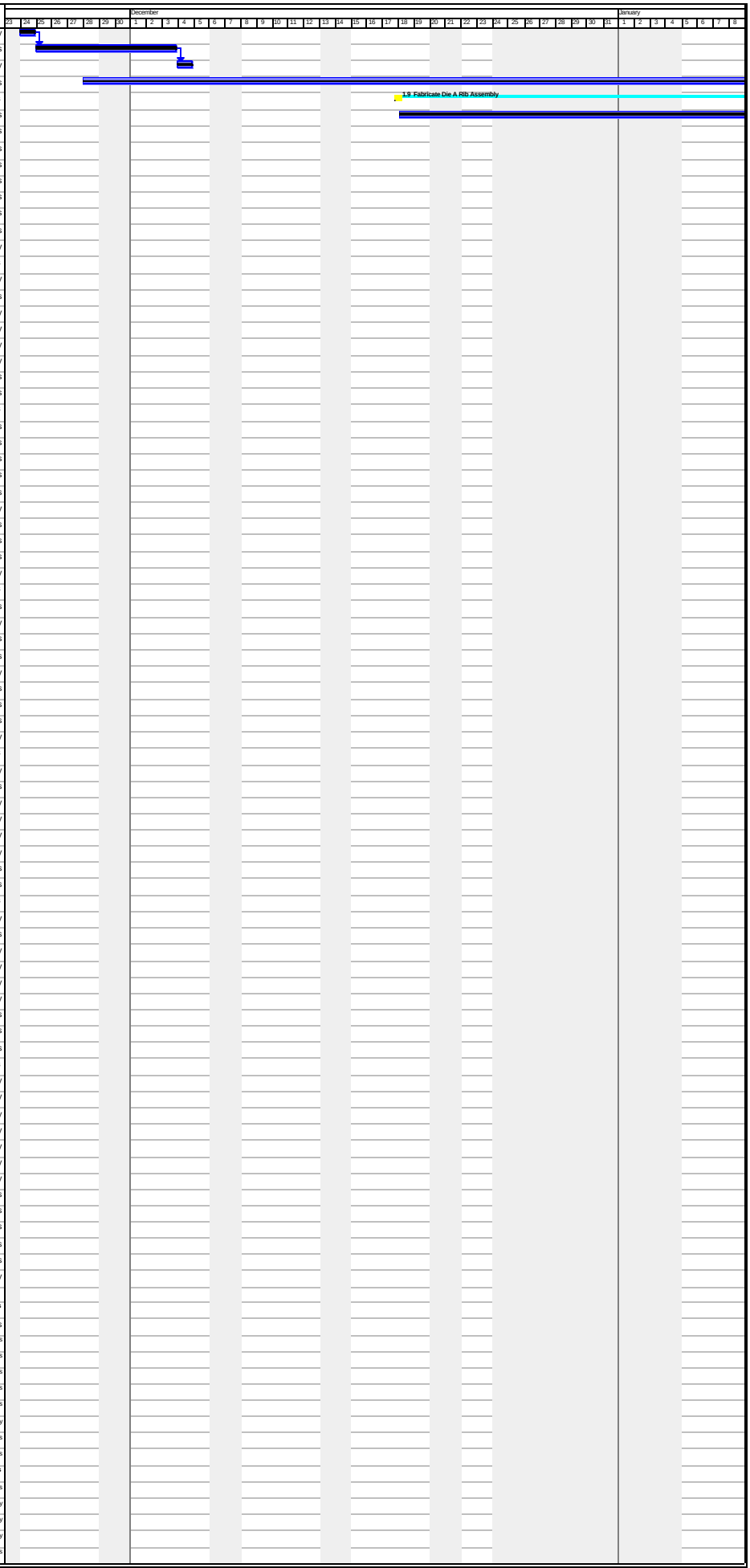
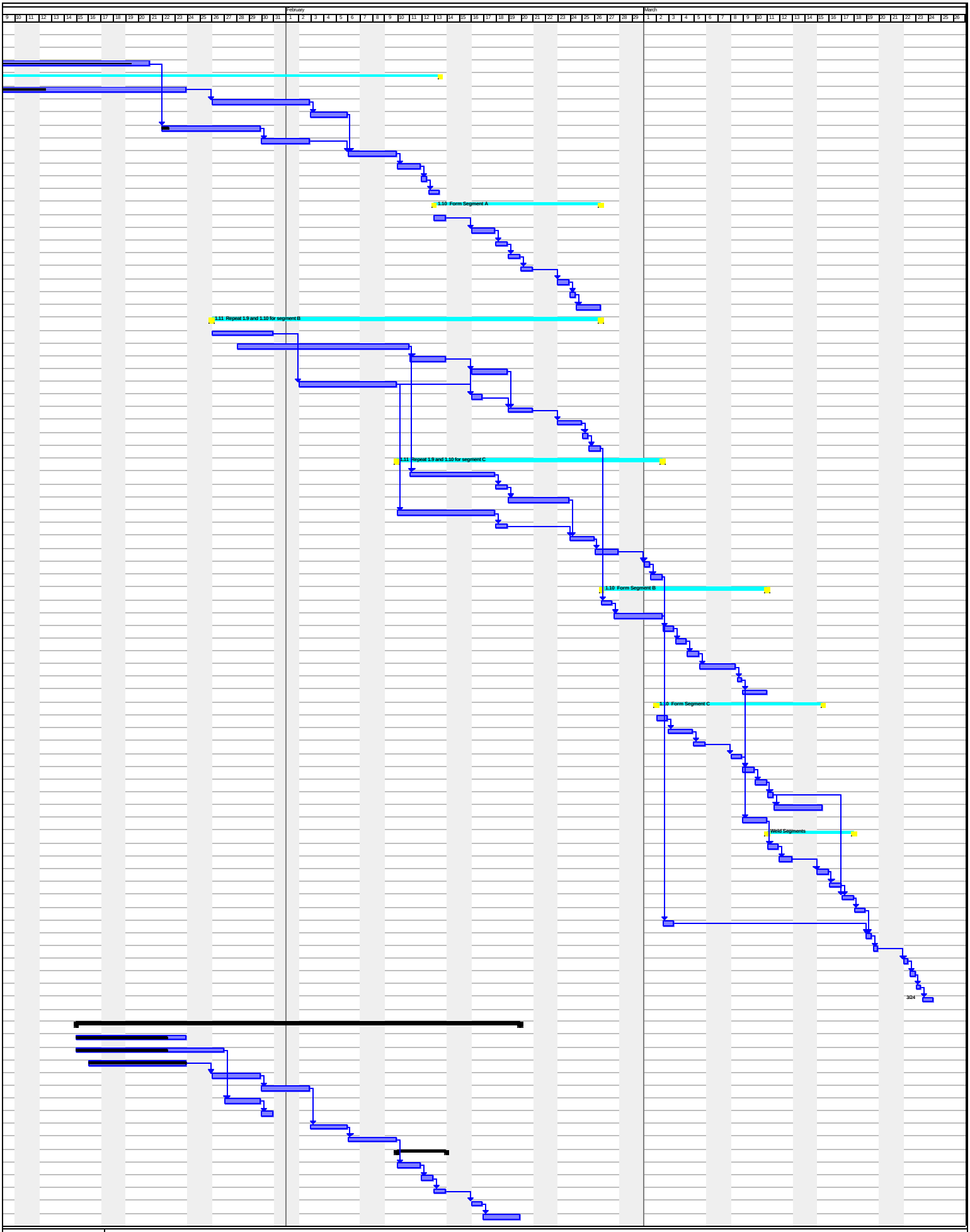
ID	Task Name	Duration
1	Kick-off Meeting	1 day
2	Forming Evaluation	7 days
3	1.7 Generate BOM for die rib assemblies and PVVS Segments and Order	1 day
4	1.8 Material Delivery for Die Enclosures and PVVS Segments	30 days
5	**1.9 Fabricate Die A Rib Assembly**	**33.5 days**
6	1.9.3 5 axis waterjet cut die ribs for Die A	19 days
7	1.9.7 Inspection of Die Ribs using CMM	6 days
8	Drill and Tap Holes in Die Ribs	3 days
9	1.9.8 Machine complete 3 wall enclosure for Die A	6 days
10	Machine Rib Reinforcements/Braces for Die A	2 days
11	1.9.14 Assemble die and inspect	2 days
12	1.9.17 Lightly tack weld Scab plate, test form, inspect, full tack/plug weld and inspect	2 days
13	1.9.23 locate/place ref points on die rib assembly	0.5 days
14	1.9.24 Final Machine precision locking device for press	1 day
15	**1.10 Form Segment A**	**9.5 days**
16	1.10.1 Plasma Cut to Pre-cut Segment Oversized	1 day
17	1.10.3 Form Segment and stress relieve with Male / Female Die	2 days
18	Inspect Segment using CMM	1 day
19	1.10.5 Locate and Place Ref points on segment with CMM	1 day
20	1.10.7 Stress Relieve if Necessary	1 day
21	1.10.8 Scribe/Mark Segment Edges using CMM/Model and machine to size	1 day
22	1.10.12 Inspect with CMM and Inspect Segment Thickness	0.5 days
23	Machine to size	2 days
24	**1.11 Repeat 1.9 and 1.10 for segment B**	**23.5 days**
25	Order Die Enclosure Material and cut to rough size	5 days
26	1.9.3 5 axis waterjet cut die ribs for Die B	10 days
27	1.9.7 Inspection of Die Ribs using CMM	3 days
28	Drill and Tap Holes in Die Ribs	3 days
29	1.9.8 Machine complete 3 wall enclosure for Die B	6 days
30	Machine Rib Reinforcements/Braces for Die B	1 day
31	1.9.14 Assemble die and inspect	2 days
32	1.9.17 Lightly tack weld Scab plate, test form, inspect, full tack/plug weld and inspect	2 days
33	1.9.23 locate/place ref points on die rib assembly	0.5 days
34	1.9.24 Final Machine precision locking device for press	1 day
35	**1.11 Repeat 1.9 and 1.10 for segment C**	**15.5 days**
36	1.9.3 5 axis waterjet cut die ribs for Die C	5 days
37	1.9.7 Inspection of Die Ribs using CMM	1 day
38	Drill and Tap Holes in Die Ribs	3 days
39	1.9.8 Machine complete 3 wall enclosure for Die C	6 days
40	Machine Rib Reinforcements/Braces for Die C	1 day
41	1.9.14 Assemble die and inspect	2 days
42	1.9.17 Lightly tack weld Scab plate, test form, inspect, full tack/plug weld and inspect	2 days
43	1.9.23 locate/place ref points on die rib assembly	0.5 days
44	1.9.24 Final Machine precision locking device for press	1 day
45	**1.10 Form Segment B**	**9.5 days**
46	1.10.1 Plasma Cut to Pre-cut Segment Oversized	1 day
47	1.10.3 Form Segment and stress relieve with Mail/Female Die	2 days
48	Inspect Segment using CMM	1 day
49	1.10.5 Locate and Place Ref points on segment with CMM	1 day
50	1.10.7 Stress Relieve if Necessary	1 day
51	1.10.8 Scribe/Mark Segment Edges using CMM/Model and machine to size	1 day
52	1.10.12 Inspect with CMM and Inspect Segment Thickness	0.5 days
53	Machine to size	2 days
54	**1.10 Form Segment C**	**9.5 days**
55	1.10.1 Plasma Cut to Pre-cut Segment Oversized	1 day
56	1.10.3 Form Segment and stress relieve with Mail/Female Die	2 days
57	Inspect Segment using CMM	1 day
58	1.10.5 Locate and Place Ref points on segment with CMM	1 day
59	1.10.7 Stress Relieve if Necessary	1 day
60	1.10.8 Scribe/Mark Segment Edges using CMM/Model and machine to size	1 day
61	1.10.12 Inspect with CMM and Inspect Segment Thickness	0.5 days
62	Machine to size	2 days
63	Assemble Jigs and Figuring for Assembly	2 days
64	**Weld Segments**	**5 days**
65	2.4 Mount A and B Segments together, inspect then tack , then inspect with CMM	1 day
66	2.10 Full weld of segments	1 day
67	2.10 Inspect weld, inspect with CMM, grind welds and polish	1 day
68	2.14 Inspect with CMM for distortion	1 day
69	Weld Segment C in place	1 day
70	2.15 Clean and Surface Finish , and inspect	1 day
71	3.5 Machine port extension tube	1 day
72	3.9 Mount and tack weld tube and inspect before full weld	0.5 days
73	3.19 Install and inspect flange then leak check	0.5 days
74	3.26 Cut off port extension and inspect	0.5 days
75	3.28 Cut hole in PVVS and inspect	0.5 days
76	3.32 Stitch weld port reinforcement and port extension and inspect	0.5 days
77	PVVS final inspections	1 day
78		
79	**Parallel Port Process Development project**	**26 days**
80	Purchase Material for skin	7 days
81	Purchase material for port	8 days
82	Locate 2 axis bending	6 days
83	Press	4 days
84	Digitize with Faro	2 days
85	Fab Port	3 days
86	Digitize Port	1 day
87	Design of Off-normal configurations (port to surface)	3 days
88	Develop model of port	2 days
89	**Weld port to surface**	**4 days**
90	design/build fixturing	2 days
91	check location with Faro Arm prior to Weld	1 day
92	weld	1 day
93	Inspect configuration	1 day
94	Cut/remove port per procedure	3 days



Project: 03-8083 schedule
Date: Thu 1/22/04

Task | Progress | Summary | Rolled Up Split | Rolled Up Progress | Project Summary | External Milestone
Split | Milestone | Rolled Up Task | Rolled Up Milestone | External Tasks | External Milestone | Deadline



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