

Activity ID	MILE STONE LEVEL	Activity Description	Duration (work days)	Forecast Start	Early Finish	Total Float	FY08																				
							FEB				MAR				APR												
							4	11	18	25	3	10	17	24	31	7	14	21									
cc 9450 - NCSX Fabrication (MIE)																											
Brown																											
Job: 1803/1805- FPA Tooling/Constr-BROWN/DUDEK																											
Station 3-Modular Coil to VVSA Assembly																											
1803-3.11		Deliver Support Cart (PE 007703)	69*	15OCT07A																							
1803S3-1		Flange bolt/VV support access platform	10*	03MAR08*	14MAR08	248																					
1803S3-2		Updated Stations 3 and 5 sequence plan	43*	31JAN08*	31MAR08	208																					
1803S3-3		Station 3 alignment FDR and clean-up activities	15	01APR08*	21APR08	208																					
1803S3-5		Analyze single point lift (proof test of support	10*	18FEB08*	29FEB08	258																					
1803S3-6		Station 3 simulation detail model	15*	04FEB08*	22FEB08	263																					
1803S3-7		VV/MC clearance study (for VVSA1, 2 and 3)	11*	01APR08*	15APR08	196																					
1803S3-8		Station 3 deflection FEA study	30	16APR08	28MAY08	196																					
1805S3-2		Left side base grout plates	85	31JAN08	29MAY08	181																					
1805S3-3		MCHP lift fixture frame weldment	85	31JAN08	29MAY08	181																					
1805S3-4		Lift fixture mounting bracket weldments	85	31JAN08	29MAY08	181																					
1805S3-5		Reworked laser frame structure	85	31JAN08	29MAY08	181																					
1805S3-6		Right inboard laser frame structure	85	31JAN08	29MAY08	181																					
1805S3-7		Left inboard laser frame structure	85	31JAN08	29MAY08	181																					
1805S3-8		Laser screen lexan sheet (1/8 x 48" x 96")	85	31JAN08	29MAY08	181																					
1805S3-9		Estimate for Station 2 type alignment system	85	31JAN08	29MAY08	181																					
1805S3-100		Hardware & Misc items	65	31JAN08	30APR08	201																					
1805S3-110		Misc assembly Cost	65	31JAN08	30APR08	201																					
1805S3-201		MC base support system (left / rt side)	65	31JAN08	30APR08	201																					
1805S3-202		Hilman roller - 8-OT plus R & U guides	65	31JAN08	30APR08	201																					
1805S3-203		AirLoc Wedgmount Precision Levelers	65	31JAN08	30APR08	201																					
1805S3-204		Lift fixture mounting bracket weldments	65	31JAN08	30APR08	201																					
1805S3-205		Estimate for Station 2 type alignment system	65	31JAN08	30APR08	201																					
1805S3-206		Hardware & Misc items	65	31JAN08	30APR08	201																					
Station 5-Final Field Period Assembly																											
1803S5-4		Station 5 (and 3) lift fixture structures and li	10*	04FEB08*	15FEB08	371																					
1803S5-5		Port 4 assembly tooling, models and dwgs	31	18FEB08	31MAR08	371																					
1803S5-6		Complete external platform models	33*	17MAR08*	30APR08	332																					
1803S5-8		Station 5 support structural analysis	10*	03MAR08*	14MAR08	382																					
1803S5-9		Station 5 PDR activities	14	21FEB08*	11MAR08	385																					
1803S5-10		Station 5 FDR - Base support	22*	05MAR08*	03APR08	240																					
1803-5.6	3	Station 5 FDR	0		03APR08	240																					
1803S5-11		Base support release for fabrication	5	04APR08	10APR08	363																					
1803S5-12		Station 5 FDR - Lift fixtures, port tooling and	10	08APR08*	21APR08	351																					
1805S5-1		FPA base support system	105	04APR08	02SEP08	240																					
1805S5-2		Type-C side support structure	105	04APR08	02SEP08	240																					
1805S5-3		NB side stabilizing support structure	105	04APR08	02SEP08	240																					
1805S5-4		TF local temporary supports	105	04APR08	02SEP08	240																					
1805S5-5		20 ton screw jacks	105	04APR08	02SEP08	240																					
1805S5-6		AirLoc Wedgmount Precision Levelers	105	04APR08	02SEP08	240																					
1805S5-7		Port 4 handling structure	105	04APR08	02SEP08	240																					
1805S5-8		Small port handling structure	105	04APR08	02SEP08	240																					
1805S5-9		Station 5 (and 3) lift fixture structures	105	04APR08	02SEP08	240																					
1805S5-102		Hardware & Misc. items	105	04APR08	02SEP08	240																					
1805S5-103		Misc. assembly Cost	105	04APR08	02SEP08	240																					

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Job: 8203 - Design Integration-BROWN																									
8203FY08-1		Service routing within cryostat & TC	46*	29FEB08*	02MAY08	1,625																			
8203FY08-2		Facility models update&integration	43	02APR08*	02JUN08	1,605																			
Chrzanowski																									
Job: 1302 - PF Design -CHRZANOWSKI																									
1302-275		Resolve FDR Chits	51	22FEB08*	02MAY08	1,255																			
Job: 1352 - PF Coil Procurement-CHRZANOWSKI																									
PF Coil Fabrication																									
141-038.1		PF Conductor Delivery	65	21FEB08A	08MAY08	404																			
141-039		Bid & Award Materials	21	03MAR08*	31MAR08	1,581																			
141-040		PF Materials Awarded	0		31MAR08	1,581																			
1352-100		Materials Delivery PF 4,5,6	68	01APR08	07JUL08	1,581																			
141-035		Bid & Award PF Coil Fabrication	60*	07MAR08*	30MAY08	303																			
141-035A		PF Coil Proposals Due	0		02APR08*	303																			
141-035B		Proposal evaluation complete	0		16APR08*	303																			
Job: 1408 - MC Winding Supplies-CHRZANOWSKI																									
1408-4.0		Order Strain Gages	1	14MAR08*	14MAR08	170																			
1408-4.1		Procure Strain Gages	55	17MAR08*	02JUN08	170																			
Job: 1451 - Mod Coil Winding-CHRZANOWSKI																									
Station 3-Casting Prep & Winding																									
P1-151		Receive A6, Prep& Instl Cladding	97*	01NOV07A	27MAR08	93																			
P1-161		Wind coil A6	75	28MAR08	27MAY08	93																			
Station 4-Winding, Instl Chill Plates,Tubing,Bag																									
P3-170		Instl Chill Plates,Tubing,Bag B6	42	31JAN08A	30APR08	171																			
Station 1 Post VPI																									
P2-051C		Final Clamps & Warm Test (Station1) C6	43	31JAN08	31MAR08	205																			
P3-171C		Final Clamps & Warm Test (Station1) B5	16	01APR08	22APR08	207																			
Job: 1459 - Mod Coil Fabr.Punch List-CHRZANOWSKI																									
Punchlist Tech shop/RESA																									
PLTS-C3		Grinding & Drill Holes -C3	102*	01OCT07A	03MAR08	187																			
PLTS-C4		Grinding & Drill Holes -C4	5	01OCT07A	10MAR08	214																			
PLTS-C5		Grinding & Drill Holes -C5	5	01OCT07A	17MAR08	1,659																			
PLTS-A6		Grinding -A6	5	01OCT07A	19SEP08	93																			
PLTS-C6		Grinding & Drill Holes -C6	20	01APR08	28APR08	205																			
PLTS-GRIND		Coil to coil fitup modifications (grinding/cp)	165*	01DEC07A	31JUL08	1,563																			
Punchlist- Coil Technicians																									
PLCT-A3		Insul,measure,TC, other punch list-A3	17	05JUL07A	14FEB08	174																			
PLCT-A4		Insul,measure,TC, other punch list-A4	17	06JUL07A	05MAR08	174																			
PLCT-B3		Insul,measure,TC, other punch list-B3	14	01OCT07A	20MAR08	174																			
PLCT-C3		Insul,measure,TC, other punch list-C3	18	01OCT07A	07APR08	174																			
PLCT-B4		Insul,measure,TC, other punch list-B4	14	01OCT07A	21APR08	174																			
PLCT-C4		Insul,measure,TC, other punch list-C4	14	25JUL07A	02MAY08	184																			
PLCT-A5		Insul,measure,TC, other punch list-A5	14	30JUL07A	12MAY08	184																			

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PLCT-A6		Insul,measure,TC,SG other punch list-A6	14	01OCT07A	09OCT08	93																
PLCT-B5		Insul,measure,TC, other punch list-B5	14	01OCT07A	29OCT08	93																
PLCT-C5		Insul,measure,TC, other punch list-C5	18	01OCT07A	06NOV08	93																
PLCT-B6		Insul,measure,TC,SG other punch list-B6	14	01OCT07A	17JUL08	171																
PLCT-C6		Insul,measure,TC,SG other punch list-C6	14	01OCT07A	16MAY08	205																

Cole

Job: 1416 - Mod Coil Type AB Fnl Dsn-WILLIAMSON

Top level assy models/drawings						
1416-503		Complete models/drawings station 3 Assy	185*	01JUL07A	31MAR08	300

Analysis and closeout documentation						
1416-601	3	Prepare EM and structural analysis of leads	86*	02JAN08A	30APR08	1,627
1416-603		Update, review and approve FMECA	78*	01NOV07A	29FEB08	1,635
1416-604		Finalize draft documents - materials, eddy curre	5	03MAR08	07MAR08	1,635
1416-605	3	Prepare Type-ABC closeout documentation	15	09APR08*	29APR08	1,613

Job: 1421 - Mod Coil Interface Design-WILLIAMSON

Outboard Interface-Bolted Joint Tests-Shear						
1421-3119B		Document test results	42*	02JAN08A	28FEB08	1,670
1421-3999		Peer Review of Test Result	0		29FEB08	1,670

Inboard Interface-AB/BC/AA						
1421-3138		Resolve issues, release assembly	58*	03DEC07A	29FEB08	6

Job: 1806 - FP Assembly specs and drawings-COLE

Station 2-Modular Coil Sub- Assembly						
1803-201	3	Station 2 Assembly Specification	164*	01JUL07A	29FEB08	6

Station 3-Modular Coil to VVSA Assembly						
1803-301		Station 3 Assembly Specification	185*	02JUL07A	31MAR08	163
1803-305		Station 3 Assembly Drawings	185*	02JUL07A	31MAR08	163

Station 5-Final Field Period Assembly						
1803-501		Station 5 Assembly Specification	48*	01APR08*	06JUN08	237
1803-505		Station 5 Assembly Drawings	152*	03SEP07A	15APR08	274
1803-509		Field period Assy Dwgs	132*	01FEB08*	06AUG08	195
1803-611		Detail dwgs ports	90	01APR08*	06AUG08	195

6.00-Final Machine Assembly						
1803-601		Station 6 Assembly Specification	120	15APR08*	02OCT08	377
1803-605		Station 6 Assembly Drawings	120	15APR08*	02OCT08	377
1803-613		Detail dwgs-man access port	120	15APR08*	02OCT08	377

Dahlgren

Job: 1702 - Base Support Struct Design-DAHLGREN

1702-515	3	Base support - PDR	5	31JAN08	06FEB08	202
1702-516	3	Disposition PDR chits	5	07FEB08	13FEB08	202
1702-520		Final design. Assy dwgs, fab dwgs,	64*	01FEB08A	30APR08	147
1702-521	2	Issue dwgs for comment	0		28MAR08*	170
1702-525M	2	Base Support Structure FDR	0		30APR08	147

Job: 1501 - Coil Structures Design-DAHLGREN

1501-533		Detail CAD Drawings,BOM	260*	01JUN07A	16JUN08	212
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							FEB				MAR				APR			
							4	11	18	25	3	10	17	24	31	7	14	21
1501-533F		Integrated Stress Analysis	176*	01OCT07A	16JUN08	222												
1501-536		Issue dwgs for review	0		01APR08*	245												
Dudek																		
Job: 1429 - MC Interface R&D-DUDEK																		
Outboard Interface-Friction																		
1429-3030		G-10 Test	30	03MAR08*	11APR08	1,640												
Job: 1431 - Mod. Coil Interface Hardware-DUDEK																		
Bladders																		
1421-3024		Prep Req, Bid,& Award Remaining Bladders	21*	03MAR08*	31MAR08	114												
1421-3025		Deliver remaining bladders	14*	01APR08	18APR08	114												
Shims-Outboard																		
1429-3066H		Deliver 1st HP shims to PPPL	1	31JAN08*	31JAN08	26												
1429-3069		Outboard Shims Available for 1st 3 pack MC	0		28FEB08	6												
S21-5.04X		Shims required for 1st 3 pack MC assy	0		29FEB08	6												
Shims-Inboard																		
1429-3062X		Inboard Shims	208	03MAR08*	02JAN09	74												
1429-3060B		PPPL water jet cut inboard shims	3	03JAN08A	05FEB08	19												
1429-3060A		PPPL mill inboard shims to thickness (for A-B)	5	06FEB08	12FEB08	19												
1429-3060D		PPPL mill inboard shims to thickness (for B-C)	10	13FEB08	26FEB08	93												
1429-3060C		PPPL anneal inboard shims	3	13FEB08	15FEB08	19												
Studs,Washers,Nuts																		
1421-3063		Stud kits available for balance of MC assy	0		30JAN08	156												
Ellis																		
Job: 8205 - Dimensional Control Coordin-ELLIS																		
METDCP-3	3	Dimensional control plans for station 3	40	05FEB08	31MAR08	163												
Goranson																		
Job: 1601 - Coil Services Design-GORANSON																		
161 - LN2 Distribution																		
191-001		Title I design WBS 161 LN2 manifolds&piping	166*	01OCT07A	02JUN08	231												
162 - Electrical Leads																		
132-001		Title I design WBS 162 Coil leads	180*	03DEC07A	21AUG08	199												
Kalish																		
Job: 1361 - TF Fabrication-KALISH																		
TF Fabrication Contract																		
1361C-108		Fab, Test & Deliver Coil #8	21*	31JAN08	28FEB08	497												
1361C-109		Fab, Test & Deliver Coil #9	1	24MAR08*	24MAR08	496												
1361C-110		Fab, Test & Deliver Coil #10	1	15APR08*	15APR08	496												
Job: 1354 - Trim Coil Design &Procurement-KALISH																		
Trim Coil **Updated estimate**																		
TRIM-020		Trim Coil System Requirements Document	12	07FEB08A	15FEB08	251												
TRIM-030		Review and Approve SRD	5	18FEB08*	22FEB08	251												
TRIM-070		Prelim trim coil concept & reqmnts	50*	02JAN08A	11MAR08	259												
TRIM-071		Layout/Design coils & supports	29*	31JAN08*	11MAR08	259												
TRIM-080		Analysis	50*	02JAN08A	11MAR08	259												
TRIM-090		Prepare for PDR	20*	25FEB08	21MAR08	251												

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							FEB				MAR				APR									
							4	11	18	25	3	10	17	24	31	7	14	21						
TRIM-100		Trim Coil PDR	1	24MAR08	24MAR08	251																		
TRIM-101	2	** Trim Coil PDR **	0		24MAR08	251																		
TRIM-110		Procure Trim Coil Insulation	50	25MAR08	03JUN08	337																		
TRIM-130		Prepare Conductor Procurement Spec	3	25MAR08	27MAR08	279																		
TRIM-140		Review and Approve Conductor Spec.	5	28MAR08	03APR08	279																		
TRIM-120		Procure Trim Coil Conductor	100	04APR08	25AUG08	279																		
TRIM-170		Complete Trim Coil Detailed Drawings	10	25MAR08	07APR08	251																		
TRIM-200		Assy drawings & parts list	10	08APR08	21APR08	251																		
TRIM-150		Prepare Trim Coil Procurement Spec.	10	25MAR08	07APR08	256																		
TRIM-160		Approve Procurement Spec	5	08APR08	14APR08	256																		
Perry																								
Job: 1353 - CS Structure Procurement-PERRY																								
CS Support Structure																								
1353-001		Design PF1a upper to lower interconnect bus	12	15APR08*	30APR08	664																		
Job: 8215 Plant Design																								
FY07 Rebaseline Exercise																								
8210-07		Update plant model	19	31JAN08	26FEB08	1,673																		
Stratton																								
Job: 3101 - Magnetic Diagnostics-STRATTON																								
Rogowski Coils																								
3101-352		Assy & detail dgws	46	31JAN08	03APR08	431																		
3101-353		Prep installation procedure	31	04APR08	16MAY08	431																		
3101-354		Purchase materials	62	31JAN08	25APR08	446																		
3101-370		Check elect characteristics of cables	503*	16APR08*	23APR10	1,135																		
3101-351		Wind coils	13*	31MAR08*	16APR08	453																		
3101-359		Install Rogowski coils (budgeted in job 1815)	21*	02APR08*	30APR08	542																		
TF and PF Co-wound Loops																								
3101-425		Design Protective boxes for PF	100*	01NOV07A	01APR08	1,558																		
3101-426		Purchase SS Sheet	10	12NOV07A	18JUN08	320																		
3101-452		Form Protective boxes	10	12NOV07A	23JUN08	320																		
3101-454		Weld end plates of PF protective boxes	10	09NOV07A	30JUN08	320																		
3101-427		Purchase Heat Shrink tubing	15	12NOV07A	19MAY08	1,495																		
3101-458		FabTF,PF & solenoid co-wound loops	186	02JUL07A	15AUG08	1,462																		
T/C and Heater Tape Leads																								
1204-140.1		Peer Review T/C and Heater Tape Leads	12	15APR08*	30APR08	183																		
Voltage Loops & Protective Boxes																								
3101-802		Fab 3 protective Boxes (Use Existing Box)	10	31JAN08	13FEB08	1,682																		
Viola																								
Job: 1802 - FP Assy Oversight&Support-VIOLA																								
Station 3 procedures,JHA,ACC,Training,Prep																								
R1802-307		Procedures written & approved	10	01APR08	14APR08	163																		
R1802-309		JHA completed	6	15APR08	22APR08	163																		
Job: 1810 - Field Period AssyStation 1,2,3 VIOLA																								
Station 1-VV Prep (hard surface components) FP#1																								
R1810-1108		Perform final acceptance testing (H/C flow test)	15	26MAR08*	15APR08	284																		
R1810-1100		Design & Build heater& thermo termination box	41	06MAR08*	01MAY08	254																		

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Station 1- VV Prep (hrd surf cmpntsFP#2)																						
R1810-1208		Perform final acceptance testing (H/C flow test)	32	16APR08	30MAY08	341																
Setup																						
R1810-2047		Calibrate stud tensioner	44	31JAN08	01APR08	1,648																
R1810-2036		Fuji Paper	20	31JAN08	27FEB08	1,672																
R1810-2038		Purchase 5 ton gantry	65	31JAN08	30APR08	1,627																
R1810-2045		2 Electric Torque wrench	56	31JAN08*	17APR08	1,636																
R1810-2080		3rd laser tracker	65	31JAN08*	30APR08	1,627																
R1810-2081		Removable photogrammetry targets	108*	31JAN08*	01JUL08	1,584																
R1810-2082		Fixed photogrammetry targets	108*	31JAN08*	01JUL08	1,584																
R1810-2083		Replacement photogrammetry targets	65	31JAN08*	30APR08	1,627																
R1810-2027		Install THIRD Holding 20 deg fixture	10	01APR08*	14APR08	1,639																
R1810-2084		Design and purchase 3 additional wedge	87*	31JAN08	02JUN08	18																
R1810-2024		Rework wedges f/combined assemblies& coil	10	31JAN08	13FEB08	1,682																
R1810-2026		Setup up satellite shop in Mock-up area	15	31JAN08	20FEB08	1,677																
R1810-2085		Trak 3 axis mill	65	31JAN08*	30APR08	1,627																
R1810-2086		Trak 3 axis mill collet set	65	31JAN08*	30APR08	1,627																
R1810-2087		Coordinate measuring machine	65	31JAN08*	30APR08	1,627																
R1810-2088		HEPA machine tool exhaust system	65	31JAN08*	30APR08	1,627																
R1810-2089		Tools, cabinets & storage shelving	65	31JAN08*	30APR08	1,627																
R1810-2002		Purchase grinding machine	45	31JAN08	02APR08	1,647																
S20-3.03		Compress G10 shims & sort (initial 300 shims	6	31JAN08*	07FEB08	22																
S20-4.01		Install MCHP fixtures & metrology equipt	67	01APR08*	03JUL08	1,582																
S20-4.02		Perform metrology set-up;purchase 6 pillars	43	31JAN08*	31MAR08	1,649																
Pre-Measuring and fitup checks																						
Pre measurement of MCHP A1,B1,C1 flanges																						
2-1-2.99		Drill Stycast fill holes	10	14MAR08*	27MAR08	56																
Pre measurement of MCHP A2,B2,C2 flanges																						
2-2-2.99		Drill Stycast fill holes	3	27MAR08*	31MAR08	152																
S22-3.02		Compress shims sort by thickness	20	07MAR08*	03APR08	96																
Pre measurement of MCHP A3,B3,C3 flanges																						
S23-1.01		Verify mating MC's of MCHP will come together	4	31JAN08	05FEB08	144																
2-3-2.99		Drill Stycast fill holes	3	01APR08	03APR08	156																
S23-3.02		Compress shims sort by thickness	6	14APR08	21APR08	90																
S23-4.01		Install MCHP fixtures & metrology equipt	6	14APR08	21APR08	90																
Pre measurement of MCHP A4,B4,C4 flanges																						
2-4-2.99		Drill Stycast fill holes	3	04APR08	08APR08	191																
Station 2 MC subassy A1B1C1																						
A-B MC Assembly																						
2-1-6.09		torque50% of final value & recheck.	1	11MAR08*	11MAR08	0																
2-1-6.10		Measure position of all monuments	2	12MAR08	13MAR08	0																
2-1-6.11		Measure shim puck height	1	14MAR08	14MAR08	0																
2-1-6.12		Remove puck locating rings & install all nose s	3	17MAR08	19MAR08	0																
2-1-6.13		"Lightly" tack weld nose flex shims "A" & "B"	1	20MAR08	20MAR08	0																
2-1-6.14		Unfasten bolts & remove "B" coil place it on sep	1	21MAR08	21MAR08	0																
2-1-6.15		Recheck part alignment of "A" coil	2	24MAR08	25MAR08	0																
2-1-6.151		Weld all Type-A flex shims plasma side	2	26MAR08	27MAR08	0																
2-1-6.16		recheck alignment	1	28MAR08	28MAR08	0																
2-1-6.17		Time for a back office assessment (first wedl on	10	31MAR08	11APR08	0																
2-1-6.18		Measure "B" fiducials estab coord sys	1	31MAR08	31MAR08	9																
2-1-6.19		Weld allType-B (A-flange) flex shims plasma	2	14APR08	15APR08	0																

Activity ID	MILE STONE LEVEL	Activity Description	Duration (work days)	Forecast Start	Early Finish	Total Float	FY08												
							FEB				MAR				APR				
							4	11	18	25	3	10	17	24	31	7	14	21	
2-1-6.20		Recheck part metrology acceptance criterion.	1	16APR08	16APR08	0													
2-1-6.21		Back office assessment of part after weld	5	17APR08	23APR08	0													
2-1-6.22		Remove alumina shims as necessary	0	17APR08	16APR08	4													
2-1-6.04		Place unfilled shim bags in wing areas	1	17APR08	17APR08	4													

