Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE
	NSCX PROTOTYPE VACUUM VESSEL SEGMENT			

Sub ID	Part ID	Qty	Drawing ID / Rev
0	NSCX PROTOTYPE VACUUM VESSEL SEGMENT	1	SE121 / A

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 0 / Seq: 10	700-BLUE TEAM, ENGINEERING	1.00	1.00	1.00	SE121 / A
(U)	ENGINEERING				

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10		1.0			
(U)	WELD WIRE				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 0 / Seq: 20	825-FINAL INSPECTION - PLANTS 1 &	1.00	1.00	1.00	SE121 / A
(U)	FINAL VISUAL INSPECTION (ENGINEERING CONCURRENCE REQUIRED). VERIFY CLEANLINESS PER ..... COMPILE ELECTRONIC DATA BOOK INFORMATION PER MTM QAP. TAKE SEVERAL PHOTOGRAPHS OF PART PREPARE C OF C AND REQUEST FOR SHIPPING RELEASE (CONTACT ENGINEERING (DOUG McCORKLE) FOR RELEASE FORM IF NOT AVAILABLE ELECTRONICALLY.				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 0 / Seq: 30	425-SHIPPING - PLANTS 1 & 2	1.00	1.00	1.00	SE121 / A
(U)	SHIP PER CUSTOMER RELEASE FORM (CONTAINER MANUFACTURED IN SUB I.D. 28) SPECIAL CRATE REQUIREMENTS: CONTAINER MUST BE CLEARLY MARKED WITH THE FOLLOWING INFORMATION: SUPPLIER: MAJOR TOOL & MACHINE, INC. 1458 E. 19TH ST. INDIANAPOLIS, IN 46218 CONTENTS: SE121 NCSX PVVS				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev		Service ID
Sub: 0 / Seq: 9999	600-DO NOT USE - PC AUTO PROJECT	1.00	1.00	1.00			TESTNG/MISC
					Drw N/A	IDC N/A	

Sub ID	Part ID	Qty	Drawing ID / Rev
1	SE121 PROTOTYPE VACUUM VESSEL	1	SE121 / A

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 1 / Seq: 10	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A
(U)	* FABRICATION OPERATION # 1				

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

1. INSTALL THE DIE FORMED PANELS ONTO FABRICATION FIXTURE. TRIM, FIT, AND ALIGN EACH PANEL TO IT'S RESPECTIVE ADJACENT PANEL AND FIXTURE REST STOPS. NOTE THAT THE FIXTURE REST STOPS ARE POSITIONED AT NOMINAL (+.090") GEOMETRIC POSITION TO AVOID STARTING ANY LOWER THAN MID-TOLERANCE. GAPS BETWEEN THE PRODUCTION PANELS AND FIXTURE REST STOPS (UP TO .090") ARE PERMITTED.
ALIGN AND TACK WELD ALL FIVE PANELS TOGETHER.
ENSURE EACH PANEL IS ALIGNED SMOOTH AND CONTINUOUS TO ITS ADJACENT MEMBER AND MIS-MATCH IS MINIMIZED. CWI / ENGINEERING CONCURRENCE REQUIRED.
ASSIST Q/A WITH PROFILE VERIFICATION.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 1 / Seq: 20	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	INSPECTION OPERATION # 1				

AFTER PART IS COMPLETELY TACK WELDED, INSPECT / VERIFY POSITIONING, FITUP, AND PROFILE OF TACK WELDED PER THE FOLLOWING:
ENSURE THE PART PROFILE IS WITHIN THE UPPER HALF OF THE APPLIED BI-LATERAL TOLERANCE AS FOLLOWS: VARIFY THAT NO INSPECTION POINT IS ABOVE THE HIGH LIMIT OF TOLERANCE (OUTWARD) OR BELOW NOMINAL (INWARD).
RECORD ACTUAL (HIGH/LOW RANGE) ON MTM I.D.C.
REPORT ANY OUT OF TOLERANCE READINGS VIA MTM N.C.R.
NOTIFY ENGINEERING (DOUG McCORKLE) FOR EVALUATION OF RESULTS PRIOR TO RELEASING PART.
ENSURE THE FIXTURE DATUM TARGETS ARE ADEQUATELY POSITIONED FOR THE NEXT SEQUENTIAL INSPECTION
INSPECT AND RECORD THE MAGNETIC PERMEABILITY OF THE WELD ZONES.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 1 / Seq: 30	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A
(U)	FABRICATION OPERATION # 2				

INSTALL THE EXTERIOR STIFFENER (FIXTURING) TO THE TOP OF THE VESSEL. TACK WELD THE STIFFENER TO THE PART.
NOTE THAT THE STIFFENER MATERIAL IS ALSO INCO 625, NO TABS REQUIRED.

BACK PURGE THE OUTSIDE WELD JOINT SURFACES. PURGE MATERIAL MUST BE MADE FROM EITHER 625 INCONEL OR 300 SERIES STAINLESS STEEL.
WELD ROOT PASSES (INCREMENTALLY, USING BACK-STEPPING METHOD TO MINIMIZE SHRINKAGE) ON ALL FIVE WELD JOINTS.

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 1 / Seq: 40	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	INSPECTION OPERATION # 2				

AFTER THE ROOT WELDS ARE COMPLETE (FABRICATION DEPT. WILL COORDINATE); RE-INSPECT / VERIFY PART PROFILE IS WITHIN APPLIED TOLERANCE AND RECORD WELDING SHRINKAGE / DISTORTION REALIZED TO THIS POINT.
RECORD ACTUAL (INDIVIDUAL) MEASUREMENTS ON INSPECTION FORM (SE121-2MTM). RECORD ACTUAL (HIGH/LOW RANGE) ON MTM I.D.C.
INSPECT AND RECORD MAGNETIC PERMEABILITY.
REPORT ANY OUT OF TOLERANCE READINGS VIA MTM NCR.
NOTIFY ENGINEERING (DOUG McCORKLE) FOR EVALUATION OF RESULTS PRIOR TO RELEASING PART.
ENSURE THE FIXTURE DATUM TARGETS ARE ADEQUATELY POSITIONED FOR THE NEXT SEQUENTIAL INSPECTION.
ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 1 / Seq: 70	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A
(U)	FABRICATION OPERATION # 4				

AFTER OBTAINING ENGINEERING PROFILE ACCEPTANCE, WELD THE REMAINDER OF THE STRUCTURAL WELD JOINTS (SEQUENCE WELDING TO MINIMIZE DISTORTION AND NUMBER OF INTER-PASSES).
AFTER WELDING IS COMPLETE, REMOVE THE OUTSIDE STIFFENING PLUG. BLEND / TOUCH UP ATTACHMENT WELDS AS REQUIRED.
LAYOUT THE PORT ASSEMBLY LOCATION. (ANGULAR LOCATION / OVERALL LENGTH AND OUTLINE ARE SCRIBED ON FIXTURE). **********(HEIGHT FROM FIXTURE PLATE TO CENTER OF TUBE NEEDED (IN ROUTING))**********
POSITION AND WELD THE PORT SUB-ASSEMBLY IN PLACE PER DRAWING.
FINISH POLISHING AND CLEANING THE INTERIOR SURFACES OF THE PORT SUB-ASSEMBLY. RESTORE TO A 32 MICRO-INCH SURFACE FINISH. REFER TO CLEANING PROCEDURE # ?????
INSTALL THE VACUUM TEST CAP TO THE CONFLAT FLANGE.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev	Service ID
Sub: 1 / Seq: 73	450-SUBLET	1.00	1.00	1.00	SE121 / A	MISC/SUBLET
(U)	VACUUM TESTING OF PORT SUB-ASSEMBLY TO PER THE FOLLOWING:					

THE PORT UNDER TEST SHALL BE EVACUATED USING A TURBO MOLECULAR PUMP TO AN INTERNAL PRESSURE OF LESS THAN OR EQUAL TO 1 X 10(-7) TORR. THE TOTAL HELIUM LEAK RATE FOR THE PORT EXTENSION SHALL BE LESS THAN OR EQUAL TO 1.7 X 10(-9) TORR-L/S.
Part Number: SE121-1
Part Description: PROTOTYPE VACUUM VESSEL SEG.
Customer: PPPL
Test Certification: VACUUM TEST CERTIFICATE Rev:

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 1 / Seq: 80	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	INSPECTION OPERATION # 3				

AFTER THE STRUTURAL WELDS AND VACUUM TESTING ARE COMPLETE (FABRICATION DEPT. WILL COORDINATE); RE-INSPECT / VERIFY PART PROFILE IS WITHIN APPLIED TOLERANCE AND RECORD WELDING SHRINKAGE / DISTORTION.
RECORD ACTUAL (HIGH/LOW RANGE) ON MTM I.D.C.
REPORT ANY OUT OF TOLERANCE READINGS VIA MTM NCR.
VERIFY MAGNETIC PERMEABILITY AND RECORD I.D.C.
ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 1 / Seq: 90	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121-003P / 0
(U)	FABRICATION OPERATION # 5				

LAYOUT AND CUT THE PORT EXTENSION TUBE PER DRAWING. CUT THE PORT OPENING PER DRAWING. PREP EDGES OF TUBE FOR RE-INSTALLATION AND WELDING.
POSITION AND WELD THE WELD BACKING RING (SE121-003P-4) IN PLACE PER DRAWING.
RE-INSTALL THE PORT EXTENSION TUBE AND WELD IN PLACE PER DRAWING.
GRIND AND POLISH THE INSIDE WELD PROFILE SMOOTH TO BASE MATERIAL (NOTE SURFACE FINISH REQUIREMENTS).
GRIND AND POLISH THE STIFFENING RING FILLET WELDS SMOOTH.
GRIND / POLISH THE PORT SUB-ASSEMBLY INTERIOR WELD SMOOTH AND CUT THE OPENING PER DRAWING.
ASSIST Q/A WITH PROFILE VERIFICATION.
AFTER INSPECTION IS COMPLETE, REMOVE PART FROM FIXTURE.
PERFORM FINAL COSMETIC UPGRADE. PREPARE PART FOR FINAL BLAST AND FINAL VISUAL INSPECTION.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 1 / Seq: 100	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	FINAL PROFILE VERIFICATION. VERIFY MAGNETIC PERMEABILITY.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 1 / Seq: 110	260-SANDBLAST	1.00	1.00	1.00	SE121 / A
(U)	MASK THE INTERIOR SURFACES AND FLANGE FACE. BLAST THE OUTSIDE SURFACE 100% USING 220 GRIT VIRGIN ALUMINUM OXIDE.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 1 / Seq: 115	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A
(U)	REMOVE MASKING AND PROTECTIVE PLASTIC CLEAN PART PER				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 1 / Seq: 120	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	FINAL MAGNETIC PERMEABLITY VERIFICATION. VERIFY MAGNETIC PERMEABILITY OF THE STRUCTURAL WELDS, VESSEL WALL, PORT EXTENSION TUBE, CONFLAT FLANGE, FLANGE TO TUBE WELD. RECORD I.D.C. DATA				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Sub ID	Part ID	Qty	Drawing ID / Rev
3	LEAVE UNRELEASED!!!! SE121-00	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 3 / Seq: 10	410-BURNOUT TABLE	1.00	1.00	1.00	SE121 / A

(U) NEST AND PROGRAM.
BURNOUT AND CLEANUP STIFFENER SEGMENTS PER NESTING / PROGRAM. ENSURE ALL DROSS IS REMOVED AND CORNERS ARE SLIGHTLY RADIUSED.

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10	INCONEL 625_6-PLATE,NICKEL ALLOY .5" THK Vendor Part ID: INCONEL 625_6	1.0		1810	

(U) INCONEL 625 (UNS N06625) PER ASTM B 443-00
ANNEALED
MAGNETIC PERMEABILITY SHALL NOT EXCEED 1.00 (REF. ASTM A800).
SURFACE MUST BE PROTECTED FROM CONTACT WITH IRON AND IRON ALLOY MATERIALS
CERTS & MILL TEST REPORTS REQ'D WITH SHIPMENT.

Material Certification:
Part Number: SE121-3 & -4
Part Description: PROTOTYPE RIB # 1 & 2

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 3 / Seq: 20	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A

(U) ASSEMBLE AND WELD STIFFENER SUB-ASSEMBLIES COMPLETE PER DRAWING, MYLAR TEMPLATE, AND WPS.....
ENSURE ADEQUATE MACHINING STOCK EXISTS ON INSIDE AND OUTSIDE CONTOUR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 3 / Seq: 30	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A

(U) VERIFY / RECORD MAGNETIC PERMEABILITY OF STIFFENERS. RECORD I.D.C. DATA.

Sub ID	Part ID	Qty	Drawing ID / Rev
14	SE121-001P-2 PANEL # 1	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 14 / Seq: 10	410-BURNOUT TABLE	1.00	1.00	1.00	SE121 / A

(U) 1. PRIOR TO BEGINNING WORK, CONTACT Q/A TO PERFORM A SERIES OF MATERIAL THICKNESS AND MAGNETIC PERMEABILITY TESTS ON THE RAW MATEIRAL (PRIOR TO MATERIAL PROCESSING AND HANDLING BY MTM). FILL OUT I.D.C. DATA ACCORDINGLY.
2. NEST AND PROGRAM PER PROVIDED GEOMETRY.

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

3. BURNOUT AND CLEANUP PANEL PER NESTING / PROGRAM.
4. CLEANUP EDGES. ENSURE ALL DROSS AND RE-CAST LAYER IS REMOVED, BLENDED SMOOTH, AND CORNERS ARE SLIGHTLY RADIUSED.
5. REPEAT MAGNETIC PERMEABILITY INSPECTION AFTER PANELS ARE CUT, CLEAN, AND READY FOR NEXT OPERATION.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10	INCONEL 625_5-PLATE,NICKEL ALLOY .375" THK	1.0		1810	
	Vendor Part ID: INCONEL 625_5				
(U)	INCONEL 625 (UNS N06625) PER ASTM B 443-00				
	ANNEALED				
	MAGNETIC PERMEABILITY SHALL NOT EXCEED 1.00 (REF. ASTM A800).				
	SURFACE MUST BE PROTECTED FROM CONTACT WITH IRON AND IRON ALLOY MATERIALS				
	CERTS & MILL TEST REPORTS REQ'D WITH SHIPMENT.				

Material Certification:
Part Number: SE121-2A
Part Description: DIE FORMED PANEL # 1

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 14 / Seq: 15	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	VISUAL INSPECT SURFACE FINISH / VERIFY MAGNETIC PERMEABILITY OF THE RAW MATERIAL PRIOR TO CUTTING (MATERIALS DEPT. WILL COORDINATE) AND EACH PANEL AFTER CUTTING / CLEANING PER THE FOLLOWING:				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Test Certification: MAG. PERMEABILITY CERT Rev:
Specification: ASTM A800 Rev:
Part Number: SE121-2A
Part Description: DIE FORMED PANEL # 1
Customer: PPPL
Serial Number: SE121-1

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 14 / Seq: 20	341-PACIFIC 750	1.00	1.00	1.00	SE121 / A

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

(U) FORM PANEL IN DIE # _____.
VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX.
VERIFY THE PANEL MATERIAL EXTENDS BEYOND THE PERIMETER OF THE TRIM-LINES OF THE GAGE BY AT LEAST 1".

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 14 / Seq: 25	260-SANDBLAST	1.00	1.00	1.00	SE121 / A

(U) SHOT BLAST WITH 180-220 GRIT VIRGIN ALUMINUM OXIDE MEDIA.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev	Service ID
Sub: 14 / Seq: 30	520-SUBLET, EXOTIC HEAT TREAT	1.00	1.00	1.00	SE121 / A	THRML TR/NA SA

(U) SOLUTION ANNEAL FORMED PANEL PER THE FOLLOWING:

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.
Specification: TBD
Certification: H/T CERTIFICATE
Part Number: SE121-2A
Part Description: DIE FORMED PANEL # 1
Customer: PPPL

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 14 / Seq: 35	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A

(U) VISUAL INSPECT SURFACE FOR DAMAGE, PITTING, GOUGES, SCRAPES ETC.....

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

VERIFY MAGNETIC PERMEABILITY AND RECORD I.D.C. DATA

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 14 / Seq: 40	341-PACIFIC 750	1.00	1.00	1.00	SE121 / A
(U)	RE-STRIKE PANEL				

VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX.
LAYOUT TRIM-LINES ON THE PANEL ESTABLISHED FROM THE MACHINED PERIMETER OF THE INSPECTION GAGE.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 14 / Seq: 50	260-SANDBLAST	1.00	1.00	1.00	SE121 / A
(U)	SHOT BLAST WITH 180-220 GRIT VIRGIN ALUMINUM OXIDE MEDIA.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 14 / Seq: 60	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A
(U)	TRIM PERIMETER TO PROVIDED TRIM-LINES. NOTE THAT INSTALLING THE WELD PREP IS NOT REQUIRED AT THIS STAGE (ADDITIONAL FITTING / TRIMMING MAY BE REQUIRED AT INSTALLATION)				

SAND AND POLISH THE INSIDE SURFACE 100% TO ACHIEVE A 32 MICRO SURFACE FINISH.
INSTALL PROTECTIVE COVERING OVER THE MAJORITY OF THE POLISHED SURFACE (STAYING CLEAR OF THE WELD JOINTS)

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 14 / Seq: 70	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A

(U)
VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX. PERIMETER SHOULD FALL WITHIN .03" OF GAGE PERIMETER.
INSPECT AND RECORD INTERIOR SIDE SURFACE FINISH.
INSPECT AND RECORD MAGNETIC PERMEABILY.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.
Test Certification: MTM INSPECTION MAP Rev:
Part Number: SE121-2A
Part Description: DIE FORMED PANEL # 1

Sub ID	Part ID	Qty	Drawing ID / Rev
15	SE121-001P-2 PANEL # 2	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 15 / Seq: 10	410-BURNOUT TABLE	1.00	1.00	1.00	SE121 / A

(U)
1. PRIOR TO BEGINNING WORK, CONTACT Q/A TO PERFORM A SERIES OF MATERIAL THICKNESS AND MAGNETIC PERMEABILITY TESTS ON THE RAW MATEIRAL (PRIOR TO MATERIAL PROCESSING AND HANDLING BY MTM). FILL OUT I.D.C. DATA ACCORDINGLY.
2. NEST AND PROGRAM PER PROVIDED GEOMETRY.
3. BURNOUT AND CLEANUP PANEL PER NESTING / PROGRAM.
4. CLEANUP EDGES. ENSURE ALL DROSS AND RE-CAST LAYER IS REMOVED, BLENDED SMOOTH, AND CORNERS ARE SLIGHTLY RADIUSED.
5. REPEAT MAGNETIC PERMEABILITY INSPECTION AFTER PANELS ARE CUT, CLEAN, AND READY FOR NEXT OPERATION.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10	INCONEL 625_5-PLATE,NICKEL ALLOY .375" THK	1.0		1810	
	Vendor Part ID: INCONEL 625_5				

(U)
INCONEL 625 (UNS N06625) PER ASTM B 443-00
ANNEALED
MAGNETIC PERMEABILITY SHALL NOT EXCEED 1.00 (REF. ASTM A800).
SURFACE MUST BE PROTECTED FROM CONTACT WITH IRON AND IRON ALLOY MATERIALS
CERTS & MILL TEST REPORTS REQ'D WITH SHIPMENT.

Material Certification:

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Part Number: SE121-2B
Part Description: DIE FORMED PANEL # 2

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 15 / Seq: 15	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A

(U)
VISUAL INSPECT SURFACE FINISH / VERIFY MAGNETIC PERMEABILITY OF THE RAW MATERIAL PRIOR TO CUTTING (MATERIALS DEPT. WILL COORDINATE) AND EACH PANEL AFTER CUTTING / CLEANING PER THE FOLLOWING:

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Test Certification: MAG. PERMEABILITY CERT Rev:
Specification: ASTM A800 Rev:
Part Number: SE121-2B
Part Description: DIE FORMED PANEL # 2
Customer: PPPL
Serial Number: SE121-2

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 15 / Seq: 20	341-PACIFIC 750	1.00	1.00	1.00	SE121 / A

(U)
FORM PANEL IN DIE # _____.
VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX.
VERIFY THE PANEL MATERIAL EXTENDS BEYOND THE PERIMETER OF THE TRIM-LINES OF THE GAGE BY AT LEAST 1".

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 15 / Seq: 25	260-SANDBLAST	1.00	1.00	1.00	

(U)
SHOT BLAST WITH 180-220 GRIT VIRGIN ALUMINUM OXIDE MEDIA.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev	Service ID
Sub: 15 / Seq: 30	520-SUBLET, EXOTIC HEAT TREAT	1.00	1.00	1.00	SE121 / A	THRML TR/NA SA
(U)	SOLUTION ANNEAL FORMED PANEL PER THE FOLLOWING:					

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.
Specification: TBD
Certification: H/T CERTIFICATE
Part Number: SE121-2B
Part Description: DIE FORMED PANEL # 2
Customer: PPPL

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 15 / Seq: 35	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	VISUAL INSPECT SURFACE FOR DAMAGE, PITTING, GOUGES, SCRAPES ETC.....				
	VERIFY MAGNETIC PERMEABILITY AND RECORD I.D.C. DATA				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 15 / Seq: 40	341-PACIFIC 750	1.00	1.00	1.00	SE121 / A
(U)	RE-STRIKE PANEL				
	VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX.				
	LAYOUT TRIM-LINES ON THE PANEL ESTABLISHED FROM THE MACHINED PERIMETER OF THE INSPECTION GAGE.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 15 / Seq: 50	260-SANDBLAST	1.00	1.00	1.00	SE121 / A
(U)	SHOT BLAST WITH 180-220 GRIT VIRGIN ALUMINUM OXIDE MEDIA.				

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 15 / Seq: 60	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A

(U)
TRIM PERIMETER TO PROVIDED TRIM-LINES. NOTE THAT INSTALLING THE WELD PREP IS NOT REQUIRED AT THIS STAGE (ADDITIONAL FITTING / TRIMMING MAY BE REQUIRED AT INSTALLATION)
SAND AND POLISH THE INSIDE SURFACE 100% TO ACHIEVE A 32 MICRO SURFACE FINISH.
INSTALL PROTECTIVE COVERING OVER THE MAJORITY OF THE POLISHED SURFACE (STAYING CLEAR OF THE WELD JOINTS)

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 15 / Seq: 70	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A

(U)
VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX. PERIMETER SHOULD FALL WITHIN .03" OF GAGE PERIMETER.
INSPECT AND RECORD INTERIOR SIDE SURFACE FINISH.
INSPECT AND RECORD MAGNETIC PERMEABILY.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.
Test Certification: MTM INSPECTION MAP Rev:
Part Number: SE121-2B
Part Description: DIE FORMED PANEL # 2

Sub ID	Part ID	Qty	Drawing ID / Rev
16	SE121-001P-2 PANEL # 3	1	/

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 16 / Seq: 10	410-BURNOUT TABLE	1.00	1.00	1.00	SE121 / A

(U)

1. PRIOR TO BEGINNING WORK, CONTACT Q/A TO PERFORM A SERIES OF MATERIAL THICKNESS AND MAGNETIC PERMEABILITY TESTS ON THE RAW MATEIRAL (PRIOR TO MATERIAL PROCESSING AND HANDLING BY MTM). FILL OUT I.D.C. DATA ACCORDINGLY.
2. NEST AND PROGRAM PER PROVIDED GEOMETRY.
3. BURNOUT AND CLEANUP PANEL PER NESTING / PROGRAM.
4. CLEANUP EDGES. ENSURE ALL DROSS AND RE-CAST LAYER IS REMOVED, BLENDED SMOOTH, AND CORNERS ARE SLIGHTLY RADIUSED.
5. REPEAT MAGNETIC PERMEABILITY INSPECTION AFTER PANELS ARE CUT, CLEAN, AND READY FOR NEXT OPERATION.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10	INCONEL 625_5-PLATE,NICKEL ALLOY .375" THK	1.0		1810	
	Vendor Part ID: INCONEL 625_5				

(U)

INCONEL 625 (UNS N06625) PER ASTM B 443-00
ANNEALED
MAGNETIC PERMEABILITY SHALL NOT EXCEED 1.00 (REF. ASTM A800).
SURFACE MUST BE PROTECTED FROM CONTACT WITH IRON AND IRON ALLOY MATERIALS
CERTS & MILL TEST REPORTS REQ'D WITH SHIPMENT.

Material Certification:
Part Number: SE121-2C
Part Description: DIE FORMED PANEL # 3

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 16 / Seq: 15	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A

(U)

VISUAL INSPECT SURFACE FINISH / VERIFY MAGNETIC PERMEABILITY OF THE RAW MATERIAL PRIOR TO CUTTING (MATERIALS DEPT. WILL COORDINATE) AND EACH PANEL AFTER CUTTING / CLEANING PER THE FOLLOWING:

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Test Certification: MAG. PERMEABILITY CERT Rev:
Specification: ASTM A800 Rev:
Part Number: SE121-2C
Part Description: DIE FORMED PANEL # 3
Customer: PPPL

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Serial Number: SE121-3

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 16 / Seq: 20	341-PACIFIC 750	1.00	1.00	1.00	SE121 / A
(U)	FORM PANEL IN DIE # _____.				

VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX.
VERIFY THE PANEL MATERIAL EXTENDS BEYOND THE PERIMETER OF THE TRIM-LINES OF THE GAGE BY AT LEAST 1".

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 16 / Seq: 25	260-SANDBLAST	1.00	1.00	1.00	
(U)	SHOT BLAST WITH 180-220 GRIT VIRGIN ALUMINUM OXIDE MEDIA.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev	Service ID
Sub: 16 / Seq: 30	520-SUBLET, EXOTIC HEAT TREAT	1.00	1.00	1.00	SE121 / A	THRML TR/NA SA
(U)	SOLUTION ANNEAL FORMED PANEL PER THE FOLLOWING:					

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.
Specification: TBD
Certification: H/T CERTIFICATE
Part Number: SE121-2C
Part Description: DIE FORMED PANEL # 3
Customer: PPPL

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 16 / Seq: 35	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	VISUAL INSPECT SURFACE FOR DAMAGE, PITTING, GOUGES, SCRAPES ETC..... VERIFY MAGNETIC PERMEABILITY AND RECORD I.D.C. DATA				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 16 / Seq: 40	341-PACIFIC 750	1.00	1.00	1.00	SE121 / A
(U)	RE-STRIKE PANEL VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX. LAYOUT TRIM-LINES ON THE PANEL ESTABLISHED FROM THE MACHINED PERIMETER OF THE INSPECTION GAGE. ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING: THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 16 / Seq: 50	260-SANDBLAST	1.00	1.00	1.00	SE121 / A
(U)	SHOT BLAST WITH 180-220 GRIT VIRGIN ALUMINUM OXIDE MEDIA. ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING: THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 16 / Seq: 60	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A
(U)	TRIM PERIMETER TO PROVIDED TRIM-LINES. NOTE THAT INSTALLING THE WELD PREP IS NOT REQUIRED AT THIS STAGE (ADDITIONAL FITTING / TRIMMING MAY BE REQUIRED AT INSTALLATION) SAND AND POLISH THE INSIDE SURFACE 100% TO ACHIEVE A 32 MICRO SURFACE FINISH. INSTALL PROTECTIVE COVERING OVER THE MAJORITY OF THE POLISHED SURFACE (STAYING CLEAR OF THE WELD JOINTS) ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING: THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING				

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 16 / Seq: 70	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX. PERIMETER SHOULD FALL WITHIN .03" OF GAGE PERIMETER. INSPECT AND RECORD INTERIOR SIDE SURFACE FINISH. INSPECT AND RECORD MAGNETIC PERMEABILY.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.
Test Certification: MTM INSPECTION MAP Rev:
Part Number: SE121-2C
Part Description: DIE FORMED PANEL # 3

Sub ID	Part ID	Qty	Drawing ID / Rev
17	SE121-001P-2 PANEL # 4	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 17 / Seq: 10	410-BURNOUT TABLE	1.00	1.00	1.00	SE121 / A
(U)	1. PRIOR TO BEGINNING WORK, CONTACT Q/A TO PERFORM A SERIES OF MATERIAL THICKNESS AND MAGNETIC PERMEABILITY TESTS ON THE RAW MATEIRAL (PRIOR TO MATERIAL PROCESSING AND HANDLING BY MTM). FILL OUT I.D.C. DATA ACCORDINGLY. 2. NEST AND PROGRAM PER PROVIDED GEOMETRY. 3. BURNOUT AND CLEANUP PANEL PER NESTING / PROGRAM. 4. CLEANUP EDGES. ENSURE ALL DROSS AND RE-CAST LAYER IS REMOVED, BLENDED SMOOTH, AND CORNERS ARE SLIGHTLY RADIUSED. 5. REPEAT MAGNETIC PERMEABILITY INSPECTION AFTER PANELS ARE CUT, CLEAN, AND READY FOR NEXT OPERATION.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10	INCONEL 625_5-PLATE,NICKEL ALLOY .375" THK Vendor Part ID: INCONEL 625_5	1.0		1810	
(U)	INCONEL 625 (UNS N06625) PER ASTM B 443-00 ANNEALED				

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

MAGNETIC PERMEABILITY SHALL NOT EXCEED 1.00 (REF. ASTM A800).
SURFACE MUST BE PROTECTED FROM CONTACT WITH IRON AND IRON ALLOY MATERIALS
CERTS & MILL TEST REPORTS REQ'D WITH SHIPMENT.

Material Certification:
Part Number: SE121-2D
Part Description: DIE FORMED PANEL # 4

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 17 / Seq: 15	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	VISUAL INSPECT SURFACE FINISH / VERIFY MAGNETIC PERMEABILITY OF THE RAW MATERIAL PRIOR TO CUTTING (MATERIALS DEPT. WILL COORDINATE) AND EACH PANEL AFTER CUTTING / CLEANING PER THE FOLLOWING:				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Test Certification: MAG. PERMEABILITY CERT Rev:
Specification: ASTM A800 Rev:
Part Number: SE121-2D
Part Description: DIE FORMED PANEL # 4
Customer: PPPL
Serial Number: SE121-4

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 17 / Seq: 20	341-PACIFIC 750	1.00	1.00	1.00	SE121 / A
(U)	FORM PANEL IN DIE # _____.				

VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX.
VERIFY THE PANEL MATERIAL EXTENDS BEYOND THE PERIMETER OF THE TRIM-LINES OF THE GAGE BY AT LEAST 1".

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 17 / Seq: 25	260-SANDBLAST	1.00	1.00	1.00	
(U)	SHOT BLAST WITH 180-220 GRIT VIRGIN ALUMINUM OXIDE MEDIA.				

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev	Service ID
Sub: 17 / Seq: 30	520-SUBLET, EXOTIC HEAT TREAT	1.00	1.00	1.00	SE121 / A	THRML TR/NA SA
(U)	SOLUTION ANNEAL FORMED PANEL PER THE FOLLOWING:					

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.
Specification: TBD
Certification: H/T CERTIFICATE
Part Number: SE121-2D
Part Description: DIE FORMED PANEL # 4
Customer: PPPL

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 17 / Seq: 35	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	VISUAL INSPECT SURFACE FOR DAMAGE, PITTING, GOUGES, SCRAPES ETC.....				
	VERIFY MAGNETIC PERMEABILITY AND RECORD I.D.C. DATA				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 17 / Seq: 40	341-PACIFIC 750	1.00	1.00	1.00	SE121 / A
(U)	RE-STRIKE PANEL				
	VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX.				
	LAYOUT TRIM-LINES ON THE PANEL ESTABLISHED FROM THE MACHINED PERIMETER OF THE INSPECTION GAGE.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 17 / Seq: 50	260-SANDBLAST	1.00	1.00	1.00	SE121 / A

(U) SHOT BLAST WITH 180-220 GRIT VIRGIN ALUMINUM OXIDE MEDIA.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 17 / Seq: 60	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A

(U) TRIM PERIMETER TO PROVIDED TRIM-LINES. NOTE THAT INSTALLING THE WELD PREP IS NOT REQUIRED AT THIS STAGE (ADDITIONAL FITTING / TRIMMING MAY BE REQUIRED AT INSTALLATION)
SAND AND POLISH THE INSIDE SURFACE 100% TO ACHIEVE A 32 MICRO SURFACE FINISH.
INSTALL PROTECTIVE COVERING OVER THE MAJORITY OF THE POLISHED SURFACE (STAYING CLEAR OF THE WELD JOINTS)

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 17 / Seq: 70	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A

(U) VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX. PERIMETER SHOULD FALL WITHIN .03" OF GAGE PERIMETER.
INSPECT AND RECORD INTERIOR SIDE SURFACE FINISH.
INSPECT AND RECORD MAGNETIC PERMEABILY.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.
Test Certification: MTM INSPECTION MAP Rev:
Part Number: SE121-2D
Part Description: DIE FORMED PANEL # 4

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Sub ID	Part ID	Qty	Drawing ID / Rev
18	SE121-001P-2 PANEL # 5	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 18 / Seq: 10	410-BURNOUT TABLE	1.00	1.00	1.00	SE121 / A

(U)

1. PRIOR TO BEGINNING WORK, CONTACT Q/A TO PERFORM A SERIES OF MATERIAL THICKNESS AND MAGNETIC PERMEABILITY TESTS ON THE RAW MATEIRAL (PRIOR TO MATERIAL PROCESSING AND HANDLING BY MTM). FILL OUT I.D.C. DATA ACCORDINGLY.
2. NEST AND PROGRAM PER PROVIDED GEOMETRY.
3. BURNOUT AND CLEANUP PANEL PER NESTING / PROGRAM.
4. CLEANUP EDGES. ENSURE ALL DROSS AND RE-CAST LAYER IS REMOVED, BLENDED SMOOTH, AND CORNERS ARE SLIGHTLY RADIUSED.
5. REPEAT MAGNETIC PERMEABILITY INSPECTION AFTER PANELS ARE CUT, CLEAN, AND READY FOR NEXT OPERATION.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10	INCONEL 625_5-PLATE,NICKEL ALLOY .375" THK Vendor Part ID: INCONEL 625_5	1.0		1810	

(U)

INCONEL 625 (UNS N06625) PER ASTM B 443-00
ANNEALED
MAGNETIC PERMEABILITY SHALL NOT EXCEED 1.00 (REF. ASTM A800).
SURFACE MUST BE PROTECTED FROM CONTACT WITH IRON AND IRON ALLOY MATERIALS
CERTS & MILL TEST REPORTS REQ'D WITH SHIPMENT.

Material Certification:
Part Number: SE121-2E
Part Description: DIE FORMED PANEL # 5

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 18 / Seq: 15	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A

(U)

VISUAL INSPECT SURFACE FINISH / VERIFY MAGNETIC PERMEABILITY OF THE RAW MATERIAL PRIOR TO CUTTING (MATERIALS DEPT. WILL COORDINATE) AND EACH PANEL AFTER CUTTING / CLEANING PER THE FOLLOWING:

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Test Certification: MAG. PERMEABILITY CERT Rev:
Specification: ASTM A800 Rev:
Part Number: SE121-2E
Part Description: DIE FORMED PANEL # 5
Customer: PPPL
Serial Number: SE121-5

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 18 / Seq: 20	341-PACIFIC 750	1.00	1.00	1.00	SE121 / A

(U) FORM PANEL IN DIE # _____.
VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX.
VERIFY THE PANEL MATERIAL EXTENDS BEYOND THE PERIMETER OF THE TRIM-LINES OF THE GAGE BY AT LEAST 1".

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 18 / Seq: 25	260-SANDBLAST	1.00	1.00	1.00	

(U) SHOT BLAST WITH 180-220 GRIT VIRGIN ALUMINUM OXIDE MEDIA.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev	Service ID
Sub: 18 / Seq: 30	520-SUBLET, EXOTIC HEAT TREAT	1.00	1.00	1.00	SE121 / A	THRML TR/NA SA

(U) SOLUTION ANNEAL FORMED PANEL PER THE FOLLOWING:

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Specification: TBD
Certification: H/T CERTIFICATE
Part Number: SE121-2E
Part Description: DIE FORMED PANEL # 5
Customer: PPPL

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 18 / Seq: 35	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	VISUAL INSPECT SURFACE FOR DAMAGE, PITTING, GOUGES, SCRAPES ETC..... VERIFY MAGNETIC PERMEABILITY AND RECORD I.D.C. DATA				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 18 / Seq: 40	341-PACIFIC 750	1.00	1.00	1.00	SE121 / A
(U)	RE-STRIKE PANEL VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX. LAYOUT TRIM-LINES ON THE PANEL ESTABLISHED FROM THE MACHINED PERIMETER OF THE INSPECTION GAGE. ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING: THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 18 / Seq: 50	260-SANDBLAST	1.00	1.00	1.00	SE121 / A
(U)	SHOT BLAST WITH 180-220 GRIT VIRGIN ALUMINUM OXIDE MEDIA. ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING: THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 18 / Seq: 60	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A
(U)	TRIM PERIMETER TO PROVIDED TRIM-LINES. NOTE THAT INSTALLING THE WELD PREP IS NOT REQUIRED AT THIS STAGE (ADDITIONAL FITTING / TRIMMING MAY BE REQUIRED AT INSTALLATION) SAND AND POLISH THE INSIDE SURFACE 100% TO ACHIEVE A 32 MICRO SURFACE FINISH. INSTALL PROTECTIVE COVERING OVER THE MAJORITY OF THE POLISHED SURFACE (STAYING CLEAR OF THE WELD JOINTS) ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:				

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 18 / Seq: 70	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	VERIFY PROFILE TO INSPECTION GAGE #_____. GAP TOLERANCE: .08" MAX. PERIMETER SHOULD FALL WITHIN .03" OF GAGE PERIMETER.				
	INSPECT AND RECORD INTERIOR SIDE SURFACE FINISH.				
	INSPECT AND RECORD MAGNETIC PERMEABILY.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.
Test Certification: MTM INSPECTION MAP Rev:
Part Number: SE121-2E
Part Description: DIE FORMED PANEL # 5

Sub ID	Part ID	Qty	Drawing ID / Rev
24	SURFACE FINISH TESTING TEST P	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 24 / Seq: 10	410-BURNOUT TABLE	1.00	1.00	1.00	SE121 / A
(C)	BURNOUT TEST PLATES PER MATERIAL CARD.				
	DEBURR AND SAND EDGES SMOOTH (WITH UNCONTAMINATED GRINDING WHEEL ONLY).				
	FORWARD ONE PLATE TO ENGINEERING (DOUG McCORKLE) AND PROCESS THE OTHER PER THE FOLLOWING ROUTING STEPS.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10	INCONEL 625_670-SHEET,NICKEL ALLOY .25" THK	480.0			480
(C)	INCONEL 625 SHEET, .25" THICK PER				

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

AMS 5599.
CERT AND MILL TEST REPORT REQ'D WITH SHIPMENT.

Material Certification: NONE REQ'D TEST SAMPLE

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 24 / Seq: 20	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A
(R)	SAND AND POLISH THE TEST PIECE (ONE SIDE) TO A 32 MICRO SURFACE FINISH				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 24 / Seq: 25	260-SANDBLAST	1.00	1.00	1.00	SE121 / A
(R)	MASK THE POLISHED SIDE AND BLAST THE OTHER SIDE WITH 180-220 GRIT VIRGIN ALUMINUM OXIDE.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Drw N/A

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 24 / Seq: 28	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A
(R)	CLEAN SAMPLE MATERIAL SURFACES PER THE FOLLOWING.....(cleaning specification being developed) WRAP THE PART IN PLASTIC FOAM.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Drw N/A

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Sub: 24 / Seq: 30 — 805-INPROCESS INSPECTION - PLANT — 1.00 — 1.00 — 1.00 — SE121 / A
(R)
VERIFY THE FOLLOWING TEST SAMPLE ATTIBUTES: SURFACE FINISH (PER ASME B46.1-1995)
CLEANLINESS (PER PROCEDURE ???? BEING DEVELOPED)
MAGNETIC PERMEABILITY (1.01 MAX)
REPORT RESULTS TO ENGINEERING (DOUG McCORKLE).

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Sub ID	Part ID	Qty	Drawing ID / Rev
26	WELD DISTORTION TESTING	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 26 / Seq: 10	410-BURNOUT TABLE	1.00	1.00	1.00	SE121 / A

(U)
NOTIFY Q/A FOR PERMEABILITY TESTING PRIOR TO BURING
BURNOUT TEST BLANK PER PROVIDED GEOMETRY (PANEL BLANK NUMBER 5)

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10	INCONEL 625_5-PLATE,NICKEL ALLOY .375" THK Vendor Part ID: INCONEL 625_5	1.0		1810	

(U)
INCONEL 625 (UNS N06625) PER ASTM B 443-00
ANNEALED
MAGNETIC PERMEABILITY SHALL NOT EXCEED 1.00 (REF. ASTM A800).
SURFACE MUST BE PROTECTED FROM CONTACT WITH IRON AND IRON ALLOY MATERIALS
CERTS & MILL TEST REPORTS REQ'D WITH SHIPMENT.

Material Certification:
Part Number: SE121-2E
Part Description: DIE FORMED PANEL

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 26 / Seq: 15	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A

(U)
VERIFY MAGNETIC PERMEABILITY OF PLATE MATERIAL PRIOR TO BURNING SHAPE AND AGAIN AFTERWARD. RECORD I.D.C. DATA

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 26 / Seq: 18	415-ROLLING/SHEAR/BRAKE PRESS	1.00	1.00	1.00	SE121 / A
(U)	ROLL CONE PER THE FOLLOWING: (INFORMATION BEING DEVELOPED, PENDING RECEIPT OF FINAL CUSTOMER ELECTRONIC MODEL DATA)				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 26 / Seq: 19	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	VERIFY MAGNETIC PERMEABILITY.....				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 26 / Seq: 20	341-PACIFIC 750	1.00	1.00	1.00	SE121 / A
(U)	FORM WELD TEST PANEL WITH THE CORRESPONDING DIE FORMED DETAIL (INFORMATION BEING DEVELOPED, DIE SET / PANEL # DECISION REQUIRED)				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 26 / Seq: 30	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A
(U)	SPLIT THE PANEL TO SIMULATE PRODUCTION WELD JOINT(S). PREP, FIT AND WELD JOINTS TO DEVELOP WELDING SEQUENCES AND MINIMIZE WELDING DISTORTION.				

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

REVIEW WITH ENGINEERING (DOUG McCORKLE)

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 26 / Seq: 40	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	VERIFY MAGNETIC PERMEABILITY OF THE WELD JOINT(S) AND HEAT AFFECTED ZONES. RECORD I.D.C. DATA.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Sub ID	Part ID	Qty	Drawing ID / Rev
19	SE121 PORT SUB-ASSEMBLY	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 19 / Seq: 10	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A
(F)	INSTALL AND WELD CONFLAT FLANGE TO TUBE PER DRAWING AND WPS..... FIT AND TRIM THE LENGTH FOR INSTALLATION (USE REFERENCE SCRIBE LINES ON BUILD FIXTURE). PREP FOR WELDING IN PLACE. GRIND / BLEND THE INTERIOR WELD SMOOTH. POLISH THE ENTIRE INSIDE SURFACE SMOOTH TO ACHIEVE A 32 MICRO SURFACE FINISH. CLEAN THE INTERIOR SURFACES PER.....				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 19 / Seq: 20	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	INSPECT INTERIOR SURFACE FINISH OF THE PORT SUB-ASSEMBLY. RECORD ACTUAL ON MTM IDC.				

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

INSPECT THE MAGNETIC PERMEABILITY OF THE FLANGE TO TUBE WELD AND SURROUNDING AREA. RECORD ACTUAL RANGE ON I.D.C.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Sub ID	Part ID	Qty	Drawing ID / Rev
20	CONFLAT FLANGE	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 20 / Seq: 10	820-RECEIVING INSPECTION	1.00	1.00	1.00	SE121 / A
(R)	RECEIVING INSPECTION				
	RECEIVE AND INSPECT THE FOLLOWING PARTS:				
	(THEY SHOULD ALL ARRIVE TOGETHER)				
	F10000000NC4				
	FG1000CI				
	FG1000VU				
	FB1000C12S				
	GC0275S				
	CONTACT ENGINEERING (DOUG McCORKLE) WHEN PARTS ARRIVE.				

IDC N/A

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10	F10000000NC4-FLANGE, CONFLAT, NON-ROTATE, 10.00"	1.0			
(R)	FLANGE, CONFLAT, NON-ROTATABLE				
	10.00 X BLANK X 0.97", CLEAR BOLT HOLES, 304L				
	Material Certification:				
	Part Number: F10000000NC4				

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
20	FG1000CI-GASKET KIT (10/PK), COPPER, FOR 10" CFF	1.0			
(R)	GASKET KIT (10/PACK), COPPER, INDIVIDUAL SEAL, FOR 10" CONFLAT FLANGE				
	VARIAN VACUUM TECHNOLOGIES				
	Material Certification:				
	Part Number: FG1000CI				

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
30	FG1000VU-GASKET, VITON, FOR 10" CFF	1.0			
(R)	GASKET, VITON, FOR 10" CONFLAT FLANGE				
	VARIAN VACUUM TECHNOLOGIES				
	Material Certification:				
	Part Number: FG1000VU				

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
40	FB1000C12S-BOLT AND NUT KIT, 12 PT, SILVER PLATED	1.0			
(R)	BOLT AND NUT KIT (25/PACK), 12 POINT, ASTM A193 GR. B8 SILVER PLATED, FOR 10" CONFLAT FLANGE VARIAN VACUUM TECHNOLOGIES				

Material Certification:
Part Number: FB1000C12S

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
50	GC0275S-GASKET CLIP KIT (10/PK), FOR 10" CFF	1.0			
(R)	GASKET CLIP KIT (10/PACK) FOR 10" CONFLAT FLANGE VARIAN VACUUM TECHNOLOGIES				

Material Certification:
Part Number: GC0275S

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 20 / Seq: 20	108-TOOL ROOM - PLANT 1	1.00	1.00	1.00	
(U)	BORE THE I.D. PER SKETCH PROVIDED BY ENGINEERING. CONTACT DOUG McCORKLE IF UNCLEAR.				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
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Drw N/A IDC N/A

Sub ID	Part ID	Qty	Drawing ID / Rev
21	PORT EXTENSION TUBE	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 21 / Seq: 10	820-RECEIVING INSPECTION	1.00	1.00	1.00	SE121 / A
(R)	RECEIVE AND INSPECT TUBE PER MTM P.O. NOTIFY ENGINEERING (DOUG McCORKLE) WHEN PART ARRIVES. VISUAL INSPECT SURFACE FINISH FOR PITS, NICKS, GOUGES, SCRAPES, SCRATCHES, ETC....				

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

10 SE121-001P-5-INCO 625 TUBE 8.0" OD X .12" WA. X 18.0" 1.0 5647
Vendor Part ID: SE121-001P-5
(R) TUBE, ROUND, INCONEL 625, SEAMLESS OR WELDED. ASTM B444 OR ASTM B705
MTM AUTHORIZATION OF WELDING PROCEDURE REQUIRED PRIOR TO STARTING WORK.
NOTE THAT THE FOLLOWING REQUIREMENTS WILL BE PERFORMED / TESTED BY MAJOR TOOL & MACHINE AFTER DELIVERY. ALL EFFORTS TO ACCOMODATE / ENSURE SUCESS MUST BE MAINTAINED:
MAGNETIC PERMEABILITY REQUIREMENT: 1.01 MAX.
VACUUM INTEGRITY REQUIREMENT: TOTAL HELIUM LEAK RATE FOR THE TUBE SHALL BE LESS THAN OR EQUAL TO 1.7 X 10(-9) TORR-L/S
INTERIOR SURFACE FINISH REQUIREMENT: INTERIOR WELD BEADS WILL BE GROUND FLUSH. THE ENTIRE INTERIOR SURFACE WILL BE POLISHED TO A 32 MICRO SURFACE FINISH AND VERIFIED PER ASME B46.1.
EXTERIOR SURFACE FINISH: MILL SURFACE ACCEPTABLE. NO PITS, SCRAPES OR GOUGES.
MATERIAL CERTIFICATION AND TEST REPORTS REQ'D WITH SHIPMENT.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 21 / Seq: 20	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A

(U) VERIFY MAGNETIC PERMEABILITY OF THE PORT EXTENTION TUBE (AS RECEIVED). RECORD ACTUAL I.D.C.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Drw N/A

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 21 / Seq: 30	405-SAWS- PLANT 2	1.00	1.00	1.00	SE121 / A

(U) SAW ONE END SQUARE REMOVING NO MORE THAN 1/2" OF MATERIAL.
DEBURR SAWED EDGE

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:
THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 21 / Seq: 40	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121 / A

(U) BLEND THE INSIDE WELD FLUSH.
POLISH THE ENTIRE INTERIOR SURFACE TO A 32 MICRO-INCH SURFACE FINISH.
PREP FOR FLANGE INSTALLATION.

ATTENTION: PRIOR TO HANDLING THE PARTS OR COMENSING ANY WORK, READ AND UNDERSTAND THE FOLLOWING:

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

THE MAGNETIC PERMEABILITY, VACUUM INTEGRITY, AND SURFACE FINISH REQUIREMENTS FOR THIS VESSEL ARE VERY STRINGENT. ALL EFFORTS MUST BE MADE TO AVOID SURFACE CONTAMINATION AND DAMAGE WHILE PROCESSING / HANDLING THIS MATERIAL. IT MUST NOT COME IN DIRECT CONTACT WITH IRON OR IRON BASED MATERIALS (EG CHAINS, CLAMPS, LIFT TRUCK FORKS, STEEL RACKS, TABLES, HAND TOOLS, ETC...) IT MUST NOT BE STORED, STACKED, OR STAGED DIRECTLY ONTO IRON OR STEEL FIXTURING. DO NOT USE ANY TOOLS (EG BRUSHES / GRINDING WHEELS) THAT ARE EITHER FERROUS, OR MAY HAVE BEEN PREVIOUSLY USED ON FERROUS ALLOYS. WELDING OF TOOLING AND/OR FIXTURING (EG HALF CLAMPS, BRACING, ETC…) TO THE COMPONENT PART MUST BE MINIMIZED (ENGINEERING CONCURRENCE REQUIRED FOR ALL CERCUMSTANCES). IN ALL SUCH CASES INCONEL 625 TABS MUST BE ATTACHED TO THE TOOL / FIXTURE TO AVOID CONTAMINATION TO THE PRODUCTION MATERIAL. EXTREME CARE MUST BE TAKEN TO ENSURE THE SURFACES ARE PROTECTED FROM GOUGING, SCRATCHING, AND ANY CONTACT WITH FORIGN MATERIAL. CONTACT ENGINEERING (DOUG McCORKLE) IF UNCLEAR.

Sub ID	Part ID	Qty	Drawing ID / Rev
23	VACUUM TEST CAP	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 23 / Seq: 10	410-BURNOUT TABLE	1.00	1.00	1.00	
(U)	BURNOUT A 10.0" DIAMETER DISK AND CLEANUP. SAND THE BURNED EDGES SMOOTH.				

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10	304L_8-PLATE,SST .75" THK Vendor Part ID: 304L_8 Mfg Part ID: 304L MATERIAL	100.0		1810	100
(U)	PLATE, 304L STAINLESS STEEL .75" THK CERTS & MILL TEST REPORT REQ'D WITH SHIPMENT.				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 23 / Seq: 20	108-TOOL ROOM - PLANT 1	1.00	1.00	1.00	
(U)	MACHINE PER DRAWING (DRAWING NEEDED!!!!) (GRIND ONE FACE AND DRILL BOLT CIRCLE, DRILL TAP VACUUM PORT (1/2" NPT)) DRILL AND REAM A CENTER HOLE FOR TOOLING BALL (.2500", TOLERANCE TBD). THIS WILL BE USED AS A TARGET FOR SMX INSPECTION AFTER INSTALLATION TO VERIFY POSITION OF THE PORT. REF CONFLAT FLANGE DRAWING FOR BOLT CIRCLE GRIND 32 SURFACE FINISH ON ONE SIDE APPLY A WOOD OR CARDBOARD PROTECTOR ONTO THE GROUND FACE.				

Sub ID	Part ID	Qty	Drawing ID / Rev
25	PORT EXTENSION WELD BACKING RI	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 25 / Seq: 10	415-ROLLING/SHEAR/BRAKE PRESS	1.00	1.00	1.00	SE121-003P / 0
(U)	SHEAR STRIP PER MATERIAL CARD AND DEBURR. ROLL THE EASY WAY TO A 8.093" I.D. OBJ (0.031" WELD SHRINKAGE ALLOWANCE).				

Piece #	Part ID	Qty	Drawing ID / Rev	Vendor	Dimensions
10	INCONEL 625_660-SHEET,NICKEL ALLOY .125" THK	72.0			2*36
(U)	INCONEL 625 SHEET, .125" THICK PER AMS 5599 / ASTM B443 (UNS N06625). CERT AND MILL TEST REPORT REQ'D WITH SHIPMENT.				

Workorder	Part ID	Qty	Drawing ID / Rev	Engineer
64880/1		1	SE121 / A	BLUE/DOUG MCCORKLE

Material Certification:
Part Number: SE121-003P-4
Part Description: WELD BACKING RING

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 25 / Seq: 20	230-FABRICATION - WEIDNER	1.00	1.00	1.00	SE121-003P / 0
(U)	PREP AND WELD PER DRAWING (SIZE TO EXISTING PORT TUBE) BLEND WELD FLUSH TO BASE METAL				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 25 / Seq: 30	415-ROLLING/SHEAR/BRAKE PRESS	1.00	1.00	1.00	SE121 / A
(U)	RE-ROLL / ROUND UP BAND				

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 25 / Seq: 40	805-INPROCESS INSPECTION - PLANT	1.00	1.00	1.00	SE121 / A
(U)	VERIFY MAGNETIC PERMEABILITY. RECORD I.D.C. DATA				

Sub ID	Part ID	Qty	Drawing ID / Rev
28	STORAGE / SHIPPING CRATE	1	/

Operation	Resource	QtyPer	StartQty	EndQty	Drawing ID / Rev
Sub: 28 / Seq: 10	425-SHIPPING - PLANTS 1 & 2	1.00	1.00	1.00	SE121 / A
(U)	BUILD STORAGE / SHIPPING CRATE PER ENGINEERING DRAWING				

Customer: 8780 - PRINCETON PLASMA PHYSICS LAB
Customer P.O.: S-04344-F
Customer Part ID: SE121 - NSCX Vacuum Vessel Prototype

Customer: 8780 - PRINCETON PLASMA PHYSICS LAB
Customer P.O.: S-04344-F
Customer Part ID: SE121 - NSCX Vacuum Vessel Prototype

PVVS PRELIMINARY INSPECTION PLAN

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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Verify Panel Joint Alignment (.02" Max)	VISUAL INSPECTIO	MFG CWI						
		Verify Panel / Rest Stop Position (0 - .09" Gap)	FEELER GAGE	MFG CWI						

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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		{g |,188"} Upper Half Of Bilateral Tolerance	SMX	QA						
		Magnetic Permeability 1.01 Max.		QA						

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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		{g |,375"} Preliminary Welding Under Stiffeners	SMX	QA						
		Magnetic Permeability (1.01 Max)		QA						

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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

PVVS PRELIMINARY INSPECTION PLAN

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		{g |,375} After Welding Stiffeners	SMX	QA						

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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability of Inconel 625 Materi d Weld Zones (1.01 Max)		QA						
		Magnetic Permeability of Conflat Flange (1.0 x)		QA						
		Magnetic Permeability of Weld / Heat Affecte ne (Flange to Tube) (1.2 Max)		QA						

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability (1.01 Max)		QA						

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Mag. Permeability Of Raw Plate		QA						

PVVS PRELIMINARY INSPECTION PLAN

		As Rec'D / Prior To Processing (Record Range)		ENG						
		Mag. Permeability Of Panel After Cutting And Cleanup (Record Range)		QA ENG						

Workorder: 64880/1-0 Sub:14 Op:15

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max.		QA						

Workorder: 64880/1-0 Sub:14 Op:20

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To Standard)	FEELER GAGE	MFG ENG						

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To Standard)	FEELER GAGE	MFG ENG						

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

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

Drawing ID: SE121 Rev: A	INSPECTION INSTRUCTIONS	RESULTS	INSPECTED BY

PVVS PRELIMINARY INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
			FEELER GAGE	QA						
		.08" Max Gap (Panel / Profile Gage)		ENG						

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
				MFG						
		Magnetic Permeability 1.01 Max								
			PROFILOMETER	QA						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)								

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
				QA						
		Magnetic Permeability 1.01 Max.								

Workorder: 64880/1-0 Sub:15 Op:20

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1			FEELER GAGE	MFG						
		.08" Max Gap (Part Surface To Standard)		ENG						

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

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

Drawing ID: SE121 Rev: A	INSPECTION INSTRUCTIONS	RESULTS	INSPECTED BY

PVVS PRELIMINARY INSPECTION PLAN

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

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
			FEELER GAGE	QA						
		.08" Max Gap (Panel / Profile Gage)		ENG						

Workorder: 64880/1-0 Sub:15 Op:70

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
				MFG						
		Magnetic Permeability 1.01 Max								
			PROFILOMETER	QA						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)								

Workorder: 64880/1-0 Sub:16 Op:15

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
				QA						
		Magnetic Permeability 1.01 Max.								

Workorder: 64880/1-0 Sub:16 Op:20

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

Drawing ID: SE121 Rev: A	INSPECTION INSTRUCTIONS	RESULTS	INSPECTED BY

PVVS PRELIMINARY INSPECTION PLAN

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

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1			FEELER GAGE	MFG						
		.08" Max Gap (Part Surface To Standard)		ENG						

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
			FEELER GAGE	QA						
		.08" Max Gap (Panel / Profile Gage)		ENG						

Workorder: 64880/1-0 Sub:16 Op:70

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
				MFG						
		Magnetic Permeability 1.01 Max								
			PROFILOMETER	QA						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)								

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

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

Drawing ID: SE121 Rev: A	INSPECTION INSTRUCTIONS	RESULTS	INSPECTED BY

PVVS PRELIMINARY INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
				QA						
		Magnetic Permeability 1.01 Max.								

Workorder: 64880/1-0 Sub:17 Op:20

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1			FEELER GAGE	MFG						
		.08" Max Gap (Part Surface To Standard)		ENG						

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1			FEELER GAGE	MFG						
		.08" Max Gap (Part Surface To Standard)		ENG						

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
			FEELER GAGE	QA						
		.08" Max Gap (Panel / Profile Gage)		ENG						

Workorder: 64880/1-0 Sub:17 Op:70

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
				MFG						
		Magnetic Permeability 1.01 Max								

PVVS PRELIMINARY INSPECTION PLAN

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

Workorder: 64880/1-0 Sub:18 Op:15

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max.		QA						

Workorder: 64880/1-0 Sub:18 Op:20

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To Standard)	FEELER GAGE	MFG ENG						

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To Standard)	FEELER GAGE	MFG ENG						

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		.08" Max Gap (Panel / Profile Gage)	FEELER GAGE	QA ENG						

PVVS PRELIMINARY INSPECTION PLAN

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

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max		MFG						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						

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

Part: - - SE121 PORT SUB-ASSEMBLY

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		32 Micro Surface Finish (Interior)	PROFILOMETER	QA						
		1.2 Max Magnetic Permeability (Flange To Tube)		QA						

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

Part: - - PORT EXTENSION TUBE

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.02 Max		QA						

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

Part: - - WELD DISTORTION TESTING

PVVS PRELIMINARY INSPECTION PLAN

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability Of Plate Prior To Cutting (1.01 Max)		QA						
		Magnetic Permeability Of Plate After Cutting (1.01 Max)		QA						

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

Part: - - WELD DISTORTION TESTING

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability Of Weld Zone (1.01		QA						
		Magnetic Permeability Of Heat Affected Zon 01 Max)		QA						