

Argonne National Laboratory

9700 Cass Avenue

Argonne, Illinois 60439

DOCUMENT NO. L143-00031

SLAC NO. SP-381-001-01

STATEMENT OF WORK

FOR

LCLS UNDULATOR MAGNET POLES

WBS L.1.04.03

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ARGONNE NATIONAL LABORATORY

*Document No.
L143-00031-02

NOTIFICATION OF SPECIFICATIONS REVISION

Title: **Statement Of Work For LCLS Undulator Magnet Poles**

Page ii of iv

*The document number as it appears on this page only shall be used to identify this document. The last two digits denote the revision number of this document (see Revision Authorization block below).

This document is fully representative of the Document No. only when the revision number on its pages correspond with those in the index below.

INDEX OF PAGE REVISIONS

(INDEX)

| | | | | | | | | | | | | | | | |
|----------|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|
| PAGE NO. | 01 | 02 | 03 | 04 | 05 | 06 | 07 | 08 | 09 | 10 | 11 | 12 | 13 | 14 | 15 |
| REV. NO. | 00 | 00 | 00 | 00 | 00 | 00 | 00 | 00 | 00 | 00 | 00 | 00 | 00 | 00 | 00 |

| | | | | | | | | | | | | | | | |
|----------|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|
| PAGE NO. | 16 | 01 | 02 | 03 | 04 | 05 | 06 | 07 | 08 | 09 | 10 | 11 | 12 | 13 | 14 |
| REV. NO. | 00 | 01 | 01 | 01 | 01 | 01 | 01 | 01 | 01 | 01 | 01 | 01 | 01 | 01 | 01 |

| | | | | | | | | | | | | | | | |
|----------|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|
| PAGE NO. | 15 | 16 | 01 | 02 | 03 | 04 | 05 | 06 | 07 | 08 | 09 | 10 | 11 | 12 | 13 |
| REV. NO. | 01 | 01 | 02 | 02 | 02 | 02 | 02 | 02 | 02 | 02 | 02 | 02 | 02 | 02 | 02 |

| | | | | | | | | | | | | | | | |
|----------|----|----|----|--|--|--|--|--|--|--|--|--|--|--|--|
| PAGE NO. | 14 | 15 | 16 | | | | | | | | | | | | |
| REV. NO. | 02 | 02 | 02 | | | | | | | | | | | | |

| | | | | | | | | | | | | | | | |
|----------|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|
| PAGE NO. | | | | | | | | | | | | | | | |
| REV. NO. | | | | | | | | | | | | | | | |

| | | | | | | | | | | | | | | | |
|----------|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|
| PAGE NO. | | | | | | | | | | | | | | | |
| REV. NO. | | | | | | | | | | | | | | | |

REVISION AUTHORIZATION

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TABLE OF CONTENTS

| | Page |
|--|-------------|
| INDEX OF PAGE REVISIONS..... | ii |
| TABLE OF CONTENTS..... | iii |
| 1.0 INTRODUCTION: | 1 |
| 2.0 SCOPE: | 1 |
| 2.1 Scope of Work for the LCLS Undulator Magnet Poles..... | 1 |
| 2.2 Delivery..... | 2 |
| 2.3 First Article. | 3 |
| 3.0 APPLICABLE DOCUMENTS AND /OR SPECIFICATIONS: | 3 |
| 4.0 TECHNICAL TASKS AND QUALITY ASSURANCE:..... | 3 |
| 4.1 Fabrication..... | 3 |
| 4.1.1 Materials..... | 3 |
| 4.1.2 Annealing. | 4 |
| 4.1.3 Marking. | 4 |
| 4.1.4 Packaging and Shipping..... | 5 |
| 4.2 Program Plan..... | 5 |
| 4.2.1 Program Plan General Description. | 5 |
| 4.2.2 Program Plan Content. | 6 |
| 4.2.3 Program Plan Format. | 7 |
| 4.2.4 Program Plan Maintenance. | 7 |
| 4.3 Program Meetings. | 7 |
| 4.4 Program Schedule. | 8 |
| 4.4.1 Program Schedule General Description..... | 8 |
| 4.4.2 Program Schedule Content..... | 8 |
| 4.4.3 Program Schedule Format..... | 8 |
| 4.4.4 Program Schedule Maintenance. | 9 |
| 4.5 Testing..... | 9 |
| 4.5.1 Measurements. | 9 |
| 4.5.2 Critical Features. | 10 |
| 4.6 Special Tooling. | 10 |
| 4.7 Quality Control..... | 10 |
| 4.7.1 First-Article Inspection. | 10 |



ARGONNE NATIONAL LABORATORY

L143-00031

Title: Statement Of Work For LCLS Undulator Magnet Poles

**Rev.
02**

Approved

Date

Page iv of iv

4.7.2 Changes Proposed by Contractor.....11

4.7.3 Proprietary Designs and Processes.11

4.8 Inspection and Test Plan.11

4.9 Quality Assurance.12

4.10 Source Inspection.12

4.11 Testing Surveillance.....12

4.12 Test Failures.12

4.13 Red Flag Notice.....12

 4.13.1 Date and Number.13

 4.13.2 Contract Required Delivery Date.....13

 4.13.3 Estimated Shipping Dates.13

 4.13.4 Statement of Problem.....13

 4.13.5 Consequence.13

 4.13.6 Action Taken.....13

 4.13.7 Action Required.14

 4.13.8 Assistance Required.....14

 4.13.9 Number of Times Reported.....14

 4.13.10 Acknowledgement of Responsibility.....14

4.14 Nonconformance Reporting.....14

4.15 Approvals.14

5.0 REPORTS, DATA, AND DELIVERABLES:15

 5.1 Progress Report.15

 5.2 Technical Data.15

 5.3 Delivery.....16

6.0 OTHER SPECIAL CONSIDERATIONS:16

 6.1 Subcontractors.....16

 6.2 Disclosure and Publication.....16



1.0 INTRODUCTION:

The Linac Coherent Light Source (LCLS) will be the world's first x-ray free electron laser when it becomes operational in 2009. The LCLS is a US-DOE-funded project that is currently in the detailed project engineering and design phase. Design and construction are accomplished by a partnership of three US national laboratories including the Stanford Linear Accelerator Center (SLAC) as home laboratory, together with the Lawrence Livermore National Laboratory (LLNL) and Argonne National Laboratory (ANL). The start of construction is planned in FY2005. Pulses of x-ray laser light from the LCLS will be many orders of magnitude brighter and several orders of magnitude shorter than presently-available x-rays from other sources. These characteristics will enable frontier new science in areas that include discovering and probing new states of matter, understanding and following chemical reactions and biological processes in real time, imaging chemical and structural properties of materials on the nanoscale, and imaging non-crystalline biological materials at atomic resolution.

In a FEL, the actual lasing occurs as a result of the electron beam passing through a precision magnetic device called an undulator. Undulator construction is the responsibility of ANL.

2.0 SCOPE:

2.1 Scope of Work for the LCLS Undulator Magnet Poles.

A total of 40 undulators are required for the LCLS project. The present procurement is for all the undulators' Magnet Poles for a total of 19,200 poles. The poles at each end of the upper and lower magnet arrays are slightly different from the rest of the poles due to two added tapped holes. These are the Last Poles. Of the 19200 poles, 170 shall be Last Poles with the additional tapped holes. An experimental prototype undulator was constructed and tested at the Advanced Photon Source (APS) at ANL. Some design and value engineering changes were made as a result, and are incorporated into the production magnet pole design.

Each undulator is comprised of a precision-tuned array of very strong permanent magnets and magnet poles that result in a precisely-set magnetic field down the axis along which the electron beam eventually travels. There are extremely stringent requirements on the



magnetic field uniformity and quality in the final device. Careful attention must be paid at each step in the construction to ensure that the final-assembled, magnetically-tuned undulator meets all requirements. Similar devices were constructed and tuned for the Advanced Photon Source and other light-source facilities; however, some of the precision and stability requirements for the LCLS devices far exceed those for existing undulators.

If these requirements are not met, or if the devices are not stable enough over time, then the desired interaction between the radiation produced in the undulator and the electron beam will not take place, and the free-electron laser will not function.

The Magnet Poles are the magnetic components that determine the magnetic field configuration by concentrating and directing the magnetic flux from the permanent magnets in each of the magnet arrays. The parts shall be made out of bars of Vanadium Permendur, and machined to final size per ANL drawings L143-110105, "Undulator Unit Assembly, Magnet Structure, Pole," and L143-110107, "Undulator Unit Assembly, Magnet Structure, Last Pole."

2.2 Delivery.

The LCLS Undulator Magnet Poles described in this Statement of Work shall be delivered in five lots. They shall be delivered no later than the times indicated on the following schedule, which are in weeks after award of contract:

| <u>Lot</u> | <u>Quantity of L143-110105</u> | <u>Quantity of L143-110107</u> | <u>Weeks After Award</u> |
|------------|------------------------------------|------------------------------------|------------------------------|
| 1 | 950 | 10 | 15 |
| 2 | 3806 | 34 | 21 |
| 3 | 4758 | 42 | 31 |
| 4 | 4758 | 42 | 41 |
| 5 | 4758 | 42 | 51 |

Each Magnet Pole shall be identified in such a way that it can be correlated to the proper purchase order, ANL drawing number, and descriptive title as listed above in Section 2.1. Each Magnet Pole shall be marked with a unique serial number and that serial number shall be used on all records of test and measurement data and certifications relating to that Pole.



2.3 First Article.

The contractor shall deliver one First-Article lot of 960 Magnet Poles, 950 per L143-110105 and 10 per L143-110107, no later than 15 weeks after the contract has been awarded. The Contractor shall not proceed with the remainder of the contract unless and until the First Article lot is accepted.

3.0 APPLICABLE DOCUMENTS AND /OR SPECIFICATIONS:

The contractor effort shall be in conformance with the following referenced documents, drawings, and specifications.

- 1) Undulator Magnet Pole drawing L143-110105, "Undulator Unit Assembly, Magnet Structure, Pole"
- 2) Undulator Magnet Last Pole drawing L143-110107, "Undulator Unit Assembly, Magnet Structure, Last Pole"
- 3) ASTM A801 "Standard Specification for Wrought Iron-Cobalt High Magnetic Saturation Alloys UNS R30005 and K92650"

4.0 TECHNICAL TASKS AND QUALITY ASSURANCE:

4.1 Fabrication.

The contractor shall furnish all materials, personnel, facilities, tools, equipment, and services to fabricate, test, document and deliver the Magnet Poles, part no. L143-110105 and part no. L143-110107 listed in Section 2.1 of this Statement of Work.

4.1.1 Materials.

The Magnet Poles shall cut from bars of ASTM A801, Type 1 material commonly called Vanadium Permendur, Hiperco 50, or Vacoflux 50. The material composition must be certified by the Contractor.



4.1.2 Annealing.

The finished Magnet Poles must be annealed in a vacuum or inert gas furnace for maximum magnetic permeability after final machining.

4.1.2.1 The annealing schedule shall be according to ASTM A801 or the material supplier's recommended schedule for obtaining maximum magnetic permeability.

4.1.2.2 The contractor shall certify for each lot of Magnet Poles that the machined parts were annealed according to AMS-A801, or a specified material supplier's annealing schedule. Copies of the part temperature profiles during the annealing processes shall be included with the Certifications. The data should be complete enough to demonstrate compliance with both the time-temperature profile and the temperature uniformity requirements of the applicable specification.

4.1.3 Marking.

Each Magnet Pole shall be etched or laser marked with a unique 5-digit numeric serial number on the bottom (6 mm x 44 mm) surface, in the middle between the two tapped holes. A serial number shall be assigned to each Magnet Pole to distinguish it from the other Poles, so that accompanying documents and data can be correctly correlated to each individual Pole.

Each Magnet Pole shall be bagged and the bag labeled for identification with the pole's unique serial number, ANL Part Number (L143-110105 or L143-110107) and Revision Number, and its SLAC number (PF-381-000-32 or PF-381-000-94). The ANL and SLAC numbers are on the corresponding part drawing.

All these identifying marks are to be written or typed on a label, and each pole shall be bagged and the bag shall have this label. The label shall have three lines.

- a) The first line shall be the ANL Part Number-Revision Number (ANL Part No. L143-110105-00).
- b) The second line shall be the SLAC Part Number (PF-381-000-32).
- c) The third line shall be the unique serial number for the particular Magnet Pole (Serial No. 00001).



The information in brackets are examples of the information to be typed on the Magnet Pole label, the actual revision and serial numbers shall be whatever is applicable to the part being bagged and tagged.

4.1.4 Packaging and Shipping.

The Magnet Poles shall be appropriately packaged to protect them from shipping damage. No nicks, dents or scratches are acceptable.

Shipment of the Magnet Poles shall be FOB the docks of the designated Undulator Assembly Contractor (see Section 5.3). If the undulator assembly contracts are not in place at the scheduled delivery time for a lot of Magnet Poles, the contractor shall store the finished Poles until Argonne National Laboratory confirms the shipping destination. A monthly storage rate shall be included in the bid for this task that would be effective only if storage is required for a lot after the shipment date specified for that lot in Section 2.2.

4.2 Program Plan.

The contractor shall prepare and maintain a Program Plan describing and scheduling all phases of this program. The Laboratory shall review and approve the Program Plan and all changes thereto prior to implementation by the contractor.

4.2.1 Program Plan General Description.

The program management plan describes the contractor's concept, plan, practice, and approach for accomplishing (managing and controlling) project tasks, management interfaces, time-phased relationships of tasks and program elements, and the criteria against which performance may be judged. The plan is to be used as the basis for organizing, administering, and measuring work. The plan, with its interrelated and referenced documents, shall include sufficient data to demonstrate the capability to accurately report schedule, and technical performance indicators. The plan shall also be used to explain variances, to describe corrective actions and decisions, and to indicate required recovery or expeditious efforts.



4.2.2 Program Plan Content.

The plan shall describe the programmatic and management structure along with the management tools, which shall be used by the contractor in performance of the contractual effort. The following shall be included:

4.2.2.1 A brief description of the program objectives, with a summary of requirements and specifications as well as a concise description of the hardware and associated components.

4.2.2.2 Summary schedules, which reflect a direct condensation of the master schedules, and which are suitable for management review.

4.2.2.3 A description of the organization for the management of the program, indicating the internal interfaces between management and other elements of the contractor's organization.

4.2.2.4 A key personnel list, portraying the contractor's key personnel, beginning with the highest level program manager (or equivalent position) descending to the lowest echelon of key staff positions necessary for effective program management.

4.2.2.5 A description of the contractor's plan for interfacing with the Laboratory and with associated contractors, as well as technical management.

4.2.2.6 A description of the contractor's management information system as applied to the data management, configuration management, and schedule management function of this contract.

4.2.2.7 Copies of the Work Breakdown Structure (if applicable).

4.2.2.8 A subcontractor plan which includes the method of procurement, procurement schedules, and procedures by which control shall be exercised for planned subcontract effort (if applicable).



ARGONNE NATIONAL LABORATORY

L143-00031

Title: Statement Of Work For LCLS Undulator Magnet Poles

Rev.
02

Approved

Date

Page 7 of 16

4.2.2.9 A description of the contractor's resources being used in performance of the program, including plant capacity, facilities, machine tools, and manpower for all contract phases including fabrication.

4.2.2.10 A description of program tasks to be accomplished and a general outline of the methods and systems, which the contractor shall utilize to accomplish each major task.

4.2.3 Program Plan Format.

The contractor's own format shall be satisfactory. Contents should be displayed in sections for ease of separate consideration.

4.2.4 Program Plan Maintenance.

The plan shall be maintained current by page revision or complete reissue to reflect all approved program changes. Change to the key personnel list, consistent with the standard Terms and Conditions Clause, shall be forwarded to the Laboratory as soon as practical after the decision to make a change, and not later than the next scheduled progress report.

4.3 Program Meetings.

The contractor shall provide for program meetings with Laboratory representatives for purposes of reviewing and resolving progress, fabrication, testing, and managerial issues. Meetings will be held at the discretion of either the Laboratory or the contractor. Current information on all aspects of the program shall be made available by the contractor to the Laboratory one week in advance. Meetings shall be held at the contractor's facility, unless the Laboratory chooses otherwise. A mandatory notice and meeting agenda will be provided by the Laboratory one week before a program meeting can be held. The contractor shall have the responsibility to provide minutes of the meeting within two (2) weeks following the session.



4.4 Program Schedule.

The contractor shall prepare and maintain a Program Schedule. This schedule shall include the major program milestones. The Laboratory shall review and approve the Program Schedule and all changes thereto prior to implementation by the contractor.

4.4.1 Program Schedule General Description.

The program schedules depict the period of performance for work specified by the contract. They portray significant program/project milestones necessary to measure, analyze, and perform corrective action as well as indicate progress and performance.

4.4.2 Program Schedule Content.

In addition to major milestones required by the Laboratory and stipulated by the Statement of Work, the schedules shall also include where applicable:

4.4.2.1 Major milestones which depict program baselines, phase start and completion, go/no-go decision points, design and inspection reviews, delivery dates, etc.

4.4.2.2 Second level milestones which include long-lead procurement, intermediate design, manufacturing, and procurement points, development milestones and interfacing points, intermediate test and analysis points, etc.

4.4.2.3 Third level milestones which include all detail control milestones that govern the preparation of work package schedules.

4.4.3 Program Schedule Format.

The schedules shall be compatible with the Program Plans. They shall be susceptible to conversion and delineation at the detailed level to critical path schedules or other detailed scheduling techniques, which may be used for fabrication and test sequences.



4.4.4 Program Schedule Maintenance.

The schedules shall denote the most recent actual results compared with the forecasted progress. When major deviations between actual results and the baseline persist to the extent that the baseline becomes of little or no value for measuring and forecasting, the contractor shall change the appropriate parts of the baseline, subject to the following:

4.4.4.1 Changes shall be announced and described in the progress report for the period in which the change is made. Reasons for the change shall be described as well as the related effects on the work packages, and/or manufacturing schedules.

4.4.4.2 Schedule changes to (or affecting) Laboratory milestones shall be approved by Argonne prior to implementation.

4.5 Testing.

The contractor shall conduct testing of the Magnet Poles prior to delivery and acceptance by the Laboratory. Acceptance tests shall be in accordance with Section **4.5.1** of this Statement of Work. Certified test results shall be submitted by the contractor to the Laboratory within two weeks after conclusion of the test. Each shipment shall be accompanied or preceded by reports of actual test results identifiable to the acceptance criteria of items submitted and shall meet the requirements of the contract document and applicable drawings and specifications. These reports shall contain the signature and title of the authorized contract representative of the agency performing the tests and shall be subject to review and acceptance by Supplier Quality Control. The data submitted shall also be transmitted in electronic PDF format directly to the responsible ANL Engineer. If requested, the contractor shall furnish additional electronic or paper copies to the Undulator Assembly Contractor (see Section 5.3).

4.5.1 Measurements.

The Magnet Poles shall be measured or otherwise tested by the contractor to verify all dimensions and other drawing requirements. While most dimensions may be reported as in conformance with the drawing, critical features shall be reported with the actual measured values and with the drawing required value or tolerance. Any non-conforming dimension or feature must be reported with the measured value and the required value or



tolerance. All dimensions apply at a temperature of 20°C. The part must be in thermal equilibrium during measurements and at the same temperature at the beginning and conclusion of the measurements within 2°C. The part temperature before and after dimensional measurement shall be recorded and reported.

4.5.2 Critical Features.

The following items are critical features needing actual measured values to be reported.

- 1) Height of the Pole (48.00 +0.00 -0.01).
- 2) Flatness of the bottom of the Pole, Datum -A- (0.01).
- 3) Thickness of the Pole (6.00 +0.00 -0.05).
- 4) Perpendicularity of each side to Datum -A- (0.01).
- 5) Distance on the bottom of the part of the two (2) tapped holes' centerline to side of Pole (3.00 ±0.05).

4.6 Special Tooling.

The contractor shall design and fabricate any special tooling required for fabrication of the Magnet Poles listed in Section 2.1 of this Statement of Work, which is not provided by the Laboratory. All special tooling fabricated by the contractor is the property of the Laboratory and shall be accounted for by the contractor. Disposition of the special tooling at the conclusion of contract shall be at the option of the Laboratory in accord with FAR clause 52.245-17.

4.7 Quality Control.

The contractor shall adhere to all quality control requirements as specified in this Statement of Work. The contractor shall adhere to the ANL policy that prohibits the use of any suspect or counterfeit parts.

4.7.1 First-Article Inspection.

A first-article inspection shall be performed in the presence of a designated representative of ANL. The first-article inspection shall be accomplished using the first deliverable



item of several of the same design or same type. The processes used and standards of workmanship shall as a minimum be representative of all items to be produced. The supplier shall notify the Laboratory Procurement Official at least seven (7) days prior to the time that the first-article is available for inspection. Unless otherwise designated by the Laboratory Procurement Official, first-article inspection will be conducted at the supplier's facility. The First Article Inspection shall consist, as a minimum, witnessing the verification of critical dimensions, reviewing Q/A documentation and material certification. Continued fabrication of additional items prior to notification of first-article acceptance shall be entirely at supplier's risk, and may result in non-reimbursement of related costs by the Laboratory.

4.7.2 Changes Proposed by Contractor.

Prior to effecting any change in ANL approved (1) design, (2) workmanship standards, or (3) manufacturing process for use in this procurement, supplier shall obtain the Laboratory's written approval. Such changes must be documented by the contractor as "marked drawing" changes to the engineering drawings for the affected item prior to the Laboratory's approval. If approved by the Laboratory, revised drawings shall be issued by the contractor.

4.7.3 Proprietary Designs and Processes.

The contractor shall notify ANL prior to effecting any change in proprietary processing or design. A meeting between the supplier, the Laboratory Procurement Official and LCLS Quality Assurance shall be called to determine the method by which contract requirements will be met while accommodating the contractor's proposed change.

4.8 Inspection and Test Plan.

The contractor shall prepare and maintain an Inspection and Test Plan. The contractor shall submit to the Laboratory Procurement Official for written approval by LCLS Quality Assurance prior to its required use, a plan, in the contractor's format, listing components, and identifying those inspections and tests planned for verification of quality and identifying documentation/planning to be used for such accomplishment.



4.9 Quality Assurance.

The contractor shall prepare and maintain a Quality Verification Program for control of quality of articles furnished in accordance with this contract. A plan shall be prepared and submitted to the Laboratory Procurement Official for written approval by LCLS Quality Assurance prior to its required use by the contractor. The contractor's quality assurance manual may suffice providing it adequately implements the quality requirements specified.

4.10 Source Inspection.

The Laboratory reserves the right to perform source inspection of any and all materials, parts, subassemblies and assemblies required for performance of this contract.

4.11 Testing Surveillance.

The Laboratory reserves the right to witness any testing accomplished by the contractor. This surveillance will be informal except for final acceptance tests. The contractor shall notify the Laboratory two (2) weeks prior to the conduct of any test.

4.12 Test Failures.

The Laboratory shall be notified by the contractor within 48 hours after the failure of any material to meet the requirements of acceptance or qualification testing. The Laboratory shall be notified immediately of any failure occurring during assembly or acceptance testing of the Magnet Poles.

4.13 Red Flag Notice.

The contractor shall immediately notify the Laboratory of any occurrence, which will impact contract schedule. The notification shall be either written or oral with written confirmation within 48 hours on a Red Flag Report, and shall include remedial action taken to offset the problem. The contractor shall provide his own format compatible with the following requirements:

**4.13.1 Date and Number.**

Each Red Flag Notice is to be dated and consecutively numbered.

4.13.2 Contract Required Delivery Date.

Contract delivery date for the subject of the report. It does not normally change from one report to the next.

4.13.3 Estimated Shipping Dates.

Include the prior Report estimate and this Report estimate.

4.13.4 Statement of Problem.

All problems shall be presented as separate items in clear concise text describing the reason why the end item is late, the reason for any slippage since the last report and the current status of the work.

4.13.5 Consequence.

The consequence of the problem or delay shall be concisely stated in terms of impact on delivery, the meeting of key milestones, the progress of other work, or on meeting specification requirements, etc.

4.13.6 Action Taken.

The action being taken to resolve the problem and recover schedule delays shall be described and the estimated effect of this action shall be highlighted. The name of the key individual in the contractor's organization who must act to resolve the problem shall be shown.

**4.13.7 Action Required.**

Future action to recover schedule shall be identified. The action shall be described, the action party identified by name, title and organization, and the date when completion of the action is required shall be set forth.

4.13.8 Assistance Required.

Any assistance required from the Laboratory to further the progress of the recovery program shall be set forth. The exact nature of any required assistance shall be stated and the date by which such action must be taken shall be provided.

4.13.9 Number of Times Reported.

The number of previous critical items reports which have identified the same problem as critical to the progress of the work or to satisfaction of the technical requirements shall be set forth.

4.13.10 Acknowledgement of Responsibility.

Each report shall acknowledge that the reporting of the critical items therein does not relieve the writer of responsibility for seeing that the necessary corrective action is taken on each item.

4.14 Nonconformance Reporting.

The contractor shall report any non-conformances to specifications, drawings, or other contract requirements on ANL Form 311.

4.15 Approvals.

All Laboratory approvals required by this contract shall be acted upon within two (2) weeks of receipt by ANL of submission by the contractor. Action will consist of a notice of approval, clarification request or rejection in writing from the Laboratory Subcontract Administrator. Approvals shall not relieve the contractor of any responsibility for reliability, quality, delivery, cost, performance or other requirements of this contract.



5.0 REPORTS, DATA, AND DELIVERABLES:

5.1 Progress Report.

The contractor shall submit monthly progress reports during the execution of this program. The progress report shall include narrative and tabular summary of performance during the report period. It shall include work performed, work forecast, and problem description and resolution. The contractor shall emphasize any deviations from plan or schedule, the reasons and impacts of such deviations, and the effects of management efforts undertaken for corrective or expeditious actions.

5.2 Technical Data.

The contractor shall deliver all technical data as specified below.

5.2.1 For each of the following items, one (1) electronic copy in PDF format followed by two (2) paper copies are required once 30 days after award of contract. Any changes to these documents must also be submitted.

- a) Program Plan (Section 4.2)
- b) Program Schedule (Section 4.4)
- c) Inspection and Test Plan (Section 4.8)
- d) Quality Verification Plan (Section 4.9)

5.2.2 For Progress Reports (Section 5.1), one (1) electronic copy in PDF format followed by two (2) paper copies are required monthly 10 days after the end of the month. The first report shall be due 40 days after award of contract.

5.2.3 For Test results, Measured values and Certifications (Sections 4.1.1, 4.1.2.2, and 4.5), one (1) electronic copy in PDF format followed by two (2) paper copies are required for ANL and either one (1) set of electronic or paper copies for the Undulator Assembly Contractor is required within two (2) weeks of completion of testing of a given lot of Magnet Poles.



ARGONNE NATIONAL LABORATORY

L143-00031

Title: Statement Of Work For LCLS Undulator Magnet Poles

Rev.
02

Approved

Date

Page 16 of 16

5.2.4 For each of the following items, one (1) electronic copy in PDF format followed by two (2) paper copies are required. These items are on an “as required” basis.

- a) Red Flag Notice (Section 4.13), submit within 48 hours of an occurrence.
- b) Nonconformance Report (Section 4.14), ANL approval required for disposition of a non-conformance.
- c) Program Meeting Minutes (Section 4.3), submit within 2 weeks of a Program Meeting.

5.3 Delivery.

The contractor shall deliver the Magnet Poles listed in Section 2.1 of this Statement of Work per the schedule indicated in Section 2.2 of this Statement of Work. The Magnet Poles are to be delivered to the Undulator assembly Contractor and not directly to Argonne. It is likely that two assembly Contractors will be selected and delivery of each lot shall be split equally between the two (2) Contractors unless otherwise instructed by ANL. It is possible that the assembly contracts will not be in place at the scheduled delivery time, in which case the finished Magnet Poles are to be stored until Argonne National Laboratory confirms the shipping destination.

6.0 OTHER SPECIAL CONSIDERATIONS:

6.1 Subcontractors.

Should the contractor intend to subcontract any portion of this work, such intentions, possible subcontractors, and the scope of their involvement shall be included in the proposal. ANL is to be informed of any change in subcontractors prior to any such change taking effect. ANL reserves the right to reject the use of any particular subcontractor.

6.2 Disclosure and Publication.

Dissemination of data and key results of the contracted effort is encouraged through the use of technical meetings, literature, and the like. The contractor shall obtain Laboratory approval prior to disclosure or publication of any information.