

## Bob Simmons

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**From:** Thomas G. Brown  
**Sent:** Friday, October 26, 2007 4:17 PM  
**To:** Phil Heitzenroeder; Bob Simmons; Michael E. Viola; Michael R. Kalish; Robert A. Ellis; James L. Anderson; Hutch Neilson; Ronald L. Strykowski; Erik D. Perry; Cole, Michael  
**Cc:** Pamela Hampton  
**Subject:** Updated sequence plan  
  
**Attachments:** AssySeqPlan\_R9.2.xls



AssySeqPlan\_R9.2.  
xls (11 MB)

Attached is a final update in the Sequence plan...I've run out of time. Station 2, 1st article and production article have been updated to reflect changes in the inboard nose weld and comments received from Mike Viola. Station 3, although contained the same logic and processes of earlier releases, has been significantly updated to reflect changes in inboard welding of the nose and the assembly change of fixing the right MCHP support location. I have also incorporated all the good general comments from Bob Ellis in Station 3 plus specific inputs regarding the proper metrology alignment terminology. He will need to go through Stations 2, 5 and 6 to make sure the metrology requirements are consistent. He will do this but at a later date.

Station 5 was only modestly updated to show place holders for the trim coils. Their assembly starts in Step 2 with the need to locate the bottom coil that surrounds Port 12. I inserted a Step 5 for the installation of all remaining trim coils. Mike I added Step 5.02 to measure the location of the trim coils. I forgot this step in my earlier releases to you. I expect that Station 5 will have some additional minor "trim coil" effects at a later date.

I'm sorry Erik but I didn't have the time to go back through Station 6 in any detail. Phil commented earlier that the metrology pole was too small. I did update Figure 3a with a larger diameter pole, but the full assembly model is too large and involved to quickly define the proper views to update all the figures. Another comment that I heard from the internal reviews was the VV welding / TF coil assembly sequence. I didn't need to fix this as the plan identifies the final TF coils (on the "C" MC's) are installed in Step 12 with all coils moved back (as much as possible) in Step 12.06. The VV is welded as part of Step 15. I think we're okay here. The trim coils will affect Station 6 but I do not believe they will impose a construction feasibility issue.

Let me know if any gross omissions or errors are found and I will do a further revision. If I receive no comments, I will assume that this is now frozen for this review.

Tom