

NCSX Project Team Meeting: July 30, 2008



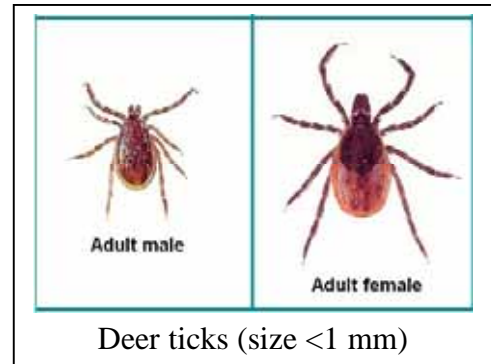
- Safety Minute
- Interactions with DOE
- 3-week look-ahead



Preventing Tick-Borne Illnesses

Ticks can transmit a range of diseases to humans, e.g., Lyme disease, Ehrlichiosis, Babesiosis, and Rocky Mountain spotted fever. These can be very serious, leading to long-term effects such as arthritis, or even death. To reduce the risk of contracting these diseases:

1) Reduce exposure to ticks. 2) Recognize early symptoms and seek treatment.



1. Reduce Exposure to Ticks

- Ticks are prevalent in grassy or wooded areas, especially where deer or mice are plentiful. Deer ticks (carriers of Lyme disease) are most prevalent in the Northeast but are spreading west and south.
- Wear long pants and tuck pant legs into your socks. This creates a long path length for ticks to traverse from ground to skin.
- Wear light-colored clothing, making it easier to see ticks crawling on clothes. Wear a hat.
- Apply repellants containing DEET, e.g. Deep Woods Off. Reapply every few hours.
- Conduct a full body check upon returning from tick-infested areas. Remove any ticks.
- To remove attached ticks, grasp as close to skin as possible with tweezers, and pull carefully without twisting. If parts remain attached, dig them out. Thoroughly disinfect the area and wash hands. Save the tick in a plastic bag for possible identification should symptoms develop. Ticks removed within 24 hours are less likely to transmit disease

2. Recognize early symptoms and seek treatment

- Symptoms appear 1-4 weeks after disease transmission.
- Symptoms may be mild, subtle, and easily confused with other conditions such as flu.

Lyme Disease	Ehrlichiosis or Babesiosis
<ul style="list-style-type: none"> • Solid red or bull-eye rash, several inches in diameter, radiating from bite site. (Does not appear in all cases.) • Swelling near bite site. • Generalized ache-iness • Joint pains, chills, fever, fatigue. 	<ul style="list-style-type: none"> • Flu-like symptoms, including: • Fever, severe chills, night sweats, headache • Generalized ache-iness • Nausea

- **If you have a tick-borne disease, it is important to get prompt medical treatment.**
- Diagnosis is difficult and may rely on indirect indicators such as symptoms, blood count profile, liver function. (Definitive tests are only effective several weeks after symptoms develop, which is too late for treatment to start.)
- Treatment is typically with antibiotics.

NCSX - Project Status



- Great praise coming from US and abroad on the completion of the first half-period assembly and VPI of the final modular coil!
- Monthly Integrated Project Team meeting held yesterday with Office of Fusion Energy, and Dan Lehman's Office, and the Princeton Site Office.
 - Engineering change proposal & authorization of closeout work
 - Anticipated budget carryover into FY09
 - Closeout contingency management
 - Closeout report
- July costs to be sent to Job Managers later this week in preparation for monthly status meeting next week.
- W7-X leadership visiting PPPL October 6-7.

Team Mtg July 30, 2008

NCSX Project Office will be responsible for preparing and submitting the Project Closeout Report



7/29/08 DRAFT

National Compact Stellarator Experiment Project Closeout Report

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National Compact Stellarator Experiment Project Closeout Report

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Team Mtg July 30, 2008



Activity ID	Activity Description	Forecast Start	Forecast Finish	% cmlpt	ETC	FY08		FY09											
						J	A	S	O	N	D	J	F	M	A	M	J	J	
Included Closeout Scope																			
Brown																			
Job: 1803/1805- FPA Tooling/Constr-BROWN																			
Station 3-Modular Coil to VVSA Assembly																			
1803S3-4	Generate laser screen trace drawings (1/2 period)	17JUL08A	25JUL08	25	8,016.30														
1803S3-6	Station 3 simulation detail model	02JUN08A	01AUG08	75	5,676.00														
1803S3-9	Oversite, cost and schedules, reviews	31JAN08A	30SEP08	LOE	2,649.42														
1805S3-207	Misc assembly Cost	31JAN08A	30SEP08		3,763.26														
Job: 8203 - Design Integration-BROWN																			
8203FY08-4	General integration activities	01FEB08A	30SEP08	LOE	10,521.38														
Brooks																			
Job: 8204 - Systems Analysis-BROOKS																			
8204-FY08Z	Syst Analysis, studies & tech assurance FY08 etc	02JUN08A	30SEP08	LOE	31,624.75														
Chrzanowski																			
Job: 1408 - MC Winding Supplies-CHRZANOWSKI																			
1408-3	Misc and safety supplies (\$7k/mo.)	23MAY07A	31JUL08	LOE	149.04														
1408-6	VPI clean manifold contract	23MAY07A	31JUL08	80	2,484.00														
1408-8	Cutting hardware for flange bolts	23MAY07A	31JUL08	LOE	273.24														
1408-7	Misc tech shop support	23MAY07A	31JUL08	80	10,108.16														
Job: 1451 - Mod Coil Winding-CHRZANOWSKI																			
Station 1 Post VPI																			
P2-171C	Final Clamps & Warm Test (Station1) B6	02JUN08A	23JUL08	5	22,806.54														
P1-171C	Final Clamps & Warm Test (Station1) A6	24JUL08	29AUG08		24,006.88														
LOE Oversight & Supervision																			
145XSPRV-3	Winding Engineering oversight and supervision	01MAY07A	30SEP08	LOE	31,832.46														
145XSPRV-A	Winding Engineering oversight and supervision	01NOV07A	29AUG08	LOE	56,904.69														
Job: 1459 - Mod Coil Fabr.Punch List-CHRZANOWSKI																			
Punchlist Tech shop/RESA																			
PLTS-B5	Grinding -B5	01MAY08A	30SEP08	0	9,476.40														
PLTS-A6	Grinding -A6	01MAY08A	30SEP08	20	3,095.62														
PLTS-B6	Grinding -B6	01MAY08A	30SEP08	0	9,476.40														
PLTS-C6	Grinding & Drill Holes -C6	01MAY08A	30SEP08	23	14,593.66														
Punchlist- Coil Technicians																			
PLCT-A6	Insul,measure,TC,SG other punch list-A6	01OCT07A	29AUG08	36	10,411.40														
PLCT-B6	Insul,measure,TC,SG other punch list-B6	01OCT07A	29AUG08	36	10,411.40														
Cole																			
Job: 1416 - Mod Coil Type AB Fnl Dsn-COLE																			
Analysis and closeout documentation																			
1416-601	Prepare EM and structural analysis of leads	31JAN08A	30JUL08	70	9,966.00														
1416-650	Prepare cooling analysis of lead area	01JUL08	30JUL08		3,020.00														
ECN Modifications																			
1416-810	Process completed ECN's 5397,5379,5380	28JUL08*	30JUL08		0.00														

Run Date: JUL08 13:17

 FORECAST SCHEDULE
 x target
 Progress Bar
 Critical Activity

080A

NCSX
 MIE CLOSEOUT PLAN
 July 23 status

Sheet 1 of 6

Activity ID	Activity Description	Forecast Start	Forecast Finish	% cmlpt	ETC	FY08			FY09											
						J	A	S	O	N	D	J	F	M	A	M	J	J		
Job: 1421 - Mod Coil Interface Design-COLE																				
Inboard Interface-CC																				
1421-3155	Resolve C-C shim FDR comments	01JUL08*	23JUL08	80	3,624.00	COLE	etc =120hr ;													
Job: 1901 - Stellarator Core Mngtt&Integr-COLE																				
191 - Stellarator Core Management & Oversight																				
1901-08	WBS 191 FY08	01OCT07A	29SEP08	LOE	24,323.08	COLE	etc =121hr ; NELSON etc =70													
1901-9000	Update drawing tree	01OCT07A	29SEP08	LOE	24,160.00	lovett=	160													
192 - Stellarator Core Integr & Global Analysis																				
1902-08	WBS 192 FY08	01OCT07A	29SEP08	LOE	57,388.46	COLE MCGINNIS	etc =121 m&s =20 travel= 10 etc =182													
Job: 1806 - FP Assembly specs and drawings-COLE																				
Station 3-Modular Coil to VVSA Assembly																				
1803-301	Station 3 Assembly Specification	02JUL07A	28JUL08	80	7,248.00	COLE	etc =24hr ;													
1803-305	Station 3 Assembly Drawings	02JUL07A	29JUL08	80	4,832.00	COLE	etc =16hr ;													
Dahlgren																				
Job: 1501 - Coil Structures Design-DAHLGREN																				
1501-533F	Integrated Stress Analysis	01OCT07A	31JUL08	95	6,021.40	DAHLGREN	etc =154hr ; FAN=etc=40													
1501-537	FDR Prep	01JUL08	31JUL08		12,370.68	DAHLGREN	etc =38hr ; RUSHINSKI etc =49h													
1501-541	Coil Support Structures - FDR		31JUL08		0.00															
Ellis																				
Job: 8205 - Dimensional Control Coordin-ELLIS																				
Station 3-Modular Coil to VVSA Assembly																				
METFY08R	Support FPA Station 2	01FEB08A	30SEP08	LOE	11,196.98	ELLIS	etc =45hr ; SMITH etc =45h													
STAT3 PREP	Station 3 preparations	30JUN08A	02SEP08	70	4,250.40	ELLIS	etc =80hr ;													
Harris																				
Job: 8102 - NCSX MIE Management ORNL-HARRIS																				
810.105XX	Project Management Office ORNL FY08 (LOE)	01FEB08A	29SEP08	LOE	75,467.11	ORNL35 HILLIS MMORRIS	etc =07\$; etc =70 ; HARRIS etc =282 etc =176 ;													
810.105Z	Project Management Office ORNL FY09 (LOE)	01OCT08*	31MAR09	LOE	35,930.73	HILLIS HARRIS	etc =45 etc =110													
Heitzenroeder																				
Job: 8202 - Engr Mgmt & Sys Eng Sprt-HEITZENROED																				
8205DC	document control & admin support	01FEB08A	31MAR09	LOE	21,307.22	SUCH TYRELL	etc =142hr etc =21													
8205FY08.2	Engr mgt & systems engr FY08	01FEB08A	30SEP08	LOE	136,471.75	HEITZENROED REIERSEN VONHALLE	etc =445hr ; SIMMONS etc =00 etc =89hr ; DUDEK etc =474 etc =89hr ;													
8205FY09	Engr mgt & systems engr FY09	01OCT08*	31MAR09	LOE	157,899.44	HEITZENROED REIERSEN VONHALLE SIMMONS DUDEK	etc = etc = etc = etc =333													
Job: 8221 -Documentation Closeout-HEITZENROEDER																				
Closeout Documentation																				
8221-100	Technical data collection	14JUL08*	12NOV08		629,463.19	SIMMONS BROOKS CHRZANOWSKI DAHLGREN DUDEK GORANSON Phil langish Perry rushinski sichta strykowsky viola Nelson Jun	=160hr =100hr =168hr =40hr =32hr =80hr =160; =24 =16; =335 =80; =160; =158 =100;													
8221-251	Tech presentation/paper collection	14JUL08*	09OCT08		9,966.00	HAMPTON	BLANCHARD =40 BROWN =375 COLE =80 DODSON =40h ELLIS =40 Fogarty= 80 Kalish =56; labik =40; freudenberg =120 Raki =16 (etc= mike morris=20 smith = 14; upcavage =215 Moon=10 Harris= 20; Gentile=20; Lew Morris=335 etc =10													

Activity ID	Activity Description	Forecast Start	Forecast Finish	% cmplt	ETC	FY08			FY09											
						J	A	S	O	N	D	J	F	M	A	M	J	J		
8221-301	Guidance to collect data	02JUN08A	29SEP08		39,847.50				SIMMONS	etc =300hr ;										
8221-305	Organizing and posting data	30SEP08	27MAR09		56,203.18										SIMMONS	etc =3				
8221-401	Finalizing and archiving key analyses/reports	14JUL08*	30SEP08		137,504.00				FREUDENBERG	etc =160hr ; DAHLGREN etc =1										
									FAN	etc =160hr ; AVASARALA etc =16										
									ZHANG	etc =160hr ;										
8221-575	Archiving doc & files in ops center	14JUL08*	26MAR09		18,108.37									SUCH	etc =200					
8221-700	As-built Drawing Updates	01AUG08*	23DEC08		233,941.28										EA/SB Designers etc =1995hr ;					

Kalish

Job: 1361 - TF Fabrication-KALISH

TF Title III and Fabrication Oversight

131-033C	Title III engr,inspection, support	02JAN08A	18SEP08	LOE	28,562.95				KALISH	etc =71hr ; 35etc =02\$K ;						
									41etc =00\$K ; EM//TB	etc =00hr ;						
									MEIGHAN	etc =173hr ;						

TF Fabrication Contract

1361C-115	Fab, Test & Deliver Coil #15	17JUL08*	31JUL08		47,220.00				49etc =47 ;							
1361C-116	Fab, Test & Deliver Coil #16	22AUG08*	22AUG08		47,220.00				49etc =47 ;							
1361C-117	Fab, Test & Deliver Coil #17	15SEP08*	15SEP08		47,220.00				49etc =47 ;							
1361C-118	Fab, Test & Deliver Coil #18	30SEP08*	30SEP08		47,220.00				49etc =47 ;							
1351-195X	ALL TF COILS DELIVERED		30SEP08		0.00				▼							

Job: 1354 - Trim Coil Design & Procurement-KALISH

Trim Coil **Updated estimate**

TRIM-170	Complete Trim Coil Detailed Drawings	25MAR08A	25JUL08	95	7,025.84				KALISH	etc =14hr ; RUSHINSKI etc =10h						
									CRUIKSHANK	etc =80hr ;						
TRIM-200	Assy drawings & parts list	01APR08A	25JUL08	95	9,988.86				KALISH	etc =04hr ; RUSHINSKI etc =10h						
									CRUIKSHANK	etc =80hr ;						

Neilson

Job: 8222 - Manuscripts and Papers - NEILSON

Prepare Closeout report

8222-900	Manuscripts, journal & papers (40 papers @40hrs)	02SEP08*	31MAR09		299,600.15											ea/em=800,em/em travel=15
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Perry

Job: 8220 - Equip Save & Facility Restora-PERRY

Safe and store NCSX hardware assets

8220-201	Coordination and oversight	01JUL08A	23DEC08		60,372.97											PERRY etc =382hr ;
8220-205	NCTC floor penetrations & PLT water hdr removal	30JUN08A	12AUG08	20	44,998.83				41etc =21\$K ; EM//TB	etc =382hr ;						
8220-209	Secure platform parts from CAS Bldg to NCTC	13AUG08	26AUG08		4,163.16				41etc =00\$K ; EM//TB	etc =48hr ;						
8220-223	Items f/TFTR bsmnt (incl spare MC cond) to NCTCB	01AUG08*	14AUG08		13,831.24				41etc =00\$K ; EM//TB	etc =172hr ;						
8220-227	Portable AC units to Dsite crib	27AUG08	03SEP08		631.76				EM//TB	etc =08hr ;						
8220-231	Drawing closeouts and field follow-up	01OCT08*	23DEC08		27,614.00									LANGELLA	etc =200hr ;	
8220-235	Large and Small shield block to Dsite pad	02SEP08*	15SEP08		2,527.04				EM//TB	etc =32hr ;						
8220-239	Machine mock-up to NCTC	13AUG08	19AUG08		631.76				EM//TB	etc =08hr ;						
8220-243	Welding machines to RESA	01OCT08*	07OCT08		668.56				EM//TB	etc =08hr ;						
8220-247	Tools to Csite crib	01OCT08*	14OCT08		2,674.24				EM//TB	etc =32hr ;						
8220-251	Measuring Equipment to MU Shop	01OCT08*	07OCT08		1,337.12				EM//TB	etc =16hr ;						
8220-255	Inventory parts,material, tools to new location	01OCT08*	28OCT08		6,685.60				EM//TB	etc =80hr ;						
8220-409	Crates,cabinets,parts shelves f/TFTRTC to NCTCB	23JUL08A	14OCT08	5	9,375.89				EM//TB	etc =124hr ;						
8220-415	Coil winding station to NCTC	13AUG08	26AUG08		5,054.08				EM//TB	etc =64hr ;						
8220-419	MC bolts (incl crate) to NCTCB	23JUL08A	14OCT08	5	2,084.11				41etc =00\$K ; EM//TB	etc =20hr ;						
8220-427	Assemble 4 remaining MC 3 packs	03SEP08	07OCT08		25,564.80				EM//TB	etc =320hr ;						
8220-431	Transport MC 3 packs (6) to NCTC	08OCT08	21OCT08		5,609.68				EM//TB	etc =64hr ; 41etc =00\$K ;						
8220-501	Autoclave- Safe all AC power	01AUG08*	07AUG08		3,762.80				LANGELLA	etc =24hr ; EM//TB	etc =08h					
8220-505	Autoclave-Removal and store Dsite pad & NCTCB	01OCT08*	23DEC08		154,843.44									LANGELLA	etc =400hr ; EM//TB e	
8220-901	VV Diagnostic parts incl fab crates to NCTCB	09SEP08*	15SEP08		1,669.86				41etc =0.2\$K ; EM//TB	etc =18hr ;						
8220-903	Move tool crib from C-site back to D-Site	09SEP08*	15SEP08		9,476.40				EM//TB	etc =120hr ;						
8220-605	VV Spool piece crates to NCTCB	01AUG08*	04AUG08		473.82				EM//TB	etc = 6						
8220-423	VVSA's (incl port extension crates) to NCTC	13AUG08	26AUG08		7,176.24				41etc =01\$K ; EM//TB	etc =72hr ;						
8220-609	Yellow wedge stands to NCTC	01OCT08*	02OCT08		334.28				EM//TB	etc = 4						

Activity ID	Activity Description	Forecast Start	Forecast Finish	% cmplt	ETC	FY08			FY09																
						J	A	S	O	N	D	J	F	M	A	M	J	J							
									EM//TB	etc =															
8220-613	Wedge cover plates to NCTC	01OCT08*	02OCT08		334.28				EM//TB	etc = 4															
8220-617	5 ton lift beam to RESA	01OCT08*	02OCT08		334.28				EM//TB	etc = 4															
8220-621	14 ton lift beam to RESA	01OCT08*	02OCT08		167.14				EM//TB	etc = 2															
8220-625	Remove coil winding rooms & dispose	02JUN08A	02SEP08	60	27,686.40				EM//TB	etc = 480	Langella	etc = 241													
8220-633	Equipment in MU machine shop-Electrical to RESA	02SEP08*	29SEP08		11,536.00				EM//TB	etc = 80	Langella	etc = 40													
8220-641	Equipment in MU machine shop-Mechanical to RESA	02SEP08*	15SEP08		12,635.20				EM//TB	etc = 160															
8220-653	Cryo pump skid- Mechanical to NCTCB	01AUG08*	26AUG08		3,790.56				EM//TB	etc = 48															
8220-657	Cryostat-disposal	27AUG08	10SEP08		3,790.56				EM//TB	etc = 48															
8220-661	Interlocked cryo room-leave in place	01AUG08*	01AUG08		0.00																				
8220-665	Spherical bearings (Dahlgren) to NCTCB	02JUL08*	03JUL08		78.97				EM//TB	etc = 1															
8220-669	Prototype castings to NCTC	13AUG08	14AUG08		631.76				EM//TB	etc = 8															
8220-673	Prototype VV cross sections-Scrap	22SEP08*	23SEP08		157.94				EM//TB	etc = 2															
8220-677	TF coil fabrication fixtures to NCTC-VPI fixture	13AUG08	14AUG08		315.88				EM//TB	etc = 4															
8220-681	TF coil fabrication fixtures to NCTC-Mandrel	13AUG08	14AUG08		315.88				EM//TB	etc = 4															
8220-685	TF coil fabrication fixtures to NCTC-Misc fixtur	13AUG08	14AUG08		315.88				EM//TB	etc = 4															
Rej																									
Job: 8101 - Project Management &Control-REJ																									
810.900	Project Management Office PPPL FY08 (LOE)	01OCT07A	30SEP08	LOE	153,091.69				NEILSON	etc =414hr ;	STRYKOWSKY	etc =540													
810.9005A	Project Management Office PPPL fy08 etc	02JUN08A	30SEP08	LOE	94,580.00				B///CB	etc =680hr ;	35etc =125k ;	41etc =035k ;	DEPUTYPC	etc =95hr ;											
810.901	Project Management Office PPPL FY09 (SA LOE)	01OCT08*	31MAR09	LOE	290,785.02				DON REJ1	etc =1265k ;															
									NEILSON	etc =335	Hampton	etc =484	41etc =055k ;	DON REJ1	etc =1	SIMMONS	etc =61	STRYKOWSKY	etc =35	35etc =175k ;					
Job: 8221 -Documentation Closeout-HEITZENROEDER																									
Prepare Closeout report																									
8221-608	Chapter & Appendices writers assigned		28JUL08*		0.00																				
8221-610	Writer guidance prepared & communicated		28JUL08*		0.00																				
8221-612	Chapter outlines finalized		29AUG08*		0.00																				
8221-614	Chapter Draftes complete		30SEP08*		0.00																				
8221-616	Chapter Draft reviews complete		15OCT08*		0.00																				
8221-618	Chapters Complete		17NOV08*		0.00																				
8221-636	Executive summary complete		05DEC08*		0.00																				
8221-639	Draft Report complete		05JAN09*		0.00																				
8221-642	Report Reviews Complete		02FEB09*		0.00																				
8221-646	DOE Concurrence		02MAR09*		0.00																				
8221-649	Final Report Issued		31MAR09*		0.00																				
8221-655	Submit NEPA form		18JUL08*		0.00																				
Strykowski																									
Job: 8998 - Allocations-STRYKOWSKY																									
99.08	PPPL Allocations FY08	LOE	01OCT07A	29SEP08	LOE	106,859.48				54etc =88 ;															
99.09C	PPPL Allocations FY09	LOE	01OCT08*	31MAR09	LOE	59,465.00				54 etc =35															
Viola																									
Job: 1802 - FP Assy Oversight&Support-VIOLA																									
Oversight and Supervision																									
1802ORNLO2	ORNL Title III field period assy station 2/3	02JUN08A	30SEP08	LOE	10,436.58				mcginnis=140																
R1802-003	Metrology Engr Super FY08	01OCT07A	30SEP08	LOE	33,974.62				PRINISKI	etc =293hr ;															
R1802-007	FPA Management FY08	01OCT07A	30SEP08	LOE	64,563.00				VIOLA	etc =558hr ;															
R1802-010	Drexel co-op student support	02JUN08A	31JUL08	LOE	1,290.30				DREXEL	etc =168 ;															
R1802-015	HP Coverage in the TFTR TC LOE FY08	01OCT07A	30SEP08	LOE	40,024.41				SH//TB	etc =440hr ;															

Activity ID	Activity Description	Forecast Start	Forecast Finish	% cmlpt	ETC	FY08			FY09									
						J	A	S	O	N	D	J	F	M	A	M	J	J
									SH//TB etc =629hr ;									
R1802-016	HP Coverage in the TFTR TC LOE FY09	01OCT08*	23DEC08	LOE	36,276.45													
1802MISC	Misc materials,tools, GSA vehicle,rigging	01FEB08A	30SEP08	LOE	42,029.28													
Station 3 procedures,JHA,ACC,Training,Prep																		
R1802-320	Update FPA cost estimate for FPA station 2&3	05SEP08	11SEP08		0.00													
Job: 1810 - Field Period AssyStation 1,2,3 VIOLA																		
General Assy Support																		
R1810-003	LOE Crane support, fixture setupfor FY08	01OCT07A	30SEP08	LOE	41,868.31													
R1810-025	Crane & Rigging inspections	01FEB08A	30SEP08	LOE	2,969.27													
R1810-007	LOE Field Supervision for FY08	01OCT07A	30SEP08	LOE	59,509.70													
R1810-2001	Misc Hardware and hardware rework (1/2 fte loe)	01FEB08A	30SEP08	LOE	17,815.63													
S21-4.02	Perform routine metrology set-up and checks (loe)	01FEB08A	30SEP08	LOE	45,942.88													
Setup																		
R1810-2034	Misc Tool and Hardware	02JUN08A	30SEP08	LOE	14,022.18													
Pre-Measuring and fitup checks																		
Pre measurement of MCHP A2,B2,C2 flanges																		
2-2-2.99	Drill Stycast fill holes C2	01JUL08*	03JUL08		9,476.40													
Station 2 MC subassy A1B1C1																		
Stycast shim bags & final measurements																		
2-1-8.01	Fill all wing bladders & cure	16JUL08A	31JUL08	70	1,137.17													
2-1-11.05	Perform Electrical Megger test on each coil	01AUG08*	04AUG08		3,790.56													
2-1-11.08	Remove from stand & measure weight of completed	23JUL08A	05AUG08	80	758.11													
S21-11.07M	Complete 1st MCHP Assy (Sta 2)		05AUG08		0.00													
Station 2 MC subassy A2B2C2																		
AB-C MC Assembly																		
2-2-7.03	Align set of monuments selected in 7.02.	24JUL08*	24JUL08		1,861.92													
2-2-7.04	Establish a set of global monuments	25JUL08	25JUL08		1,861.92													
2-2-7.05	Mark nose shim locations & puck locations.	28JUL08	28JUL08		1,579.40													
2-2-7.06	Place initial set shims (4-8) on Type-B	29JUL08	28JUL08		0.00													
2-2-7.08	Lower mating "C" coil into position.	29JUL08	29JUL08		3,158.80													
2-2-7.081	Perform alignment "C" coil tooling balls	30JUL08	30JUL08		1,861.92													
2-2-7.09	Install jack screws & dial indicators	31JUL08	31JUL08		1,579.40													
2-2-7.10	Position coil within ±.002"	01AUG08	01AUG08		1,579.40													
2-2-7.11	Install shims studs, & "wiggle"	04AUG08	04AUG08		2,369.10													
2-2-7.12	Torque50% of final value.	05AUG08	05AUG08		789.70													
2-2-7.13	Measure position of all monuments	06AUG08	06AUG08		2,792.88													
2-2-7.14	Measure shim puck height	07AUG08	07AUG08		1,579.40													
2-2-7.15	remove puck locating rings & install all nose s	08AUG08	08AUG08		4,738.20													
2-2-7.16	"Lightly" tack weld nose flex shims	11AUG08	11AUG08		789.70													
2-2-7.17	remove "C" coil & place it on a separate fixtur	12AUG08	12AUG08		3,158.80													
2-2-7.18	Recheck part alignment & weld all Type-B flex s	13AUG08	13AUG08		5,585.76													
2-2-7.19	After welding "B" coil nose shims recheck align	14AUG08	14AUG08		1,861.92													
2-2-7.20	Back office assessment of part after weld	15AUG08	15AUG08		3,723.84													
2-2-7.21	Measure "C" fiducials	15AUG08	15AUG08		1,861.92													
2-2-7.22	Weld all Type-C (A-flange) flex shims plasma sid	18AUG08	18AUG08		3,158.80													
2-2-7.23	After welding determine metrology acceptance	19AUG08	19AUG08		1,861.92													
2-2-7.24	Back office assessment	20AUG08	20AUG08		3,723.84													
2-2-7.25	Remove shims for alignment mating coil	21AUG08	20AUG08		0.00													
2-2-7.07	Place unfilled shim bags in wing areas	21AUG08	21AUG08		1,579.40													
2-2-7.26	Lower mating "C" coil into position.	22AUG08	22AUG08		3,158.80													
2-2-7.261	alignment "C" coil tooling balls	25AUG08	25AUG08		1,861.92													
2-2-7.27	position coil accurately in x, y, & z directio	26AUG08	26AUG08		1,579.40													
2-2-7.28	Install shims;studs,, & "wiggle"	27AUG08	27AUG08		2,369.10													
2-2-7.29	Torque50% of final value.	28AUG08	28AUG08		789.70													
2-2-7.30	Measure position of all monuments	29AUG08	29AUG08		2,792.88													

Activity ID	Activity Description	Forecast Start	Forecast Finish	% cmplt	ETC	FY08 FY09																	
						FY08			FY09														
						J	A	S	O	N	D	J	F	M	A	M	J	J					
2-2-7.31	Adjust shims locally. Re-torque all studs50%.	02SEP08	02SEP08		3,158.80																		
2-2-7.32	Install bushing. Replace nut & tighten back50%	03SEP08	03SEP08		4,738.20																		
2-2-7.33	After super bolt tightening, measure position	04SEP08	04SEP08		2,792.88																		
2-2-7.34	Tighten all bolts to final torque.	05SEP08	05SEP08		1,579.40																		
2-2-7.35	After tightening hardware, meas position of monu	08SEP08	08SEP08		2,792.88																		
2-2-7.36	Weld B / C nose region solenoid side	09SEP08	09SEP08		4,738.20																		
2-2-7.37	Measure positions of all monuments	10SEP08	10SEP08		1,861.92																		
2-2-7.38	Back office of above results & INSTALL wing supp	11SEP08	11SEP08		3,723.84																		
2-2-7.39	Fill all lose bushings with Stycast 2850FT	12SEP08	12SEP08		3,158.80																		
Stycast shim bags & final measurements																							
2-2-8.01	Fill all wing bladders & cure	15SEP08	16SEP08		3,158.80																		
2-2-8.02	Inject stycast in all shim spaces	17SEP08	18SEP08		3,158.80																		
2-2-10.0	Complete local service & interface details	19SEP08	18SEP08		0.00																		
2-2-11.01	Measure tooling balls on all coils.	19SEP08	22SEP08		3,723.84																		
2-2-11.02	Install or identify three primary fiducials	23SEP08	24SEP08		3,723.84																		
2-2-11.03	Scan "B" flange Type-C coil & interfacing base	25SEP08	29SEP08		5,585.76																		
2-2-11.04	Measure bolt length on all tension fasteners	30SEP08	30SEP08		1,579.40																		
2-2-11.05	Perform Electrical Megger test on each coil	01OCT08	02OCT08		3,342.80																		
2-2-11.06	Mark part for identification	03OCT08	02OCT08		0.00																		
2-2-11.07	Install lift support beams	03OCT08	06OCT08		6,685.60																		
2-2-11.08	Remove from stand & measure weight of completed	07OCT08	07OCT08		3,342.80																		
2-2-11.09	Move to holding area.	08OCT08	09OCT08		6,685.60																		
Station 3 Setup/Preparations/General																							
Misc Prep activities																							
R1810-3113	Procure wire rope slings & 6 17ton shackles	01JUL08A	23JUL08	50	18,845.20																		
Station 3-Assemble Mod Coils and VVSA-FP#1																							
Set-up and Prep																							
3-1-1.01	transfer CAD models	01JUL08*	10JUL08		13,033.44																		
Install Laser Screen																							
3-1-6.03	Turn each lasers on & measure each laser source	04AUG08*	04AUG08		4,129.58																		
3-1-6.04	Print path on milar paper	05AUG08	04AUG08		0.00																		
3-1-6NEW	Dry-run MCHP thru laser screen path without VVSA	06AUG08	11AUG08		10,108.16																		
Install Vacuum Vessel																							
3-1-7.03	Install VVSA to base support and make connection	12AUG08	12AUG08		1,895.28																		
3-1-7.04	take tooling ball readings and secure VVSA	13AUG08	14AUG08		3,790.56																		
3-1-7.05	Scan VV surface and compare data	15AUG08	19AUG08		6,702.91																		
Trial fit MCHP over VV																							
3-1-8.01	Install any bumper protection components on the	20AUG08	20AUG08		947.64																		
3-1-8.03	Install MCHP lift fixture, disengage leveler	21AUG08	22AUG08		3,790.56																		
3-1-8.05	Move right MCHP over the VV	25AUG08	27AUG08		18,074.59																		
3-1-8.05M	MCHP test fit over VVSA Complete		27AUG08		0.00																		
3-1-6.05	Disengage the right MCHP & position on floor	28AUG08	28AUG08		1,895.28																		