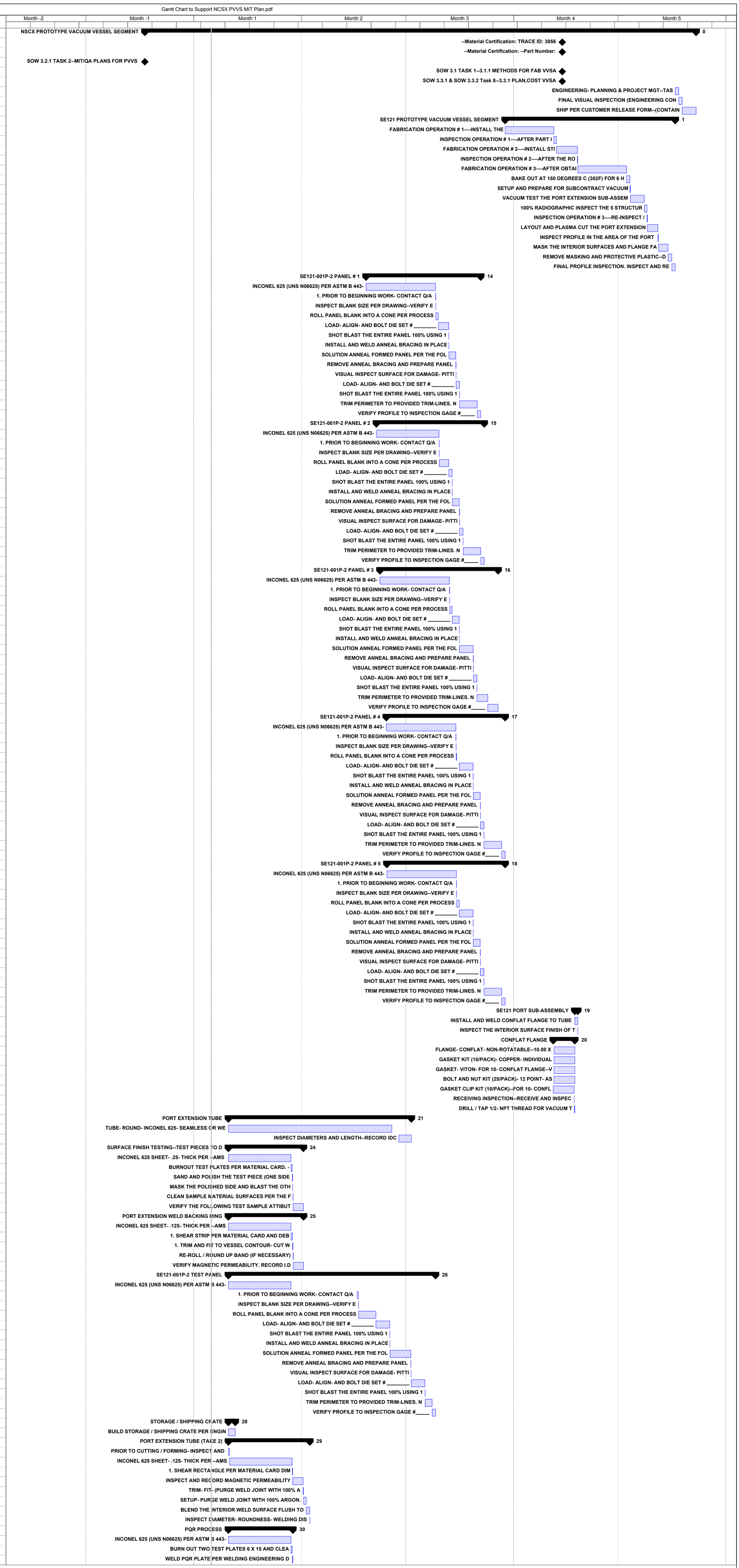ID	OP	Part Desc	Task Name
1	0	< ----SUB ID	NSCX PROTOTYPE VACUUM VESSEL SEGMENT
2	*10	WELD WIRE/GTAW- .062 DIA	--Material Certification: TRACE ID: 3856
3	*30	WELD WIRE/GTAW- .093 DIA	--Material Certification: --Part Number:
4	10	BLUE TEAM- ENGINEERING	SOW 3.2.1 TASK 2--MIT/QA PLANS FOR PVVS
5	11	BLUE TEAM- ENGINEERING	SOW 3.1 TASK 1--3.1.1 METHODS FOR FAB VVSA
6	12	BLUE TEAM- ENGINEERING	SOW 3.3.1 & SOW 3.3.2 Task 8--3.3.1 PLAN,COST VVSA
7	13	BLUE TEAM- ENGINEERING	ENGINEERING- PLANNING & PROJECT MGT--TAS
8	20	FINAL INSPECTION - PLANTS 1 & 2	FINAL VISUAL INSPECTION (ENGINEERING CON
9	30	SHIPPING - PLANTS 1 & 2	SHIP PER CUSTOMER RELEASE FORM--(CONTAIN
10	1	< ----SUB ID	SE121 PROTOTYPE VACUUM VESSEL SEGMENT
11	10	FABRICATION - WEIDNER	FABRICATION OPERATION # 1----INSTALL THE
12	20	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECTION OPERATION # 1----AFTER PART I
13	30	FABRICATION - WEIDNER	FABRICATION OPERATION # 2----INSTALL STI
14	40	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECTION OPERATION # 2----AFTER THE RO
15	70	FABRICATION - WEIDNER	FABRICATION OPERATION # 3----AFTER OBTAI
16	71	PAINT BOOTH	BAKE OUT AT 150 DEGREES C (302F) FOR 6 H
17	72	FABRICATION - WEIDNER	SETUP AND PREPARE FOR SUBCONTRACT VACUUM
18	73	SUBLET	VACUUM TEST THE PORT EXTENSION SUB-ASSEM
19	75	MQS CONTRACTOR X-RAY	100% RADIOGRAPHIC INSPECT THE 5 STRUCTUR
20	80	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECTION OPERATION # 3----RE-INSPECT /
21	90	FABRICATION - WEIDNER	LAYOUT AND PLASMA CUT THE PORT EXTENSION
22	100	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECT PROFILE IN THE AREA OF THE PORT
23	110	SANDBLAST	MASK THE INTERIOR SURFACES AND FLANGE FA
24	115	FABRICATION - WEIDNER	REMOVE MASKING AND PROTECTIVE PLASTIC--D
25	120	INPROCESS INSPECTION - PLANTS 1 & 2	FINAL PROFILE INSPECTION. INSPECT AND RE
26	14	< ----SUB ID	SE121-001P-2 PANEL # 1
27	*10	PLATE-NICKEL ALLOY .375- THK	INCONEL 625 (UNS N06625) PER ASTM B 443-
28	10	BURNOUT TABLE	1. PRIOR TO BEGINNING WORK- CONTACT Q/A
29	15	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECT BLANK SIZE PER DRAWING--VERIFY E
30	18	ROLLING/SHEAR/BRAKE PRESS	ROLL PANEL BLANK INTO A CONE PER PROCESS
31	20	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
32	25	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
33	27	FABRICATION - WEIDNER	INSTALL AND WELD ANNEAL BRACING IN PLACE
34	30	SUBLET- EXOTIC HEAT TREAT	SOLUTION ANNEAL FORMED PANEL PER THE FOL
35	32	FABRICATION - WEIDNER	REMOVE ANNEAL BRACING AND PREPARE PANEL
36	35	INPROCESS INSPECTION - PLANTS 1 & 2	VISUAL INSPECT SURFACE FOR DAMAGE- PITTI
37	40	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
38	50	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
39	60	FABRICATION - WEIDNER	TRIM PERIMETER TO PROVIDED TRIM-LINES. N
40	70	INPROCESS INSPECTION - PLANTS 1 & 2	VERIFY PROFILE TO INSPECTION GAGE #_____
41	15	< ----SUB ID	SE121-001P-2 PANEL # 2
42	*10	PLATE-NICKEL ALLOY .375- THK	INCONEL 625 (UNS N06625) PER ASTM B 443-
43	10	BURNOUT TABLE	1. PRIOR TO BEGINNING WORK- CONTACT Q/A
44	15	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECT BLANK SIZE PER DRAWING--VERIFY E
45	18	ROLLING/SHEAR/BRAKE PRESS	ROLL PANEL BLANK INTO A CONE PER PROCESS
46	20	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
47	25	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
48	27	FABRICATION - WEIDNER	INSTALL AND WELD ANNEAL BRACING IN PLACE
49	30	SUBLET- EXOTIC HEAT TREAT	SOLUTION ANNEAL FORMED PANEL PER THE FOL
50	32	FABRICATION - WEIDNER	REMOVE ANNEAL BRACING AND PREPARE PANEL
51	35	INPROCESS INSPECTION - PLANTS 1 & 2	VISUAL INSPECT SURFACE FOR DAMAGE- PITTI
52	40	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
53	50	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
54	60	FABRICATION - WEIDNER	TRIM PERIMETER TO PROVIDED TRIM-LINES. N
55	70	INPROCESS INSPECTION - PLANTS 1 & 2	VERIFY PROFILE TO INSPECTION GAGE #_____
56	16	< ----SUB ID	SE121-001P-2 PANEL # 3
57	*10	PLATE-NICKEL ALLOY .375- THK	INCONEL 625 (UNS N06625) PER ASTM B 443-
58	10	BURNOUT TABLE	1. PRIOR TO BEGINNING WORK- CONTACT Q/A
59	15	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECT BLANK SIZE PER DRAWING--VERIFY E
60	18	ROLLING/SHEAR/BRAKE PRESS	ROLL PANEL BLANK INTO A CONE PER PROCESS
61	20	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
62	25	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
63	27	FABRICATION - WEIDNER	INSTALL AND WELD ANNEAL BRACING IN PLACE
64	30	SUBLET- EXOTIC HEAT TREAT	SOLUTION ANNEAL FORMED PANEL PER THE FOL
65	32	FABRICATION - WEIDNER	REMOVE ANNEAL BRACING AND PREPARE PANEL
66	35	INPROCESS INSPECTION - PLANTS 1 & 2	VISUAL INSPECT SURFACE FOR DAMAGE- PITTI
67	40	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
68	50	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
69	60	FABRICATION - WEIDNER	TRIM PERIMETER TO PROVIDED TRIM-LINES. N
70	70	INPROCESS INSPECTION - PLANTS 1 & 2	VERIFY PROFILE TO INSPECTION GAGE #_____
71	17	< ----SUB ID	SE121-001P-2 PANEL # 4
72	*10	PLATE-NICKEL ALLOY .375- THK	INCONEL 625 (UNS N06625) PER ASTM B 443-
73	10	BURNOUT TABLE	1. PRIOR TO BEGINNING WORK- CONTACT Q/A
74	15	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECT BLANK SIZE PER DRAWING--VERIFY E
75	18	ROLLING/SHEAR/BRAKE PRESS	ROLL PANEL BLANK INTO A CONE PER PROCESS
76	20	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
77	25	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
78	27	FABRICATION - WEIDNER	INSTALL AND WELD ANNEAL BRACING IN PLACE
79	30	SUBLET- EXOTIC HEAT TREAT	SOLUTION ANNEAL FORMED PANEL PER THE FOL
80	32	FABRICATION - WEIDNER	REMOVE ANNEAL BRACING AND PREPARE PANEL
81	35	INPROCESS INSPECTION - PLANTS 1 & 2	VISUAL INSPECT SURFACE FOR DAMAGE- PITTI
82	40	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
83	50	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
84	60	FABRICATION - WEIDNER	TRIM PERIMETER TO PROVIDED TRIM-LINES. N
85	70	INPROCESS INSPECTION - PLANTS 1 & 2	VERIFY PROFILE TO INSPECTION GAGE #_____
86	18	< ----SUB ID	SE121-001P-2 PANEL # 5
87	*10	PLATE-NICKEL ALLOY .375- THK	INCONEL 625 (UNS N06625) PER ASTM B 443-
88	10	BURNOUT TABLE	1. PRIOR TO BEGINNING WORK- CONTACT Q/A
89	15	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECT BLANK SIZE PER DRAWING--VERIFY E
90	18	ROLLING/SHEAR/BRAKE PRESS	ROLL PANEL BLANK INTO A CONE PER PROCESS
91	20	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
92	25	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
93	27	FABRICATION - WEIDNER	INSTALL AND WELD ANNEAL BRACING IN PLACE
94	30	SUBLET- EXOTIC HEAT TREAT	SOLUTION ANNEAL FORMED PANEL PER THE FOL
95	32	FABRICATION - WEIDNER	REMOVE ANNEAL BRACING AND PREPARE PANEL
96	35	INPROCESS INSPECTION - PLANTS 1 & 2	VISUAL INSPECT SURFACE FOR DAMAGE- PITTI
97	40	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
98	50	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
99	60	FABRICATION - WEIDNER	TRIM PERIMETER TO PROVIDED TRIM-LINES. N
100	70	INPROCESS INSPECTION - PLANTS 1 & 2	VERIFY PROFILE TO INSPECTION GAGE #_____
101	19	< ----SUB ID	SE121 PORT SUB-ASSEMBLY
102	10	FABRICATION - WEIDNER	INSTALL AND WELD CONFLAT FLANGE TO TUBE
103	20	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECT THE INTERIOR SURFACE FINISH OF T
104	20	< ----SUB ID	CONFLAT FLANGE
105	*10	FLANGE- CONFLAT- NON-ROTATE- 10.00-	FLANGE- CONFLAT- NON-ROTATABLE--10.00 X
106	*20	GASKET KIT (10/PK)- COPPER- FOR 10- C	GASKET KIT (10/PACK)- COPPER- INDIVIDUAL
107	*30	GASKET- VITON- FOR 10- CFF	GASKET- VITON- FOR 10- CONFLAT FLANGE--V
108	*40	BOLT AND NUT KIT- 12 PT- SILVER PLATE	BOLT AND NUT KIT (25/PACK)- 12 POINT- AS
109	*50	GASKET CLIP KIT (10/PK)- FOR 10- CFF	GASKET CLIP KIT (10/PACK)--FOR 10- CONFL
110	10	RECEIVING INSPECTION	RECEIVING INSPECTION--RECEIVE AND INSPEC
111	20	TOOL ROOM - PLANT 1	DRILL / TAP 1/2- NPT THREAD FOR VACUUM T
112	21	< ----SUB ID	PORT EXTENSION TUBE
113	*10	INCO 625 TUBE 8.0- OD X .12- WA. X 18.0-	TUBE- ROUND- INCONEL 625- SEAMLESS OR WE
114	10	FABRICATION - WEIDNER	INSPECT DIAMETERS AND LENGTH--RECORD IDC
115	24	< ----SUB ID	SURFACE FINISH TESTING--TEST PIECES TO D
116	*10	SHEET-NICKEL ALLOY .25- THK	INCONEL 625 SHEET- .25- THICK PER --AMS
117	10	BURNOUT TABLE	BURNOUT TEST PLATES PER MATERIAL CARD. -
118	20	FABRICATION - WEIDNER	SAND AND POLISH THE TEST PIECE (ONE SIDE
119	25	SANDBLAST	MASK THE POLISHED SIDE AND BLAST THE OTH
120	28	FABRICATION - WEIDNER	CLEAN SAMPLE MATERIAL SURFACES PER THE F
121	30	INPROCESS INSPECTION - PLANTS 1 & 2	VERIFY THE FOLLOWING TEST SAMPLE ATTIBUT
122	25	< ----SUB ID	PORT EXTENSION WELD BACKING RING
123	*10	SHEET-NICKEL ALLOY .125- THK	INCONEL 625 SHEET- .125- THICK PER --AMS
124	10	ROLLING/SHEAR/BRAKE PRESS	1. SHEAR STRIP PER MATERIAL CARD AND DEB
125	20	FABRICATION - WEIDNER	1. TRIM AND FIT TO VESSEL CONTOUR- CUT W
126	30	ROLLING/SHEAR/BRAKE PRESS	RE-ROLL / ROUND UP BAND (IF NECESSARY)
127	40	INPROCESS INSPECTION - PLANTS 1 & 2	VERIFY MAGNETIC PERMEABILITY. RECORD I.D
128	26	< ----SUB ID	SE121-001P-2 TEST PANEL
129	*10	PLATE-NICKEL ALLOY .375- THK	INCONEL 625 (UNS N06625) PER ASTM B 443-
130	10	BURNOUT TABLE	1. PRIOR TO BEGINNING WORK- CONTACT Q/A
131	15	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECT BLANK SIZE PER DRAWING--VERIFY E
132	18	ROLLING/SHEAR/BRAKE PRESS	ROLL PANEL BLANK INTO A CONE PER PROCESS
133	20	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
134	25	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
135	27	FABRICATION - WEIDNER	INSTALL AND WELD ANNEAL BRACING IN PLACE
136	30	SUBLET- EXOTIC HEAT TREAT	SOLUTION ANNEAL FORMED PANEL PER THE FOL
137	32	FABRICATION - WEIDNER	REMOVE ANNEAL BRACING AND PREPARE PANEL
138	35	INPROCESS INSPECTION - PLANTS 1 & 2	VISUAL INSPECT SURFACE FOR DAMAGE- PITTI
139	40	PACIFIC 750	LOAD- ALIGN- AND BOLT DIE SET # _____
140	50	SANDBLAST	SHOT BLAST THE ENTIRE PANEL 100% USING 1
141	60	FABRICATION - WEIDNER	TRIM PERIMETER TO PROVIDED TRIM-LINES. N
142	70	INPROCESS INSPECTION - PLANTS 1 & 2	VERIFY PROFILE TO INSPECTION GAGE #_____
143	28	< ----SUB ID	STORAGE / SHIPPING CRATE
144	10	SHIPPING - PLANTS 1 & 2	BUILD STORAGE / SHIPPING CRATE PER ENGIN
145	29	< ----SUB ID	PORT EXTENSION TUBE (TAKE 2)
146	10	INPROCESS INSPECTION - PLANTS 1 & 2	PRIOR TO CUTTING / FORMING- INSPECT AND
147	*10	SHEET-NICKEL ALLOY .125- THK	INCONEL 625 SHEET- .125- THICK PER --AMS
148	20	ROLLING/SHEAR/BRAKE PRESS	1. SHEAR RECTANGLE PER MATERIAL CARD DIM
149	30	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECT AND RECORD MAGNETIC PERMEABILITY
150	40	FABRICATION - WEIDNER	TRIM- FIT- (PURGE WELD JOINT WITH 100% A
151	50	PLASMA WORKCENTER	SETUP- PURGE WELD JOINT WITH 100% ARGON.
152	60	FABRICATION - WEIDNER	BLEND THE INTERIOR WELD SURFACE FLUSH TO
153	70	INPROCESS INSPECTION - PLANTS 1 & 2	INSPECT DIAMETER- ROUNDNESS- WELDING DIS
154	30	< ----SUB ID	PQR PROCESS
155	*10	PLATE-NICKEL ALLOY .375- THK	INCONEL 625 (UNS N06625) PER ASTM B 443-
156	10	BURNOUT TABLE	BURN OUT TWO TEST PLATES 6 X 15 AND CLEA
157	20	FABRICATION - WEIDNER	WELD PQR PLATE PER WELDING ENGINEERING D