

INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

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

Revision: 12/11/03 15:23

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Verify Panel Joint Alignment Panel #1 to Panel #2 Joint (.02" Max)	VISUAL INSPECTION	MFG CWI						
*		Verify Panel Joint Alignment Panel #2 to Panel #3 Joint (.02" Max)	VISUAL INSPECTION	MFG CWI						
*		Verify Panel Joint Alignment Panel #3 to Panel #4 Joint (.02" Max)	VISUAL INSPECTION	MFG CWI						
*		Verify Panel Joint Alignment Panel #4 to Panel #5 Joint (.02" Max)	VISUAL INSPECTION	MFG CWI						
*		Verify Panel Joint Alignment Panel #5 to Panel #1 Joint (.02" Max)	VISUAL INSPECTION	MFG CWI						
*		Verify Panel / Rest Stop Position Panel #1 (0 - .09" Gap)	FEELER GAGE	MFG CWI						
*		Verify Panel / Rest Stop Position Panel #2 (0 - .09" Gap)	FEELER GAGE	MFG CWI						
*		Verify Panel / Rest Stop Position Panel #3 (0 - .09" Gap)	FEELER GAGE	MFG CWI						
*			FEELER GAGE	MFG						

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

		Verify Panel / Rest Stop Position Panel #4 (0 - .09" Gap)		CWI					
*		Verify Panel / Rest Stop Position Panel #5 (0 - .09" Gap)	FEELER GAGE	MFG					
				CWI					
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		CWI					
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		CWI					
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		CWI					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		CWI					
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		CWI					

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

Revision: 12/11/03 15:24

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

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

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

	Record range (high / low)								
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Workorder: 64880/1-0 Sub:1 Op:30

Revision: 12/04/03 8:41

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

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

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

Revision: 12/11/03 15:24

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		g ,375" vessel profile after root welds are complete	SMX	QA						

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

*		Magnetic Permeability (1.01 Max)	PERMEABILITY GAG	QA						
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Workorder: 64880/1-0 Sub:1 Op:70

Revision: 12/04/03 8:41

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

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

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

Revision: 12/11/03 15:25

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		{g ,375"}	SMX	QA						

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INSPECTION DATA CHECKLIST

INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

		Welded vessel profile							
*		Magnetic Permeability (1.01 Max)	PERMEABILITY GAG	QA					

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

Revision: 12/11/03 15:26

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

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

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

Revision: 12/11/03 15:26

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-002P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

*		{g ,375"} Profile at / near Port Extension	SMX	QA					
*		Magnetic Permeability (1.01 Max) (Port Stub / Port Extension)	PERMEABILITY GAG	QA					
*		32 MICRO-INCH RA SURFACE FINISH (PORT EXTENSION INTERIOR)	PROFILOMETER	QA					

Workorder: 64880/1-0 Sub:1 Op:115

Revision: 12/11/03 15:28

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

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

Revision: 12/11/03 15:29

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

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

Part: - - SE121 PROTOTYPE VACUUM VESSEL SEGMENT

Drawing ID: SE121-003P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability of all Inconel 625 Material And Weld Zones (1.01 Max)	PERMEABILITY GAG	QA						
*		Magnetic Permeability of Conflat Flange (1.02 Max)	PERMEABILITY GAG	QA						
*		Magnetic Permeability of Weld / Heat Affecte ne (Flange to Tube) (1.2 Max)	PERMEABILITY GAG	QA						
*		{g ,375} Finished part profile	SMX	QA						
*		{# d.125"p48" A B C} Port Extension position (after re-attachment)	SMX	QA						

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

Revision: 12/11/03 15:11

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		Magnetic Permeability 1.0 Max. (Panel Blank)	PERMEABILITY GAG	QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581-D.ED 09-25-03			A
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK	QA		J-160	.412	085-D.GR 10-02-03			A
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES,	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR			A

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

	PITS, OR GOUGES (Panel Blank)							10-02-03		
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Workorder: 64880/1-0 Sub:14 Op:31

Revision: 12/04/03 9:13

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

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

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

Revision: 12/11/03 15:11

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY OF ANNEALE 1.01 MAX	PERMEABILITY GAG	QA		J-1143	1.008-1.009	522-R.DU		
								10-29-03		

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

Revision: 10/29/03 10:55

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG QA			FEELER GAGE .080 (GOOD) FEELER GAGE	746-G.D 10-29-03	522-R.DU 10-29-03	

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

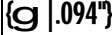
Revision: 12/11/03 15:12

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

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

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

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

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

Revision: 12/11/03 15:12

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		Magnetic Permeability 1.0 Max. (Panel Blank)	PERMEABILITY GAG	QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581-D.ED 09-25-03			A
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK O.D. MICS	QA		J-160	.405	085-D.GR 10-02-03			A
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR 10-02-03			A

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

Revision:

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

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

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

Revision: 12/11/03 15:13

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY OF ANNEALE 1.01 MAX	PERMEABILITY GAG	QA						

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

Revision:

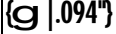
Part: - - SE121-001P-2 PANEL # 2

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG ENG						

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

Revision: 12/11/03 15:13

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	QA						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
*		 .094" .094" Max Gap (Part Surface To gauge)	TEMPLATE FEELER GAGE	QA ENG						

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

Revision: 12/11/03 15:14

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			PERMEABILITY GAG	QA			TESTED 15 RANDOM LO CATIONS, MAX. MAG.	581-D.ED		

A

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

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

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

Revision:

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

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

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

Revision: 12/11/03 15:14

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY OF ANNEALE 1.01 MAX	PERMEABILITY GAG	QA						

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

Revision:

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

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

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INSPECTION DATA CHECKLIST

INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

	.08" Max Gap (Part Surface To gauge)	ENG							
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Workorder: 64880/1-0 Sub:16 Op:70

Revision: 12/11/03 15:14

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	QA						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
*		g .094" .094" Max Gap (Part Surface To gauge)	TEMPLATE FEELER GAGE	QA ENG						

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

Revision: 12/11/03 15:15

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability 1.0 Max. (Panel Blank)	PERMEABILITY GAG	QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581-D.ED 09-25-03		A
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK O.D. MICS	QA		J-160	.396	085-D.GR 10-02-03		A
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR 10-02-03		A

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

Revision:

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

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

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SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		VERIFY HEAT TREAT CERTIFICATION AND FURNACE CHART COMPLY WITH MTM PURCHASE ORDER REQUIREMENTS		QA						

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

Revision: 12/11/03 15:15

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY OF ANNEALE 1.01 MAX	PERMEABILITY GAG	QA						

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

Revision:

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG ENG						

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

Revision: 12/11/03 15:16

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	QA						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
*		{g .094"} .094" Max Gap (Part Surface To gauge)	TEMPLATE FEELER GAGE	QA ENG						

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

Workorder: 64880/1-0 Sub:18 Op:10

Revision: 12/11/03 15:21

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		Magnetic Permeability 1.0 Max. (Panel Blank)	PERMEABILITY GAG	QA		J-1143	TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581-D.ED 09-25-03			A
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK O.D. MICS	QA		J-160	.415	085-D.GR 10-02-03			A
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR 10-02-03			A

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

Revision:

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

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

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

Revision: 12/11/03 15:22

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

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

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INSPECTION DATA CHECKLIST

INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

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

Revision:

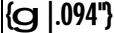
Part: - - SE121-001P-2 PANEL # 5

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1		.08" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG ENG						

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

Revision: 12/11/03 15:22

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

Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	QA						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
*		 .094" .094" Max Gap (Part Surface To gauge)	TEMPLATE FEELER GAGE	QA ENG						

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

Revision: 12/11/03 15:31

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

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

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

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

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

Revision: 12/11/03 15:32

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

Drawing ID: SE121-002P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		32 Micro Surface Finish (Interior)	PROFILOMETER	QA						
*		1.2 Max Magnetic Permeability (Flange To Tube)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:24 Op:30

Revision: 10/02/03 9:44

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

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		SURFACE FINISH: 32 MICRO ON ONE SIDE SMOOTH BLASTED SURFACE SIDE OPPOS	PROFILOMETER	QA		J-1152	22 TO 27 MICRO	139-R.S		
		CLEANLINESS PER PP475.	VISUAL INSPECTION	QA		VISUAL	ACC	139-R.S		

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

		MAGNETIC PERMEABILITY (1.01 MAX)		QA		J-1143	1.01	085-D.GR 10-02-03			A
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Workorder: 64880/1-0 Sub:25 Op:15

Revision: 12/11/03 15:30

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

Drawing ID: SE121-003P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
		MAGNETIC PERMEABILITY 1.01 MAX (AFTER ROLLING / PRIOR TO WELDING)	PERMEABILITY GAG	QA			15 RANDOM LOCATION HIGH=1.007, LOW=1.006	581-D.ED 09-22-03			A

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

Revision: 12/11/03 15:30

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

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

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START							
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Workorder: 64880/1-0 Sub:25 Op:40

Revision: 12/11/03 15:31

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

Drawing ID: SE121-003P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY 1.01 MAX	ULTRASONIC THICK	QA						
*		CLEANLINESS PER PP475		QA						

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

Revision: 11/06/03 10:07

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET # 1

Drawing ID: SE121 Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	MFG						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		.094" Max Gap (Part Surface To gauge)		QA ENG						

Workorder: 64880/1-0 Sub:29 Op:10

Revision: 12/11/03 15:33

Part: SE212-003P-3 - -

Drawing ID: SE121-002P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA			MAX. RECORDING OF P ERM. OF PLATE 1.002	581-D.ED		

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INSPECTION DATA CHECKLIST

INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

		MAGNETIC PERMEABILITY 1.01 MAX					, 12 PLCS. RANDOMLY CHECKED.	09-17-03		
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Workorder: 64880/1-0 Sub:29 Op:30

Revision: 12/11/03 15:34

Part: SE212-003P-3 - -

Drawing ID: SE121-002P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		MAGNETIC PERMEABILITY 1.01 MAX (AFTER ROLLING / PRIOR TO WELDING)	PERMEABILITY GAG	QA			21 RANDOM LOCATION , HIGH=1.007, LOW=1.006	581-D.ED 09-22-03			A

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

Revision: 12/04/03 8:41

Part: SE212-003P-3 - -

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

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INSPECTION PLAN (INTERNAL TESTS AND FINAL DOCUMENTATION TEST COMBINED)

		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START							
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Workorder: 64880/1-0 Sub:29 Op:70

Revision:

Part: SE212-003P-3 - -

Drawing ID: SE121 Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		32 MICRO-INCH RA SURFACE FINISH (PORT EXTENSION TUBE)	PROFILOMETER	QA						
*		MAGNETIC PERMEABILITY 1.01 MAX (PORT EXTENSION TUBE)	PERMEABILITY GAG	QA						

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

Revision:

Part: - - NAMEPLATE

Drawing ID: NAMEPLATE Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
		MAGNETIC PERMEABILITY OF NAMEPLA 1.0 MAX	PERMEABILITY GAG	QA		J1143	9 LOC. CHECKED- HIG H 1.007, LOW 1.007.	581-D.ED 09-24-03		

Workorder: 64880/1-0 Sub:31 Op:20

Revision:

Part: - - NAMEPLATE

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

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