NATIONAL SPHERICAL TORUS EXPERIMENT UPGRADE PROJECT
Engineering Change Proposal (ECP)
Part I To be Completed by Originator

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ECP-027

COVER PAGE

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Originator (CAM) Chrzanowski

Date Submitted 4/25/2012

ECP No. 027

ECP Title Update (replanning) of Control Accounts 1302, 1304, 1305, 1307 including additional tasks and updated resources. Delete Planning Package 8200-PP01A; work not required.

Required Reviewers (Change Control Board)
- ☐ Williams
- ☒ Strykowsky
- ☐ Dudek
- ☐ Stevenson
- ☒ Langish
- ☐ Other...

Change Level 2 Federal Project Director

Approvals

Change Level	Approving Official	Approval	Signature
3	NSTXU Project Manager	☒ Yes ☐ No	Ron Strykowsky — Digitally signed by Ron Strykowsky DN: cn=Ron Strykowsky, o, ou=PPPL, email=rstrykow@pppl.gov, c=US Date: 2012.04.27 14:26:49 -04'00'
3a Expedited ECP	NSTXU Engineering Lead	☐ Yes ☐ No	
2	NSTXU Federal Project Dir.	☒ Yes ☐ No	Jeffrey Makiel — Digitally signed by Jeffrey Makiel DN: cn=Jeffrey Makiel, o=Princeton Site Office, ou=US Dept of Energy, email=jmakiel@pppl.gov, c=US Date: 2012.05.01 07:33:53 -04'00'
1	Associated Director OFES	☐ Yes ☐ No	
0	Deputy Secretary of Energy	☐ Yes ☐ No	

Approval Date

- **Primavera Updated** ☐
- **Cobra Updated** ☐
- **WAD Updated** ☐
- **RAM Updated** ☐

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PART I

Originator (CAM) Chrzanowski

Date Submitted 4/25/2012

Type of ECP ☒ Standard ☐ Expedited

Type of Change (Check all that apply) ☐ Technical ☒ Cost ☒ Schedule ☐ Editorial ☐ Other

Reason for Change Update (replanning) of Control Accounts 1302, 1304, 1305, 1307 including additional tasks and updated resources. Delete Planning Package 8200-PP01A; work not required.

Impacted WBS Elements

☒ 1.1	☐ Milestone
☐ 1.2	☐ Other...
☐ 1.3	
☐ 1.4	
☐ 1.5	
☐ 1.6	
☐ 1.7	
☒ 1.8	
☐ PEP	

Control Accounts

☐ 1000	☐ 1306	☐ 2470	☒ 5000	☒ 8200
☐ 1001	☒ 1307	☐ 2475	☐ 5200	☐ 8210
☐ 1002	☐ 1310	☐ 2480	☐ 5501	☐ 8250
☐ 1200	☐ 2300	☐ 2485	☐ 6100	☐ Other...
☐ 1300	☐ 2420	☐ 2490	☐ 7200	
☐ 1301	☐ 2425	☐ 3200	☐ 7300	
☒ 1302	☐ 2430	☐ 3300	☐ 7400	
☐ 1303	☐ 2440	☐ 3400	☐ 7100	
☒ 1304	☐ 2450	☐ 4100	☐ 7710	
☒ 1305	☐ 2460	☐ 4500	☐ 7900	

Impacts of Change (Briefly Describe) **Increase cost and schedule change**

Impact on Materials Parts Already Manuf. ○ Yes ◉ No

If yes, what is recommended disposition None

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Detailed Description of Change

Description of Change

1) DELETE the following tasks:
From Control Account 1305 delete:
1304-1310
1304-5500
Total decrease: $39,256.00

2) Update Control Accounts 1302, 1304, 1305, and 1306 with the attached schedule:
Total increase/(decrease):
1302: $(251,446.77) Note: Tasks from 1302 moved to CA's below.
1304: $132,423.57
1305: $279,107.20
1307: $8,338.40
Total increase: $168,422.40

3) Delete Planning Package 8200-PP01A Al Block Gaps (work not necessary)
Total decrease: $107,230.24

Net Contingency draw: $21,936.16

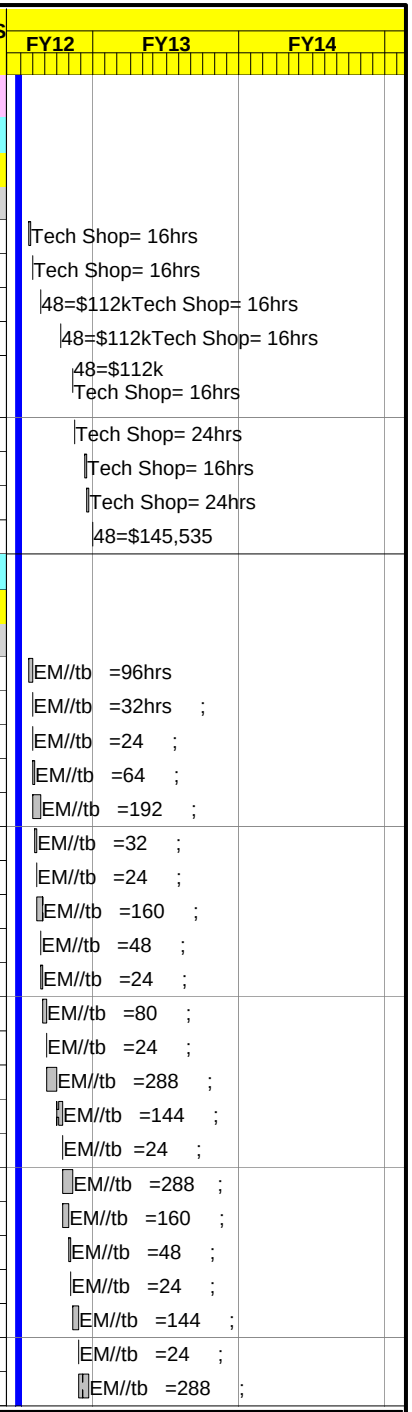
SUBMIT ECP

Do not fill in information below this point

List of Attachments ☐ **Primavera Schedule (Before/After)** ☐ **Cobra (Before/After)** ☐ **Other...**

NSTX Upgrade Project

Activity ID	DFRD	Activity Description	Work Days	Forecast Start	Forecast Finish	Total Float	% Comp	Budgeted Cost	EVMS
Job: 1304 - Inner TF Bundle (Ds/Fab)-CHRZANOWSKI									
Manufacture Inner TF Conductor									
Procurement									
1304-0951B		Receive & inspect Quadrant #1 (Conductors 3 & 4)	1	25APR12	25APR12	41	0	1,536.32	F
1304-0951C		Receive & inspect Quadrant #1 (Conductors 5-9)	1	03MAY12	03MAY12	41	0	1,536.32	F
1304-09503		Receive & inspect Quadrant #3 Conductors	1	22MAY12	22MAY12	60	0	119,136.32	F
1304-09504		Receive & inspect Quadrant #4 Conductors	1	12JUL12	12JUL12	60	0	119,136.32	F
1304-09506		Receive & inspect Quadrant #5 Conductors	1	10AUG12	10AUG12	754	0	119,136.32	F
1304-09507		Transfer Quadrant #5 Conductors to Warehouse	1	17AUG12	17AUG12	774	0	2,304.48	F
1304-09508		Receive & inspect Quadrant #6 Conductors	1	12SEP12	12SEP12	754	0	1,536.32	F
1304-09509		Transfer Quadrant #6 Conductors to Warehouse	1	17SEP12	17SEP12	754	0	2,304.48	F
1304-0950B		Receive Balance of Final Machined TF Cond	1	01OCT12*	01OCT12	744	0	157,177.80	F
Job: 1305 - OHMIC Heating Coil (OH)-CHRZANOWSKI									
Inner TF Conductor Receipt/Inspection/Prep									
Fabrication / Assembly									
1304-1330		Solder cooling tubes Quadrant#1 (Conductors 1&2)	6	23APR12	30APR12	27	0	9,217.92	E
1304-1340		Cleanup TF conductors-post solder Quadrant#1(1&2	2	01MAY12	02MAY12	27	0	3,072.64	E
1304-1340A		Transfer TF conductor CS Coil Area Quadrnt#1(1&2	1	03MAY12	03MAY12	27	0	2,304.48	E
1304-13302		Solder cooling tubes Quadrant#1 (Conductors 3&4)	4	04MAY12	09MAY12	27	0	6,145.28	E
1304-1350		Sandblast Quadrant#1 Conductors (Clean & Bag)	12	04MAY12	21MAY12	42	0	18,435.84	E
1304-13402		Cleanup TF conductors-post solder Quadrant#1(3&4	2	10MAY12	11MAY12	27	0	3,072.64	E
1304-13405		Transfer TF conductor CS Coil Area Quadrnt#1(3&4	1	14MAY12	14MAY12	27	0	2,304.48	E
1304-13303		Solder cooling tubes Quadrant#1 (Conductors 5-9)	10	15MAY12	29MAY12	27	0	15,363.20	E
1304-1360		Apply Primer & Cure Quadrant#1 Conductors	3	22MAY12	24MAY12	42	0	4,608.96	E
1304-1360A		Transfer to Insulating Area Quadrant#1 Conductor	1	25MAY12	25MAY12	42	0	2,304.48	E
1304-13403		Cleanup TF conductors-post solder Quadrant#1(5-9	5	30MAY12	05JUN12	27	0	7,681.60	E
1304-13406		Transfer TF conductor CS Coil Area Quadrnt#1(5-9	1	06JUN12	06JUN12	27	0	2,304.48	E
1304-13304		Solder TF cooling tubes Quadrant#2	18	07JUN12	02JUL12	27	0	27,653.76	E
1304-13404		Cleanup TF conductors-post solder Quadrant#2	9	03JUL12	16JUL12	27	0	13,826.88	E
1304-13407		Transfer TF conductor CS Coil Area Quadrnt#2	1	17JUL12	17JUL12	27	0	2,304.48	E
1304-13408		Solder TF cooling tubes Quadrant#3	18	18JUL12	10AUG12	28	0	27,653.76	E
1304-13502		Sandblast Quadrant#2 Conductors (Clean & Bag)	10	18JUL12	31JUL12	27	0	15,363.20	E
1304-13602		Apply Primer & Cure Quadrant#2 Conductors	3	01AUG12	03AUG12	27	0	4,608.96	E
1304-13605		Transfer to Insulating Area Quadrant#2 Conductor	1	06AUG12	06AUG12	27	0	2,304.48	E
1304-13409		Cleanup TF conductors-post solder Quadrant#3	9	13AUG12	23AUG12	28	0	13,826.88	E
1304-13410		Transfer TF conductor CS Coil Area Quadrnt#3	1	24AUG12	24AUG12	28	0	2,304.48	E
1304-13411		Solder TF cooling tubes Quadrant#4	18	27AUG12	20SEP12	29	0	27,653.76	E



Data Date 31MAR12
Run Date 25APR12 10:38

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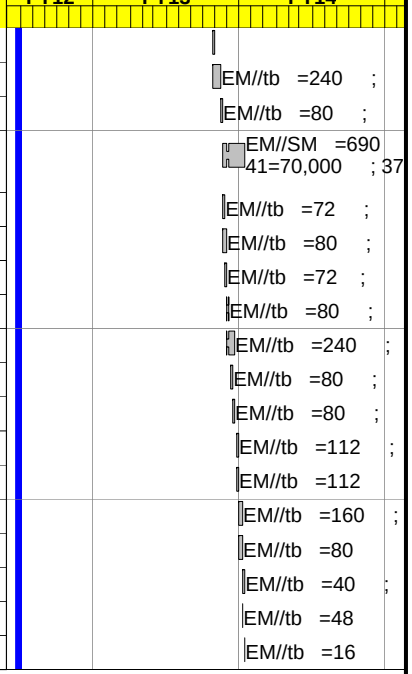
EC27
EVMS Rule
A = LOE K = Planning Pkg
B = Milestone
C = % Complete
E = 50 - 50

NSTX UPGRADES
ECP-027

FORECAST
Progress Bar
Critical Activity

Activity ID	DFRD	Activity Description	Work Days	Forecast Start	Forecast Finish	Total Float	% Comp	Budgeted Cost	EVMS	FY12 FY13 FY14
1304-13503		Sandblast Quadrant#3 Conductors (Clean & Bag)	10	27AUG12	10SEP12	28	0	15,363.20	E	EM//tb =160 ;
1304-13603		Apply Primer & Cure Quadrant#3 Conductors	3	11SEP12	13SEP12	28	0	4,608.96	E	EM//tb =48 ;
1304-13606		Transfer to Insulating Area Quadrant#3 Conductor	1	14SEP12	14SEP12	28	0	2,304.48	E	EM//tb =24 ;
1304-13412		Cleanup TF conductors-post solder Quadrant#4	9	21SEP12	03OCT12	29	0	13,931.04	E	EM//tb =144 ;
1304-13413		Transfer TF conductor CS Coil Area Quadrnt#4	1	04OCT12	04OCT12	29	0	2,356.56	E	EM//tb =24 ;
1304-13504		Sandblast Quadrant#4 Conductors (Clean & Bag)	10	05OCT12	18OCT12	29	0	15,710.40	E	EM//tb =160 ;
1304-13604		Apply Primer & Cure Quadrant#4 Conductors	3	19OCT12	23OCT12	29	0	4,713.12	E	EM//tb =48 ;
1304-13607		Transfer to Insulating Area Quadrant#4 Conductor	1	24OCT12	24OCT12	29	0	2,356.56	E	EM//tb =24 ;
Inner TF Quadrant 1										
Fabrication / Assembly										
1304-1520		Apply turn insulation Quadrant #1	6	11JUN12	18JUN12	33	0	18,435.84	E	EM//tb =192 ;
1304-1530		Assemble Quadrant #1	10	19JUN12	02JUL12	33	0	38,408.00	E	EM//tb =400 ;
1304-1540		Prepare VPI operation	3	03JUL12	06JUL12	33	0	9,217.92	E	EM//tb =96 ;
1304-1550		VPI- fill quadrant #1	2	09JUL12	10JUL12	33	0	6,145.28	E	EM//tb =64 ;
1304-1560		Cure VPI'd coil	8	11JUL12	20JUL12	33	0	6,145.28	E	EM//tb =64 ;
1304-1570		Remove Quadrant #1 from mold	1	23JUL12	23JUL12	33	0	3,072.64	E	EM//ST =32 ;
1304-1580		Cleanup quadrant	3	24JUL12	26JUL12	33	0	4,608.96	E	EM//tb =48 ;
1304-1590		Perform T/T electrical tests	1	27JUL12	27JUL12	33	0	1,536.32	E	EM//tb =16 ;
Inner TF Quadrant 2										
Fabrication / Assembly										
1304-1620		Apply turn insulation Quadrant #2	5	07AUG12	13AUG12	27	0	15,363.20	E	EM//tb =160 ;
1304-1630		Assemble Quadrant #2	6	14AUG12	21AUG12	27	0	23,044.80	E	EM//tb =240 ;
1304-1640		Prepare VPI operation	3	22AUG12	24AUG12	27	0	9,217.92	E	EM//tb =96 ;
1304-1650		VPI- fill quadrant	2	27AUG12	28AUG12	27	0	6,145.28	E	EM//tb =64 ;
1304-1660		Cure VPI'd coil	8	29AUG12	10SEP12	27	0	6,145.28	E	EM//tb =64 ;
1304-1670		Remove Quadrant #2 from mold	1	11SEP12	11SEP12	27	0	3,072.64	E	EM//tb =32 ;
1304-1680		Cleanup quadrant	3	12SEP12	14SEP12	27	0	4,608.96	E	EM//tb =48 ;
1304-1690		Perform T/T electrical tests	1	17SEP12	17SEP12	27	0	1,536.32	E	EM//tb =16 ;
Inner TF Quadrant 3										
Fabrication / Assembly										
1304-1720		Apply turn insulation Quadrant #3	5	18SEP12	24SEP12	27	0	15,363.20	E	EM//tb =160 ;
1304-1730		Assemble Quadrant #3	6	25SEP12	02OCT12	27	0	23,218.40	E	EM//tb =240 ;
1304-1740		Prepare VPI operation	3	03OCT12	05OCT12	27	0	9,426.24	E	EM//tb =96 ;
1304-1750		VPI- fill quadrant	2	08OCT12	09OCT12	27	0	6,284.16	E	EM//tb =64 ;
1304-1760		Cure VPI'd coil	8	10OCT12	19OCT12	27	0	6,284.16	E	EM//tb =64 ;
1304-1770		Remove Quadrant #3 from mold	1	22OCT12	22OCT12	27	0	3,142.08	E	EM//tb =32 ;
1304-1780		Cleanup quadrant	3	23OCT12	25OCT12	27	0	4,713.12	E	EM//tb =48 ;
1304-1790		Perform T/T electrical tests #4	1	26OCT12	26OCT12	27	0	1,571.04	E	EM//tb =16 ;
Inner TF Quadrant 4										
Fabrication / Assembly										
1304-1820		Apply turn insulation Quadrant #4	5	29OCT12	02NOV12	27	0	15,710.40	E	EM//tb =160 ;
1304-1830		Assemble Quadrant #4	6	05NOV12	12NOV12	27	0	23,565.60	E	EM//tb =240 ;
1304-1840		Prepare VPI operation	3	13NOV12	15NOV12	27	0	9,426.24	E	EM//tb =96 ;

Activity ID	DFRD	Activity Description	Work Days	Forecast Start	Forecast Finish	Total Float	% Comp	Budgeted Cost	EVMS	FY12	FY13	FY14
1304-1850		VPI- fill quadrant	2	16NOV12	19NOV12	27	0	6,284.16	E		EM//tb =64 ;	
1304-1860		Cure VPI'd coil	8	20NOV12	03DEC12	27	0	6,284.16	E		EM//tb =64 ;	
1304-1870		Remove Quadrant #4 from mold	1	04DEC12	04DEC12	27	0	1,571.04	E		EM//tb =16 ;	
1304-1880		Cleanup quadrant	3	05DEC12	07DEC12	27	0	4,713.12	E		EM//tb =48 ;	
1304-1890		Perform T/T electrical tests	1	10DEC12	10DEC12	27	0	1,571.04	E		EM//tb =16 ;	
Inner TF Coil Assemble Quadrants												
Fabrication / Assembly												
1304-4800		Assemble quadrants together	7	11DEC12	19DEC12	27	0	27,493.20	E		EM//tb =280 ;	
1304-4900		Apply groundwrap insulation	3	20DEC12	02JAN13	27	0	4,713.12	E		EM//tb =48 ;	
1304-4902		Assemble Mold	5	03JAN13	09JAN13	27	0	11,782.80	E		EM//tb =120 ;	
1304-5000		Prepare VPI operation	3	10JAN13	14JAN13	27	0	9,426.24	E		EM//tb =96 ;	
1304-5100		VPI full TF coil	2	15JAN13	16JAN13	27	0	6,284.16	E		EM//tb =64 ;	
1304-5200		Cure VPI'd coil	8	17JAN13	28JAN13	27	0	6,284.16	E		EM//tb =64 ;	
1304-5300		Remove full TF from mold and cleanup	1	29JAN13	29JAN13	27	0	1,571.04	E		EM//tb =16 ;	
1304-5400		Perform Final electrical tests	1	30JAN13	30JAN13	27	0	1,571.04	E		EM//tb =16 ;	
TF/OH Fabrication												
Fabrication / Assembly												
1305-5700A		Reposition TF to Vertical Position	1	31JAN13	31JAN13	27	0	3,142.08	E		EM//tb =32 ;	
1305-5700B		Install Aquapour Mold & Cure	6	01FEB13	08FEB13	27	0	14,139.36	E		EM//tb =144 ;	
1305-5800		Apply slip plane, and inner groundwall insulatn	2	18MAR13	19MAR13	2	0	4,713.12	E		EM//tb =48 ;	
1305-5600		Prepare TF for OH winding	5	20MAR13	26MAR13	2	0	15,710.40	E		EM//tb =160 ;	
1305-5900		Braze first lead and prepare for winding	5	27MAR13	02APR13	2	0	15,710.40	E		EM//tb =160 ;	
1305-6000		Wind 1st Quarter of layer #1	5	03APR13	09APR13	2	0	15,710.40	E		EM//tb =160 ;	
1305-6100		Make[2] in-line brazes of 1st Quarter of layer#1	4	10APR13	15APR13	2	0	6,284.16	E		EM//tb =64 ;	
1305-6200		Wind second Quarter of layer #1	4	16APR13	19APR13	2	0	12,568.32	E		EM//tb =128 ;	
1305-6200A		Make[2] in-line brazes of 2nd Quarter of layer#1	4	22APR13	25APR13	2	0	6,284.16	E		EM//tb =64 ;	
1305-6200B		Wind Third Quarter of layer #1(2-SHIFT till Fin)	2	26APR13	29APR13	2	0	9,426.24	E		EM//tb =96 ;	
1305-6200C		Make[2] in-line brazes of 3rd Quarter of layer#1	2	29APR13	30APR13	2	0	4,713.12	E		EM//tb =48 ;	
1305-6200D		Wind 4th Quarter of layer #1	2	30APR13	01MAY13	2	0	9,426.24	E		EM//tb =96 ;	
1305-6300		Perform prelim electrical tests layer #1	1	02MAY13	02MAY13	2	0	1,571.04	E		EM//tb =16 ;	
1305-6400		Braze layer to layer joint layer #1	2	03MAY13	06MAY13	2	0	7,069.68	E		EM//tb =72 ;	
1305-6500		Wind 1st Quarter of layer #2	2	06MAY13	07MAY13	2	0	12,568.32	E		EM//tb =128 ;	
1305-6600		Make[2] in-line brazes of 1st Quarter of layer#2	2	07MAY13	08MAY13	2	0	9,426.24	E		EM//tb =96 ;	
1305-6700		Wind second Quarter of layer #2	2	08MAY13	09MAY13	2	0	9,426.24	E		EM//tb =96 ;	
1305-6700A		Make[2] in-line brazes of 2nd Quarter of layer#2	2	09MAY13	10MAY13	2	0	4,713.12	E		EM//tb =48 ;	
1305-6700B		Wind Third Quarter of layer #2	2	10MAY13	13MAY13	2	0	9,426.24	E		EM//tb =96 ;	
1305-6700C		Make[2] in-line brazes of 3rd Quarter of layer#2	2	13MAY13	14MAY13	2	0	4,713.12	E		EM//tb =48 ;	
1305-6700D		Wind 4th Quarter of layer #2	2	14MAY13	15MAY13	2	0	9,426.24	E		EM//tb =96 ;	
1305-6800		Perform prelim electrical tests layer #2	1	15MAY13	15MAY13	2	0	1,571.04	E		EM//tb =16 ;	
1305-6900		Braze layer to layer joint layer #2	1	16MAY13	16MAY13	2	0	4,713.12	E		EM//tb =48 ;	
1305-7000		Wind 1st Quarter of layer #3	2	17MAY13	20MAY13	2	0	12,568.32	E		EM//tb =128 ;	
1305-7100		Make[2] in-line brazes of 1st Quarter of layer#3	2	20MAY13	21MAY13	2	0	9,426.24	E		EM//tb =96 ;	
1305-7200		Wind second Quarter of layer #3	2	21MAY13	22MAY13	2	0	9,426.24	E		EM//tb =96 ;	

Activity ID	DFRD	Activity Description	Work Days	Forecast Start	Forecast Finish	Total Float	% Comp	Budgeted Cost	EVMS	FY12 FY13 FY14
1305-7200A		Make[2] in-line brazes of 2nd Quarter of layer#3	2	22MAY13	23MAY13	2	0	4,713.12	E	EM//tb =48 ;
1305-7200B		Wind Third Quarter of layer #3	2	23MAY13	24MAY13	2	0	9,426.24	E	EM//tb =96 ;
1305-7200C		Make[2] in-line brazes of 3rd Quarter of layer#3	2	24MAY13	28MAY13	2	0	4,713.12	E	EM//tb =48 ;
1305-7200D		Wind 4th Quarter of layer #3	2	28MAY13	29MAY13	2	0	9,426.24	E	EM//tb =96 ;
1305-7300		Perform prelim electrical tests layer #3	1	29MAY13	29MAY13	2	0	1,571.04	E	EM//tb =16 ;
1305-7400		Braze layer to layer joint layer #3	1	30MAY13	30MAY13	2	0	4,713.12	E	EM//tb =48 ;
1305-7500		Wind 1st Quarter of layer #4	2	31MAY13	03JUN13	2	0	12,568.32	E	EM//tb =128 ;
1305-7600		Make[2] in-line brazes of 1st Quarter of layer#4	2	03JUN13	04JUN13	2	0	9,426.24	E	EM//tb =96 ;
1305-7700		Wind second Quarter of layer #4	2	04JUN13	05JUN13	2	0	9,426.24	E	EM//tb =96 ;
1305-7700A		Make[2] in-line brazes of 2nd Quarter of layer#4	2	05JUN13	06JUN13	2	0	4,713.12	E	EM//tb =48 ;
1305-7700B		Wind Third Quarter of layer #4	2	06JUN13	07JUN13	2	0	9,426.24	E	EM//tb =96 ;
1305-7700C		Make[2] in-line brazes of 3rd Quarter of layer#4	2	07JUN13	10JUN13	2	0	4,713.12	E	EM//tb =48 ;
1305-7700D		Wind 4th Quarter of layer #4	2	10JUN13	11JUN13	2	0	9,426.24	E	EM//tb =96 ;
1305-7700F		Make final lead brazes layer #4	2	11JUN13	12JUN13	2	0	4,713.12	E	EM//tb =48 ;
1305-7700E		Perform prelim electrical tests layer #4	1	13JUN13	13JUN13	2	0	1,571.04	E	EM//tb =16 ;
1305-7800		Apply groundwrap insulation	3	14JUN13	18JUN13	2	0	9,426.24	E	EM//tb =96 ;
1305-7900		Mount OH mold around coil	5	19JUN13	25JUN13	2	0	15,710.40	E	EM//tb =160 ;
1305-8000		Prepare VPI operation	3	26JUN13	28JUN13	2	0	9,426.24	E	EM//tb =96 ;
1305-8100		VPI- mold	2	01JUL13	02JUL13	2	0	6,284.16	E	EM//tb =64 ;
1305-8200		Cure VPI'd coil	8	03JUL13	16JUL13	2	0	6,284.16	E	EM//tb =64 ;
1305-8300		Remove mold from OH coil	1	17JUL13	17JUL13	2	0	3,142.08	E	EM//tb =32 ;
1305-8400		Cleanup OH coil	2	18JUL13	19JUL13	2	0	3,142.08	E	EM//tb =32 ;
1305-8500		Silverplate all electrical surfaces [OH/TF]	3	22JUL13	24JUL13	2	0	2,356.56	E	EM//tb =24 ;
1305-8600		Perform Final OH electrical tests	1	25JUL13	25JUL13	2	0	1,571.04	E	EM//tb =16 ;
1305-8700		Remove intermediate spacer between OH and TF bun	5	26JUL13	01AUG13	2	0	23,565.60	E	EM//tb =240 ;
1305-8800		Perform hydrostat and flow tests- OH/TF coils	3	02AUG13	06AUG13	2	0	4,713.12	E	EM//tb =48 ;
1305-8800A		Install Upper & Lower Crowns	10	07AUG13	20AUG13	2	0	31,420.80	E	EM//tb =320 ;
1305-8900		Transport to CS assembly station	1	21AUG13	21AUG13	2	0	3,927.60	E	EM//tb =40 ;
Job: 1306 - Inner PF Coils-CHRZANOWSKI										
Procurement										
1306-5030	X	Bid/Award Inner PF Fabrication (Coil & Supp)	25	28AUG12	02OCT12	4	0	0.00	E	
Job: 1307 - CS Casing Assembly -CHRZANOWSKI										
Procurement										
1307-2030E		Receipt/QA Insp Complete-Incomel Casing Assembly	1	25OCT12	25OCT12	150	0	131,470.56	F	48=121,732
Fabrication / Assembly										
1307-2030F		Setup casing for Inconel studs	5	26OCT12	01NOV12	150	0	7,855.20	F	EM//tb =8
Job: 1302 - Center Stack Assembly-CHRZANOWSKI										
Fabrication / Assembly										
1302-0210		Install Inconel Weld Studs on Casing Wall	14	02NOV12	21NOV12	150	0	21,994.56	E	EM//tb =224 ;
1302-0210A		Mount tiles to Inconel casing	35	11JUN13	31JUL13	17	0	54,986.40	E	EM//tb =560

Activity ID	DFRD	Activity Description	Work Days	Forecast Start	Forecast Finish	Total Float	% Comp	Budgeted Cost	EVMS
1302-0160		Receive & Inspect Inner PF Coils	5	26JUL13	01AUG13	11	0	3,927.60	E
1302-0170A		Install outer bands/flux loops on Inner PF1A/B	15	26JUL13	15AUG13	4	0	23,565.60	E
1302-0170B		Position/weld Upper PF1B coil t/lower casing flg	5	16AUG13	22AUG13	4	0	7,855.20	E
1302-1500		Assemble CS (OH Diag, Microtherm, Casing PFCs)	38	22AUG13	15OCT13	2	0	234,385.02	K
1302-1500A		Position OH/TF in vertical position	3	22AUG13	26AUG13	2	0	7,069.68	K
1302-0170C		Position/weld lower PF1B coil t/lower casing flg	5	23AUG13	29AUG13	4	0	7,855.20	E
1302-1500B		Join the Lower PF1A assembly with OH/TF Bundle	3	27AUG13	29AUG13	2	0	7,069.68	K
1302-0170D		Mount CS casing support to lower PF1A	5	30AUG13	06SEP13	4	0	7,855.20	E
1302-1500C		Install the surface diagnostics onto OH surface	15	30AUG13	20SEP13	2	0	23,565.60	K
1302-0180		Install microtherm insulation around lower PF1A	5	09SEP13	13SEP13	4	0	7,855.20	E
1302-0180A		Install microtherm insulation around upper PF1A	5	16SEP13	20SEP13	4	0	7,855.20	E
1302-1500D		Install Micro-therm insulation around OH coil	7	23SEP13	01OCT13	2	0	11,049.12	K
1302-1540A		Install outer bands/flux loops Inner PF1C coils	7	23SEP13	01OCT13	4	0	11,049.12	E
1302-1500E		Position CS Casing assembly over the OH/TF coil	5	02OCT13	08OCT13	2	0	16,228.80	K
1302-1540B		Assemble ceramic break assemblies	5	02OCT13	08OCT13	4	0	8,114.40	E
1302-1500F		Ready for Delivery to Test Cell	5	09OCT13	15OCT13	2	0	4,057.20	K
1302-1540C		Leak Test CB Assemblies	3	09OCT13	11OCT13	4	0	4,868.64	E
1302-1550		Deliver CS to NTC	1	16OCT13	16OCT13	2	0	1,622.88	E