

Activity ID	Activity Description	Percent Start	Percent Finish	Org	Start	End	Shif	Total
<b>Station 3- Assembly Mod Coils and VISA-FP3</b>								
<b>Misc Prep activities</b>								
3-0-PLAT.3	Install station 3 platforms FP3B required	30JUL09	12AUG09	10	1	51		
<b>Pre-assemble LEFT MCHP</b>								
3-3-2.01	Position left MCHP over left support	13AUG09	13AUG09	1	1	51		
3-3-2.02	Secure left MCHP to vertical support posts	14AUG09	14AUG09	1	1	51		
3-3-2.03	Measure all inboard measurements	17AUG09	18AUG09	2	1	51		
3-3-2.04	Measure the Type-A and Type-C end flanges while	19AUG09	20AUG09	2	1	51		
3-3-2.05	Allow time for the back office to review the me	21AUG09	24AUG09	2	1	51		
3-3-2.06	Mark nose shim locations & pucks	21AUG09	21AUG09	1	1	51		
<b>Pre-assemble RIGHT MCHP</b>								
3-3-3.01	Move the right support cart in the far right	24AUG09	21AUG09	0	1	51		
3-3-3.02	Position right MCHP over right support	04NOV09	04NOV09	1	1	51		
3-3-3.03	Secure right MCHP to support base	05NOV09	05NOV09	1	1	51		
3-3-3.04	Measure the target monuments on right MCHP with	08NOV09	08NOV09	2	1	51		
3-3-3.05	Measure the Type-A and Type-C end flanges while	10NOV09	11NOV09	2	1	51		
3-3-3.06	Allow time for the back office to review the me	12NOV09	17NOV09	4	1	51		
3-3-3.07	Mark nose shim locations	12NOV09	12NOV09	1	1	51		
3-3-3.08	Define all outboard shim thicknesses	13NOV09	12NOV09	0	1	51		
<b>Pre-assemble LEFT and RIGHT MCHP</b>								
3-3-4.01	Place alumina shims (4-8) on left side type A	13NOV09	13NOV09	1	1	51		
3-3-4.02	Temp fit right MCHP and move support cart	16NOV09	16NOV09	1	1	51		
3-3-4.03	Position right MCHP over right support	17NOV09	17NOV09	1	1	51		
3-3-4.04	Bring Air Loc wedgemoount leveler to take load	18NOV09	18NOV09	1	1	51		
3-3-4.05	Measure the target monuments on left MCHP with	19NOV09	20NOV09	2	1	51		
3-3-4.06	Install temporary scaffolding to install flange	19NOV09	19NOV09	1	1	51		
3-3-4.07	Install remaining alumina shims; install nuts/bushings	23NOV09	24NOV09	2	1	51		
3-3-4.08	Make a hand "wobble" test (rotate on both)	25NOV09	30NOV09	2	1	51		
3-3-4.09	Tighten flange fasteners to 50%	01DEC09	01DEC09	1	1	51		
3-3-4.10	measure the position of all monuments	02DEC09	02DEC09	1	1	51		
3-3-4.11	Measure the shim puck height (at a number of po	03DEC09	04DEC09	2	1	51		
3-3-4.111	Fit and tack weld flex shims in place	07DEC09	06DEC09	3	1	51		
3-3-4.12	Uniform all bolts & nut right MCHP to right	14DEC09	11DEC09	2	1	51		
3-3-4.121	Lay left MCHP onto 60 degree wedge for welding	14DEC09	15DEC09	2	1	51		
3-3-4.122	Measure the left MCHP fiducials	16DEC09	16DEC09	1	1	51		
3-3-4.13	Recheck alignment & weld plasma side shims	17DEC09	18DEC09	2	1	51		
3-3-4.14	After welding the left MCHP nose shims recheck	21DEC09	22DEC09	2	1	51		
3-3-4.15	Time for back office assessment	04JAN10	05JAN10	2	1	51		
3-3-4.151	Lift left MCHP & install on support stand	06JAN10	06JAN10	1	1	51		
3-3-4.152	Lay right MCHP on 60 deg wedge for welding	07JAN10	07JAN10	1	1	51		
3-3-4.16	Measure right MCHP fiducials establish ref	08JAN10	08JAN10	1	1	51		
3-3-4.17	Weld right MCHP flex shims	11JAN10	12JAN10	2	1	51		
3-3-4.18	After welding the right MCHP nose shims recheck	13JAN10	13JAN10	1	1	51		
3-3-4.19	Time for back office assessment	14JAN10	15JAN10	2	1	51		
<b>RE-assemble LEFT and RIGHT MCHP</b>								
3-3-5.01	Lift right MCHP and move support cart	18JAN10	18JAN10	1	2	0		
3-3-5.02	Position right MCHP over right support	19JAN10	19JAN10	1	2	0		
3-3-5.03	Bring Air Loc wedgemoount leveler to take load	20JAN10	20JAN10	1	2	0		
3-3-5.04	Measure the target monuments on left MCHP with	21JAN10	21JAN10	1	2	0		
3-3-5.05	Bond all inboard shim pucks to the right MCHP T	22JAN10	22JAN10	1	2	0		
<b>Install Laser Screen</b>								
3-3-6.02	Place all laser screens	25JAN10	25JAN10	1	2	0		
3-3-6.03	Turn each laser on & measure each laser source	26JAN10	26JAN10	1	2	0		
3-3-6.04	Print path on miller paper	27JAN10	26JAN10	0	2	0		
3-3-6.05	Disengage the right MCHP A move to far right	27JAN10	27JAN10	1	2	0		
3-3-6.06	Remove the left MCHP test laser path	28JAN10	28JAN10	1	2	0		
3-3-6.07	Place left MCHP in temp location	28JAN10	28JAN10	0	2	0		
<b>Install Vacuum Vessel</b>								
3-3-7.02	Install VV N2 port support stand	29JAN10	29JAN10	1	2	0		
3-3-7.03	Install VISA to base support and make connection	01FEB10	01FEB10	1	2	0		
3-3-7.04	take tooling ball readings and secure VISA	02FEB10	02FEB10	1	2	0		
3-3-7.05	Scan VV surface and compare data	03FEB10	03FEB10	1	2	0		
<b>Install RIGHT MCHP over VV</b>								
3-3-8.01	Install any bumper protection components on the	04FEB10	04FEB10	1	2	0		
3-3-8.03	Install MCHP lift fixture, disengage leveler	05FEB10	05FEB10	1	2	0		
3-3-8.04	Re-install the right adjuster bar	08FEB10	05FEB10	0	2	0		
3-3-8.05	Move right MCHP over the VV	08FEB10	08FEB10	1	2	0		
3-3-8.06	Position right MCHP over right support	10FEB10	10FEB10	1	2	0		
3-3-8.07	Bring Air Loc Wedgemoount leveler up to take load	11FEB10	11FEB10	1	2	0		
3-3-8.08	Measure the target monuments on right MCHP with	12FEB10	12FEB10	1	2	0		
3-3-8.09	move MCHP to right 12"	15FEB10	12FEB10	0	2	0		
<b>Install LEFT MCHP over VV</b>								
3-3-9.02	Move left MCHP over VV to within 12"	15FEB10	15FEB10	1	2	0		
3-3-9.03	Using adjuster bar move right MCHP back	16FEB10	16FEB10	1	2	0		
3-3-9.05	Position left MCHP over left support	17FEB10	17FEB10	1	2	0		
3-3-9.06	Bring Air Loc Wedgemoount leveler up to take load	18FEB10	18FEB10	1	2	0		
3-3-9.061	Measure the target monuments on right MCHP	19FEB10	19FEB10	1	2	0		
3-3-9.07	Remove laser screens to provide more fr space	22FEB10	22FEB10	1	2	0		
3-3-9.08	Install temporary scaffolding to install flange	23FEB10	23FEB10	1	2	0		
3-3-9.09	Install bolts and all outboard alumina shims.	24FEB10	24FEB10	1	2	0		
3-3-9.1	Tighten flange fasteners to 50%	25FEB10	25FEB10	1	2	0		
3-3-9.11	Make a hand "wobble" test (rotate on both)	26FEB10	26FEB10	1	2	0		
3-3-9.12	Perform metrology measurements of all alignment	01MAR10	02MAR10	2	2	0		
3-3-9.13	Perform position adjustments on left side MCHP	03MAR10	03MAR10	1	2	0		
3-3-9.14	Remove BSC20 structure from left MCHP	04MAR10	03MAR10	0	2	0		
3-3-9.15	Machine and install bushings	04MAR10	04MAR10	1	2	0		
3-3-9.16	Tighten nuts 100%. Re-verify adequate MCHP all	05MAR10	05MAR10	1	2	0		
<b>Weld inboard shims &amp; fill bushing gaps</b>								
3-3-10.01	Weld inboard shims solenoid side	08MAR10	08MAR10	2	2	0		
3-3-10.02	Measure the positions of all monuments	10MAR10	10MAR10	1	2	0		
3-3-10.03	Fill all lose bushings with Sycast 2850FT	11MAR10	11MAR10	1	2	0		
3-3-10.04	Measure the monuments on all coils	12MAR10	15MAR10	2	2	0		
<b>VISA attachment to MC</b>								
3-3-11.01	Attach permanent VV supports to Type A MC	16MAR10	16MAR10	1	2	0		
3-3-11.02	Attach temp VV supports to Type B MC	17MAR10	17MAR10	1	2	0		
3-3-11.03	Disconnect base support and transfer load to VV	18MAR10	18MAR10	1	2	0		
3-3-11.04	Install VV lateral supports and align VVSA	19MAR10	19MAR10	1	2	0		
3-3-11.05	Prepare VVSA for transport. Install blocking	22MAR10	22MAR10	1	2	0		
<b>Transfer to Station 5</b>								
3-3-12.01	Install rigging to MC/V transfer to support frame	23MAR10	23MAR10	1	2	0		
3-3-12.02	Transfer to Station 5 located in NCX3 TC	24MAR10	24MAR10	1	2	0		
3-3-10.02M	2	Complete 3rd MC-VV Assy (Sta 3)	24MAR10	24MAR10	0	2	0	
<b>Job: 1815 - Field Period Assy-Station 5-VIOLA</b>								
<b>Station 5- Final FP Assy-FP3 (in NCX3 TC)</b>								
<b>Pre-Installation setup</b>								
5-3-2.01	Install period support fixture	25MAR10	26MAR10	1	2	0		
5-3-2.02	Temporarily position/support lower trim coils t	26MAR10	26MAR10	1	2	0		
5-3-2.03	Install FPA on support stand. Use leveler pad	30MAR10	30MAR10	1	2	0		
5-3-2.04	Install external working platforms	31MAR10	01APR10	2	2	0		
5-3-2.05	Install internal VV working platforms	02APR10	02APR10	1	2	0		
<b>VV Port Installation</b>								
5-3-3.01	Install the domes (left and right side), insert	05APR10	05APR10	2	1	0		
5-3-3.02	Install small dome ports and remaining circular	07APR10	10APR10	2	1	0		
5-3-3.03	Leak check each port immediately after it is ve	14APR10	17APR10	2	1	0		
<b>Install Port Boats</b>								
5-3-4.01	Install boats on all ports except for port 4	03MAY10	18MAY10	12	1	0		
<b>TF Coils, structures &amp; port 12 trim coils</b>								
5-3-5.01	Make MC N2 serv connections on MC run N2 lines	19MAY10	21MAY10	3	2	0		
5-3-5.011	Run thermocouple and strain gage lines	24MAY10	24MAY10	1	2	0		
5-3-5.02	Install MC test leveling struts	25MAY10	25MAY10	1	2	0		
5-3-5.03	Install subassembly TF supports	26MAY10	26MAY10	1	2	0		
5-3-5.04	But in place Port 12 trim coil brackets	27MAY10	27MAY10	1	2	0		
5-3-5.05	But part of Port 12 trim coil supports	28MAY10	28MAY10	1	2	0		
5-3-5.06	Position two TF coils over the "C" MC	01JUN10	01JUN10	1	2	0		
5-3-5.07	Move TF coil over the right "A" MC	02JUN10	02JUN10	1	2	0		
5-3-5.08	Install the Type-A TF coil support brackets	03JUN10	03JUN10	1	2	0		
5-3-5.09	Install local MC lead stem right Type-B MC	04JUN10	04JUN10	1	2	0		
5-3-5.1	Install TF coils left side of Period assembly	07JUN10	09JUN10	3	2	0		
5-3-5.11	Install remaining TF trim support brackets	10JUN10	10JUN10	1	2	0		
5-3-5.12	But part 4 trim coil to trim coil brackets	11JUN10	11JUN10	1	2	0		
5-3-5.13	But part trim coil to trim coil brackets	14JUN10	15JUN10	2	2	0		
<b>Slanted trim coils &amp; support structure</b>								
5-3-6.01	Position 4 slanted trim coils behind TF coils	16JUN10	16JUN10	1	2	0		
5-3-6.02	Install the magnet systems support structure	17JUN10	17JUN10	1	2	0		
5-3-6.03	Attach channel strut on magnet struct	18JUN10	18JUN10	1	2	0		
5-3-6.04	Attach additional support structure struts	21JUN10	21JUN10	1	2	0		
5-3-6.05	MC leads will be supported off magnet struct	22JUN10	22JUN10	1	2	0		
5-3-6.06	Metrology measurements of each trim coil	23JUN10	24JUN10	2	2	0		
5-3-6.07	Install MC run junction boxes design TBD	25JUN10	28JUN10	2	1	29		
<b>MC coolant connections &amp; services runs</b>								
5-3-7.01	Install top and bottom MC coolant headers.	25JUN10	25JUN10	1	2	0		
5-3-7.02	Bring MC strain gage & TC lines through	28JUN10	28JUN10	1	2	0		
5-3-7.03	Grounding connections	29JUN10	29JUN10	1	2	0		
5-3-11.08	Check manifolds (pressure, flow, etc.	28JUN10	30JUN10	3	2	27		
<b>TF Ripup, Port 4's &amp; diagnostics</b>								
5-3-8.01	Perform a rip-up check of the four TF coils	30JUN10	01JUL10	2	2	0		
5-3-8.011	Tack weld the left and right port 4's	02JUL10	02JUL10	1	2	0		
5-3-8.02	Install boats on both port 4's	06JUL10	06JUL10	1	2	0		
5-3-10.01	Install Rogowski coils on end of VV left side	07JUL10	09JUL10	3	2	0		
<b>PF Struct, Final measurement &amp; Transfer</b>								
5-3-11.000	Install PF support structure (WBS 7)							