

64880/1 PPPL NCSX PVVS INSPECTION PLAN

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

Revision: 12/11/03 15:29

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-003P Rev: 0			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)	PERMEABILITY GAG	QA						
*		Magnetic Permeability of Conflat Flange (1.02 Max)	PERMEABILITY GAG	QA						
*		Magnetic Permeability of Weld / Heat Affecte ne (Flange to Tube) (1.2 Max)	PERMEABILITY GAG	QA						
*		(g ,375) Finished part profile	SMX	QA						
*		(# d.125"p48" A B C) Port Extension position (after re-attachment)	SMX	QA						

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

Revision: 12/11/03 15:11

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
*		Magnetic Permeability 1.0 Max. (Panel Blank)	PERMEABILITY GAG	QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581-D.ED 09-25-03		A
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK	QA		J-160	.412	085-D.GR 10-02-03		A
*		SURFACE FINISH:	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR		A

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.



INSPECTION DATA CHECKLIST

64880/1 PPPL NCSX PVVS INSPECTION PLAN

	SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)						10-02-03
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Workorder: 64880/1-0 Sub:14 Op:31

Revision: 12/04/03 9:13

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

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		VERIFY HEAT TREAT CERTIFICATION AND FURNACE CHART COMPLY WITH MTM PURCHASE ORDER REQUIREMENTS		QA						

Workorder: 64880/1-0 Sub:14 Op:35

Revision: 12/11/03 15:11

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
*		MAGNETIC PERMEABILITY OF ANNEALE 1.01 MAX	PERMEABILITY GAG	QA		J-1143	1.008-1.009	522-R.DU 10-29-03		A

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

Revision: 10/29/03 10:55

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 QA			FEELER GAGE .080 (GOOD) FEELER GAGE	746-G.D 10-29-03	522-R.DU 10-29-03	A

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


Revision: 12/11/03 15:12

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

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

*		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	QA					
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA					
*		 .094" .094" Max Gap (Part Surface To gauge)	TEMPLATE FEELER GAGE	QA ENG					

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

Revision: 12/11/03 15:12

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	
*		Magnetic Permeability 1.0 Max. (Panel Blank)	PERMEABILITY GAG	QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581-D.ED 09-25-03			A
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK O.D. MICS	QA		J-160	.405	085-D.GR 10-02-03			A
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR 10-02-03			A

Workorder: 64880/1-0 Sub:15 Op:31

Revision:

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

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		VERIFY HEAT TREAT CERTIFICATION AND FURNACE CHART COMPLY WITH MTM PURCHASE ORDER REQUIREMENTS		QA							

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INSPECTION DATA CHECKLIST

64880/1 PPPL NCSX PVVS INSPECTION PLAN

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

Revision: 12/11/03 15:13

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

Drawing ID: SE121-001P Rev: 0			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

Revision:


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

Drawing ID: SE121-001P Rev: 0			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

Revision: 12/11/03 15:13

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

Drawing ID: SE121-001P Rev: 0			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						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
*		 .094" .094" Max Gap (Part Surface To gauge)	TEMPLATE FEELER GAGE	QA ENG						

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

Revision: 12/11/03 15:14

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
*			PERMEABILITY GAG	QA			TESTED 15 RANDOM LO	581-D.ED		

A

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		Magnetic Permeability 1.0 Max. (Panel Blank)					CATIONS, MAX. MAG. PERMEABILITY =1.000	09-25-03		
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK O.D. MICS	QA		J-160	.381	085-D.GR 10-02-03		A
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR 10-02-03		A

Workorder: 64880/1-0 Sub:16 Op:31

Revision:

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

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		VERIFY HEAT TREAT CERTIFICATION AND FURNACE CHART COMPLY WITH MTM PURCHASE ORDER REQUIREMENTS		QA						

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

Revision: 12/11/03 15:14

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

Drawing ID: SE121-001P Rev: 0			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:16 Op:40

Revision:

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

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT

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64880/1 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:16 Op:70

Revision: 12/11/03 15:14

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

Drawing ID: SE121-001P Rev: 0			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						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
*		 .094" .094" Max Gap (Part Surface To gauge)	TEMPLATE FEELER GAGE	QA ENG						

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

Revision: 12/11/03 15:15

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
*		Magnetic Permeability 1.0 Max. (Panel Blank)	PERMEABILITY GAG	QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581-D.ED 09-25-03		A
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK O.D. MICS	QA		J-160	.396	085-D.GR 10-02-03		A
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR 10-02-03		A

Workorder: 64880/1-0 Sub:17 Op:31

Revision:

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

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

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		VERIFY HEAT TREAT CERTIFICATION AND FURNACE CHART COMPLY WITH MTM PURCHASE ORDER REQUIREMENTS		QA						

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

Revision: 12/11/03 15:15

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

Drawing ID: SE121-001P Rev: 0			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

Revision:

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

Drawing ID: SE121-001P Rev: 0			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:17 Op:70

Revision: 12/11/03 15:16

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

Drawing ID: SE121-001P Rev: 0			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						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
*		(g .094")	TEMPLATE	QA						

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INSPECTION DATA CHECKLIST

64880/1 PPPL NCSX PVVS INSPECTION PLAN

	.094" Max Gap (Part Surface To gauge)	FEELER GAGE	ENG						
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Workorder: 64880/1-0 Sub:18 Op:10

Revision: 12/11/03 15:21

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	
*		Magnetic Permeability 1.0 Max. (Panel Blank)	PERMEABILITY GAG	QA		J-1143	TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581-D.ED 09-25-03			A
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK O.D. MICS	QA		J-160	.415	085-D.GR 10-02-03			A
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR 10-02-03			A

Workorder: 64880/1-0 Sub:18 Op:31

Revision:

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

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		VERIFY HEAT TREAT CERTIFICATION AND FURNACE CHART COMPLY WITH MTM PURCHASE ORDER REQUIREMENTS		QA			VISUAL	825-B.JA 01-07-04			A

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

Revision: 12/11/03 15:22

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

Drawing ID: SE121-001P Rev: 0			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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64880/1 PPPL NCSX PVVS INSPECTION PLAN

	MAGNETIC PERMEABILITY OF ANNEALE 1.01 MAX								
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Workorder: 64880/1-0 Sub:18 Op:40

Revision:


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

Drawing ID: SE121-001P Rev: 0			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

Revision: 12/11/03 15:22

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

Drawing ID: SE121-001P Rev: 0			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						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
*		 .094" .094" Max Gap (Part Surface To gauge)	TEMPLATE FEELER GAGE	QA ENG						

Workorder: 64880/1-0 Sub:19 Op:10

Revision: 12/24/03 9:48

Part: SE212-003P-3 - PORT EXTENSION -

Drawing ID: SE121-002P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*				CWI						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI					

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

Revision: 12/11/03 15:32

Part: SE212-003P-3 - PORT EXTENSION -

Drawing ID: SE121-002P Rev: 0			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:24 Op:30

Revision: 10/02/03 9:44

Part: - - SURFACE FINISH TESTING TEST PIECES TO DEVELOP SURFACE FINISHING TECHNIQUES, CLEANING PROCEDURE, AND PERMEABILITY TESTING METH

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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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		SURFACE FINISH: 32 MICRO ON ONE SIDE SMOOTH BLASTED SURFACE SIDE OPPOS	PROFILOMETER	QA		J-1152	22 TO 27 MICRO	139-R.S 10-02-03			A
		CLEANLINESS PER PP475.	VISUAL INSPECTION	QA		VISUAL	ACC	139-R.S 10-02-03			A
		MAGNETIC PERMEABILITY (1.01 MAX)		QA		J-1143	1.01	085-D.GR 10-02-03			A

Workorder: 64880/1-0 Sub:25 Op:15

Revision: 12/11/03 15:30

Part: SE121-003P-4 - PORT EXTENSION WELD BACKING RING -

Drawing ID: SE121-003P 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			15 RANDOM LOCATION HIGH=1.007, LOW=1.006	581-D.ED 09-22-03			A

Workorder: 64880/1-0 Sub:25 Op:20

Revision: 12/24/03 9:50

Part: SE121-003P-4 - PORT EXTENSION WELD BACKING RING -

Drawing ID: SE121-003P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER		CWI						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						

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

Revision: 12/22/03 11:31

Part: SE121-003P-4 - PORT EXTENSION WELD BACKING RING -

Drawing ID: SE121-003P Rev: 0			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						
*		CLEANLINESS PER PP475		QA						

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

Revision: 11/06/03 10:07

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET # 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: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		.094" Max Gap (Part Surface To gauge)		QA ENG						
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Workorder: 64880/1-0 Sub:29 Op:10

Revision: 12/11/03 15:33

Part: SE212-003P-3 - -

Drawing ID: SE121-002P 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			MAX. RECORDING OF P ERM. OF PLATE 1.002 , 12 PLCS. RANDOMLY CHECKED.	581-D.ED 09-17-03			A

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

Revision: 12/11/03 15:34

Part: SE212-003P-3 - -

Drawing ID: SE121-002P 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			21 RANDOM LOCATION , HIGH=1.007, LOW=1 .006	581-D.ED 09-22-03			A

Workorder: 64880/1-0 Sub:29 Op:40

Revision: 01/16/04 8:36

Part: SE212-003P-3 - -

Drawing ID: SE121-003P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER		CWI						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
Drawing ID: SE121-002P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Verify Port Tube Weld Joint Alignment (.02" Max)		QA						

Workorder: 64880/1-0 Sub:29 Op:50

Revision: 01/09/04 14:25

Part: SE212-003P-3 - -

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		PRIOR TO OPERATION START								
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		QA						

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

Revision: 01/09/04 14:37

Part: SE212-003P-3 - -

Drawing ID: SE121-001P Rev: 0			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						
1*		8.0" Diameter +3/32" / -0 (per ASTM B444)		QA						

Workorder: 64880/1-0 Sub:31 Op:10

Revision:

Part: - - NAMEPLATE

Drawing ID: NAMEPLATE Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		MAGNETIC PERMEABILITY OF NAMEPLA	PERMEABILITY GAG	QA		J1143	9 LOC. CHECKED- HIG H 1.007, LOW 1.007.	581-D.ED		

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INSPECTION DATA CHECKLIST

64880/1 PPPL NCSX PVVS INSPECTION PLAN

	1.0 MAX						09-24-03	
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Workorder: 64880/1-0 Sub:31 Op:20

Revision:

Part: - - NAMEPLATE

Drawing ID: Rev:		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		MAGNETIC PERMEABILITY OF NAMEPLA 1.0 MAX	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:39 Op:10

Revision:

Part: - - SE121-003P NCSX PVVS COMPLETE RE-STRUCTURE / DETAIL TASK BREAKDOWN 07Jan03 BASED ON RELEASE MEETING DISCUSSION PRIMARY STR

Drawing ID: SE121-002P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						

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INSPECTION DATA CHECKLIST

64880/1 PPPL NCSX PVVS INSPECTION PLAN

*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
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Workorder: 64880/1-0 Sub:39 Op:30

Revision:

Part: - - SE121-003P NCSX PVVS COMPLETE RE-STRUCTURE / DETAIL TASK BREAKDOWN 07Jan03 BASED ON RELEASE MEETING DISCUSSION PRIMARY STR

Drawing ID: SE121-003P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:39 Op:40

Revision:

Part: - - SE121-003P NCSX PVVS COMPLETE RE-STRUCTURE / DETAIL TASK BREAKDOWN 07Jan03 BASED ON RELEASE MEETING DISCUSSION PRIMARY STR

Drawing ID: SE121-003P Rev: 0			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)	PERMEABILITY GAG	QA						
*		Magnetic Permeability of Conflat Flange (1.02 Max)	PERMEABILITY GAG	QA						
*		Magnetic Permeability of Weld / Heat Affecte ne (Flange to Tube) (1.2 Max)	PERMEABILITY GAG	QA						
*		(g ,375) Finished part profile	SMX	QA						
*		(# d.125"p48" A B C) Port Extension position (after re-attachment)	SMX	QA						

Workorder: 64880/1-0 Sub:40 Op:10

Revision: 01/12/04 16:15

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

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

Revision: 01/12/04 16:15

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:40 Op:70

Revision: 01/12/04 16:22

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Verify Panel Joint Alignment Weld Seam # 1-2 (.02" Max)	VISUAL INSPECTION	MFG						
		Verify Panel Joint Alignment Weld Seam # 3-4 (.02" Max)		MFG						
				CWI						
*		Verify Panel / Rest Stop Position Panel #1 (0 - .09" Gap)	FEELER GAGE	MFG						
*		Verify Panel / Rest Stop Position Panel #3 (0 - .09" Gap)	FEELER GAGE	MFG						
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:40 Op:80

Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		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. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:90

Revision: 01/12/04 16:22

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
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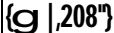
64880/1 PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:40 Op:100

Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 ,208" Profile Tolerance (+.188 / -.020") (tack welded vessel)	SMX	QA						
*			PERMEABILITY GAG	QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		Magnetic Permeability 1.01 Max. Record range (high / low)							
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Workorder: 64880/1-0 Sub:40 Op:110

Revision: 01/12/04 16:23

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:40 Op:120

Revision:

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INSPECTION DATA CHECKLIST

64880/1 PPPL NCSX PVVS INSPECTION PLAN

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		G ,228" Profile Tolerance (+.188/-.040") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:130

Revision: 01/12/04 16:23

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*				QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION								
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Workorder: 64880/1-0 Sub:40 Op:140

Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 248" Profile Tolerance (+.188/-.060") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:150

Revision: 01/12/04 16:23

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:40 Op:160

Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .268" Profile Tolerance (+.188/-.080") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:170

Revision: 01/12/04 16:24

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:40 Op:180

Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		g ,288" Profile Tolerance (+.188/-.100") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:190

Revision: 01/12/04 16:24

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:40 Op:200

Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 308" Profile Tolerance (+.188/-.120") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

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INSPECTION DATA CHECKLIST

64880/1 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:40 Op:210

Revision: 01/12/04 16:16

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:40 Op:220

Revision: 01/13/04 12:52

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
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64880/1 PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		{g ,328"} Profile Tolerance (+.188/-.140") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:230

Revision: 01/12/04 16:13

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE		QA						

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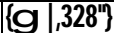
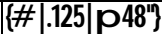
64880/1 PPPL NCSX PVVS INSPECTION PLAN

	PRIOR TO OPERATION START AND THROUGH COMPLETION								
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Workorder: 64880/1-0 Sub:40 Op:240

Revision: 01/13/04 12:53

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .328" Profile Tolerance (+.188/-.140") (within approximately 6" of port attachment point)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						
		 .125 p48"	SMX	QA						

Workorder: 64880/1-0 Sub:40 Op:250

Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:40 Op:260

Revision: 01/16/04 9:06

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		G ,348" Profile Tolerance (+.188/-.160") (within approximately 6" of port attachment point)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						
		{# .150 p48"	SMX	QA						

Workorder: 64880/1-0 Sub:40 Op:270

Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		PRIOR TO OPERATION START AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:40 Op:280

Revision: 01/16/04 9:07

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g .358) Profile Tolerance (+.188/-.170") (within approximately 6" of port attachment point)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						
		(# .150 p48)	SMX	QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:40 Op:290

Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:40 Op:300

Revision: 01/16/04 9:08

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
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64880/1 PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g .368") Profile Tolerance (+.188/-.160") (within approximately 6" of port attachment point)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						
		(# .150 p48")	SMX	QA						

Workorder: 64880/1-0 Sub:41 Op:10

Revision: 01/12/04 16:33

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Verify Panel Joint Alignment Weld Seam # 4-5 (.02" Max)	VISUAL INSPECTION	MFG CWI						
*		Verify Panel / Rest Stop Position Panel #4 (0 - .09" Gap)	FEELER GAGE	MFG						
*		Verify Panel / Rest Stop Position Panel Sub-Set #2-5 (0 - .09" Gap)	FEELER GAGE	MFG						
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:41 Op:20

Revision:

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0		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. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:41 Op:30

Revision: 01/12/04 16:34

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:41 Op:40

Revision:

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .208" Profile Tolerance (+.188 / -.020") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:41 Op:50

Revision: 01/12/04 16:34

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:41 Op:60

Revision:

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		ⓐ 228"	SMX	QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

	Profile Tolerance (+.188/-.040") (tack welded vessel)								
*	Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:41 Op:70

Revision: 01/12/04 16:34

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

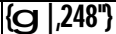
NOTE: the recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, title 18, chapter 47.

64880/1 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:41 Op:80

Revision:

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 248" Profile Tolerance (+.188/-0.060") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:41 Op:90

Revision: 01/12/04 16:35

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP		QA						

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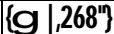
64880/1 PPPL NCSX PVVS INSPECTION PLAN

		PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:41 Op:100

Revision:

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .268" Profile Tolerance (+.188/-.080") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:41 Op:110

Revision: 01/12/04 16:35

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*				QA						

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.

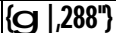
64880/1 PPPL NCSX PVVS INSPECTION PLAN

		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:41 Op:120

Revision:

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .288" Profile Tolerance (+.188/-.100") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:41 Op:130

Revision: 01/12/04 16:37

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:41 Op:140

Revision:

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 ,308" Profile Tolerance (+.188/-.120") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:41 Op:150

Revision: 01/12/04 16:37

Part: - - PANEL SUB-SET 2-5-4

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:41 Op:160

Revision:

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .288" Profile Tolerance (+.188/-.140") (tack welded vessel)	SMX	QA						

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INSPECTION DATA CHECKLIST

64880/1 PPPL NCSX PVVS INSPECTION PLAN

*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						
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Workorder: 64880/1-0 Sub:43 Op:10

Revision: 01/12/04 16:38

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Verify Panel Joint Alignment Weld Seam # 1-3 (.02" Max)	VISUAL INSPECTION	MFG						
				CWI						
*		Verify Panel / Rest Stop Position Panel #1 (0 - .09" Gap)	FEELER GAGE	MFG						
*		Verify Panel / Rest Stop Position Panel #3 (0 - .09" Gap)	FEELER GAGE	MFG						
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:43 Op:20

Revision:

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			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. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:43 Op:30

Revision: 01/12/04 16:38

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:43 Op:40

Revision: 01/07/04 17:48

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		g ,208 Profile Tolerance (+.188 / -.020") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:43 Op:50

Revision: 01/12/04 16:39

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		PRIOR TO OPERATION START AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:43 Op:60

Revision: 01/07/04 17:47

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .228" Profile Tolerance (+.188/-.040") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:43 Op:70

Revision: 01/12/04 16:39

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64880/1 PPPL NCSX PVVS INSPECTION PLAN


Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:43 Op:80

Revision: 01/08/04 8:09

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 ,248" Profile Tolerance (+.188/-0.060")	SMX	QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		(tack welded vessel)							
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA					

Workorder: 64880/1-0 Sub:43 Op:90

Revision: 01/12/04 16:40

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:43 Op:100

Revision: 01/08/04 8:12

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Ⓞ ,268" Profile Tolerance (+.188/-0.80") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:43 Op:110

Revision: 01/12/04 16:40

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		QA						

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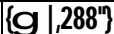
64880/1 PPPL NCSX PVVS INSPECTION PLAN

		AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:43 Op:120

Revision: 01/08/04 9:03

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .288" Profile Tolerance (+.188/-.100") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:43 Op:130

Revision: 01/12/04 16:40

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

		VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:43 Op:140

Revision: 01/08/04 9:04

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 ,308" Profile Tolerance (+.188/-.120") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:43 Op:150

Revision: 01/12/04 16:41

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:43 Op:160

Revision: 01/16/04 9:17

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .328" Profile Tolerance (+.188/-.140") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:10

Revision: 01/12/04 16:26

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
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64880/1 PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Verify Panel Joint Alignment Weld Seam # 2-5 (.02" Max)	VISUAL INSPECTION	MFG CWI						
*		Verify Panel / Rest Stop Position Panel #2 (0 - .09" Gap)	FEELER GAGE	MFG						
*		Verify Panel / Rest Stop Position Panel #5 (0 - .09" Gap)	FEELER GAGE	MFG						
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:45 Op:20

Revision:

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		g ,188" Upper Half Of Bilateral Tolerance (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:30

Revision: 01/12/04 16:26

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP		QA						

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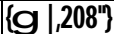
64880/1 PPPL NCSX PVVS INSPECTION PLAN

		PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:45 Op:40

Revision:

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .208" Profile Tolerance (+.188 / -.020") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:50

Revision: 01/12/04 16:26

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*				QA						

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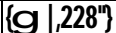
64880/1 PPPL NCSX PVVS INSPECTION PLAN

		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:45 Op:60

Revision:

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .228" Profile Tolerance (+.188/-.040") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:70

Revision: 01/12/04 16:31

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		QA						

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.

64880/1 PPPL NCSX PVVS INSPECTION PLAN

		AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					

Workorder: 64880/1-0 Sub:45 Op:80

Revision:

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,248ⁿ) Profile Tolerance (+.188/-.060") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:90

Revision: 01/12/04 16:31

Part: - - PANEL SUB-SET 2-5

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:45 Op:100

Revision:

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 ,268" Profile Tolerance (+.188/-0.080") (tack welded vessel)	SMX	QA						

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INSPECTION DATA CHECKLIST

64880/1 PPPL NCSX PVVS INSPECTION PLAN

*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						
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Workorder: 64880/1-0 Sub:45 Op:110

Revision: 01/12/04 16:32

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						


Workorder: 64880/1-0 Sub:45 Op:120

Revision:

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64880/1 PPPL NCSX PVVS INSPECTION PLAN

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .288" Profile Tolerance (+.188/-.100") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:130

Revision: 01/12/04 16:32

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

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INSPECTION DATA CHECKLIST

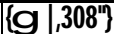
64880/1 PPPL NCSX PVVS INSPECTION PLAN

*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
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Workorder: 64880/1-0 Sub:45 Op:140

Revision:

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 ,308" Profile Tolerance (+.188/-.120") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:150

Revision: 01/12/04 16:32

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA		QA						

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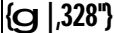
64880/1 PPPL NCSX PVVS INSPECTION PLAN

		PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:45 Op:160

Revision: 01/16/04 9:16

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .328" Profile Tolerance (+.188/-.140") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

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