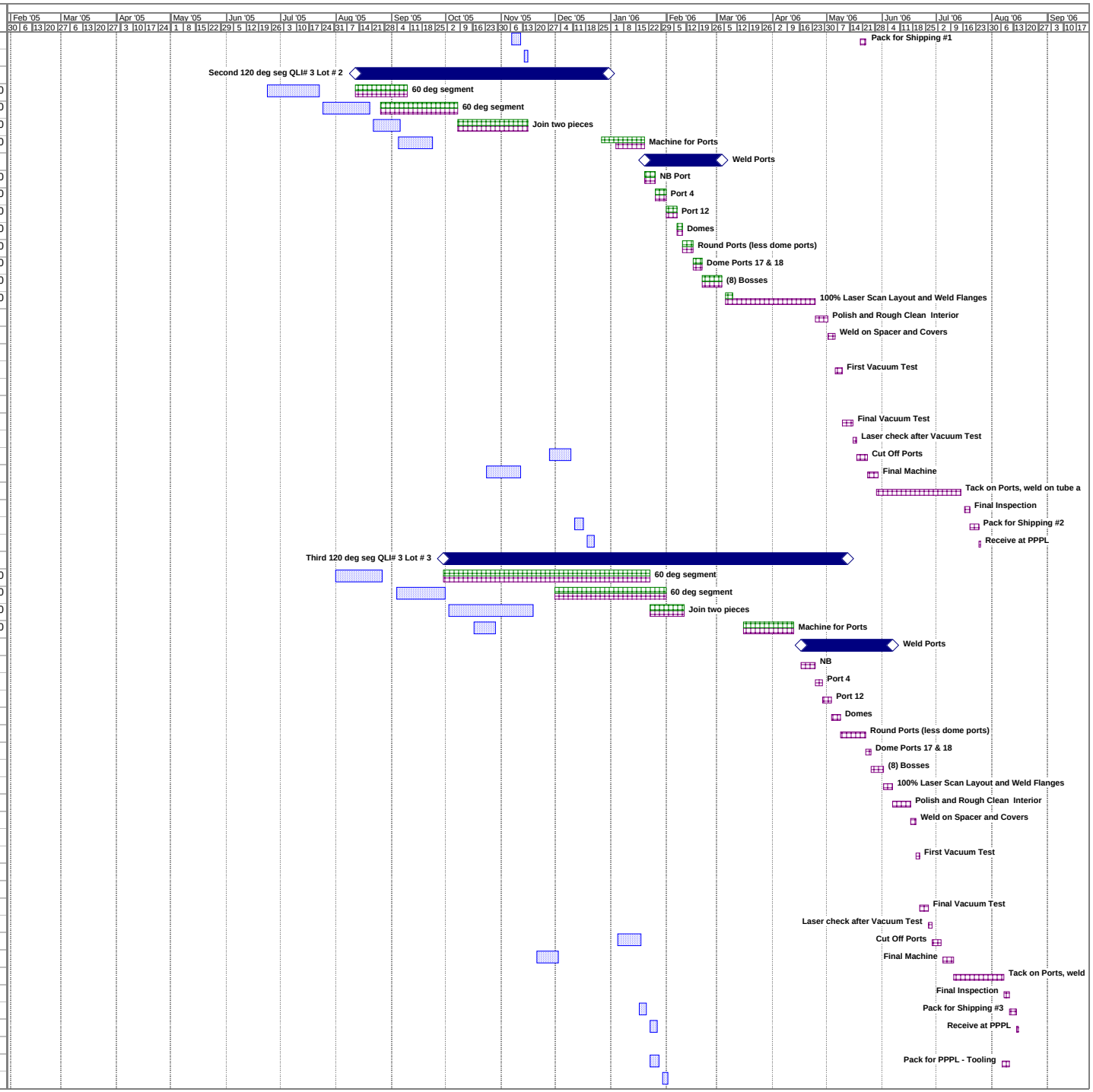


Summary Contract Milestone Planned Completed

Mike Manuel
April 14 2006

NCSX VVSA for PPPL
Subcontract S005243-F
MTM WO# 65678

ID	Task Name	% Comp
62	Pack for Shipping #1	
63	Receive at PPPL	
64	**Second 120 deg seg QLI# 3 Lot # 2**	
65	60 deg segment	100
66	60 deg segment	100
67	Join two pieces	100
68	Machine for Ports	100
69	**Weld Ports**	
70	NB Port	100
71	Port 4	100
72	Port 12	100
73	Domes	100
74	Round Ports (less dome ports)	100
75	Dome Ports 17 & 18	100
76	(8) Bosses	100
77	100% Laser Scan Layout and Weld Flanges	20
78	Polish and Rough Clean Interior	
79	Weld on Spacer and Covers	
80	**Vacuum Test**	
81	First Vacuum Test	
82	Heat Blankets (deleted)	
83	Thermal Cycle (deleted)	
84	Final Vacuum Test	
85	Laser check after Vacuum Test	
86	Cut Off Ports	
87	Final Machine	
88	***Tack on Ports, weld on tube and block (NEW)***	
89	Final Inspection	
90	Pack for Shipping #2	
91	Receive at PPPL	
92	**Third 120 deg seg QLI# 3 Lot # 3**	
93	60 deg segment	100
94	60 deg segment	100
95	Join two pieces	100
96	Machine for Ports	100
97	**Weld Ports**	
98	NB	
99	Port 4	
100	Port 12	
101	Domes	
102	Round Ports (less dome ports)	
103	Dome Ports 17 & 18	
104	(8) Bosses	
105	100% Laser Scan Layout and Weld Flanges	
106	Polish and Rough Clean Interior	
107	Weld on Spacer and Covers	
108	**Vacuum Test**	
109	First Vacuum Test	
110	Heat Blankets (deleted)	
111	Thermal Cycle (deleted)	
112	Final Vacuum Test	
113	Laser check after Vacuum Test	
114	Cut Off Ports	
115	Final Machine	
116	***Tack on Ports, weld on tube and block (NEW)***	
117	Final Inspection	
118	Pack for Shipping #3	
119	Receive at PPPL	
120	**Tooling Deliveries**	
121	Pack for PPPL - Tooling	
122	Receive at PPPL - Tooling	



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