

UNIVERSAL PROCUREMENT PROCESS OVERVIEW							
PHASE	PROCESSES, DELIVERABLES AND MILESTONES (Abbreviations are listed at the end of the table)	STARTING POINT	MAXIMUM DURATION/DEADLINE	MAXIMUM TIME FOR DECISION BY THE BUYER	REJECTION CONSEQUENCES (Abbreviations are listed at the end of the table)	POSSIBLE CONTRACTUAL PENALTIES*	DELIVERY FORMAT**
0	<b>Ordering and accepting VV basic configuration</b>  <b>Advance payment no. 1*</b> 10 % of the Purchase price for the Vacuum Vessel basic configuration excl. VAT (i.e. price of the Item No.1 as defined in Annex No. 3 - Price Schedule and Deliverables) after the Seller's acceptance of the Order of Vacuum Vessel basic configuration (or when the Order is deemed accepted)	Signing the contract	4 weeks	-	-	-	-
1	<b>Preparation phase</b>						
1.1	<b>Production and engineering documentation - group no. 1</b> (definition of the group no. 1: see either sheet Procurement General Time Plan, or TS, end of the chapter 3) Providing first version of the documentation including only the group no. 1  <b>Bill of raw material - group no. 1</b> Providing an updated list of raw material foreseen for manufacturing group no. 1 and corresponding preliminary version of MTC  <b>General testing plan - group no. 1</b> Providing first version of general testing plan  <b>Manufacturing plan - group no. 1</b> Providing first version of manufacturing plan  <b>Advance payment no. 2*</b> 20 % of the Purchase price for the Vacuum Vessel basic configuration excl. VAT (i.e. price of the Item No.1 as defined in Annex No. 3 - Price Schedule and Deliverables) after the <b>Production and engineering documentation - group no. 1</b> (i.e. the Framework Purchase Agreement milestone (A)) is approved by the Buyer according to the criteria defined in the Technical Specification.  <b>Partial payment no. 1*</b> 5 % of the Purchase price of the Vacuum Vessel basic configuration excl. VAT (i.e. price of the Item No.1 as defined in Annex No. 3 - Price Schedule and Deliverables) after the Production and engineering documentation - group no. 1 is submitted and approved (see the Framework Purchase Agreement).	Ordering BC (other items in the group 1 could be ordered with delay with respect to BC)	17 weeks	3 weeks	<b>Manufacturing is not allowed to start until the full phase 1.1 is fully approved</b> Rework the documentation and submit for approval to Buyer (2 weeks)  <b>Bill of raw material shall be approved separately</b> If approved, the ordering of the raw material is allowed.	<b>In case of rejection of the Production and engineering documentation - group no. 1</b> "Advance payment no. 2" is not paid until the Seller fulfill all requirements of the Technical specification.  <b>If the Production and engineering documentation - group no. 1 is not submitted and approved on time according to the Technical specification, penalty applies.</b>	Internet
1.2	<b>Handover</b> Signing of handover document " <b>Handover Protocol of the Production and engineering documentation - group no. 1</b> ".	Approval of the Production and engineering documentation - group no. 1	N/A	N/A	-	<b>In case the phase 1.1 is not finished on time</b> (see chapter 9.4 of the Technical specification)	Internet CD paper

1.3	<b>Production and engineering documentation - group no. 2</b> (definition of the group no. 2: see either sheet Procurement General Time Plan, or TS, end of the chapter 3) Providing an updated version of the documentation including the first version for group no. 2 and updated documentation for group no. 1 (if needed)	Ordering all items within the group is finished	8 weeks	2 weeks	<b>Manufacturing of the group no. 2 is not allowed to start until the full phase 1.3 is fully approved</b> Rework the documentation within 1 month and submit for approval to Buyer (2 weeks)  <b>Bill of raw material shall be approved separately</b> If approved, the ordering of the raw material is allowed.	-	Internet
	<b>Bill of raw material - group no. 2</b> Providing list of raw material foreseen for manufacturing group no. 2 and corresponding preliminary version of MTC						
	<b>General testing plan - group no. 2</b> Providing an update of the general testing plan						
	<b>Manufacturing plan - group no. 2</b> Providing an update of manufacturing plan						

Ordering material of given group starts when the bill of raw material of the given phase is approved (1.1 or 1.3)  
Documentation of phase 1 should be provided by the Seller (at latest 2 weeks from end of phase 1)

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2	<b>Raw material acceptance phase</b>						
2.1	<b>Bill of raw material</b> Updating the bill of raw material including the final version of MTCs for each ordered batch of material	Receiving material	2 weeks	2 weeks	<b>Testing not allowed and reorder of material is necessary</b> Reorder the material as required from the Buyer and submit to the Buyer (2 weeks from receiving material). The Buyer has 2 weeks for approval.	-	Internet
2.2a	<b>General testing plan - Raw material sample testing</b> Updating the general testing plan for the raw material sample part	N/A	Up to 2 weeks before starting phase 2.2b	2 weeks	<b>Testing of the material batch not allowed</b> Rework the plan within 1 week and submit for approval to the Buyer (2 weeks)  <b>Manufacturing is not allowed to start</b> <u>If failure of tests (wrong testing procedure):</u> Start over phase 2.2 for rejected batches of material and redo the tests  <u>If material failure (wrong material):</u> Reorder material and start over phase 2 for rejected batches of material	-	Internet
	<b>General testing results - Raw material sample testing</b> Testing each batch of raw material and providing summary documentation and samples (output)	Approval of phases 2.1 and 2.2a	4 weeks	2 weeks		-	Internet Specimen
2.2b	<b>Partial payment no. 2*</b> 100% of the purchase price for the raw material for the " <b>Vacuum vessel main body weldment</b> " excl. VAT after the Seller proves that all ordered raw material for the production has been delivered to the Seller and successfully tested and approved by the Buyer. As a proof the documentation of the delivered material and tests results are considered unless the parties agree otherwise. <b>Advance payment no. 3*</b> 20 % of the purchase price for the Vacuum Vessel basic configuration excl. VAT (i.e. price of the Item No.1 as defined in Annex No. 3 - Price Schedule and Deliverables).						

Manufacturing of each group starts from approval of phases 1 and 2 for each group  
Approved documentation of phase 2 should be provided by the Seller (at latest 2 weeks from end of phase 2)

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3	<b>Manufacturing phase</b>						
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3.1	<p><b>Production and engineering documentation</b> Updating the production and engineering documentation (phase 1) for each group (also includes post-processing documentation)</p> <p><b>General testing plan</b> Updating general testing plan for the MIC phase, including prototyping, welding and post processing plans (if ordered)</p> <p><b>Manufacturing plan</b> Updating manufacturing plan</p>	Approval of phases 1 and 2 for each group	2 weeks	3 weeks	<p><b>Phase 3.3 is not allowed to start</b> Rework the plan within 1 week and submit for approval to the Buyer (2 weeks).</p>	-	Internet
3.2a	<p><b>General testing plan - Welding on prototypes</b> Updating the general testing plan for the welding procedure on prototypes</p>	N/A	Up to 2 weeks before starting phase 3.2b	2 weeks	<p><b>Welding on prototypes is not allowed to start</b> Rework the plan within 1 week and submit for approval to the Buyer (2 weeks).</p> <p><b>Welding of the VV assembly is not allowed to start</b></p>	-	Internet
3.2b	<p><b>General testing results - Welding on prototypes</b> Realizing welding tests on prototypes and providing summary documentation, prototypes and samples (output)</p>	Approval of phase 3.2a	4 weeks	2 weeks	<p><u>If failure of welder or equipment:</u> Start over phase 3.2 for rejected welding prototypes</p> <p><u>If failure of welding technology:</u> Propose different welding technology and start over phases 3.1 and 3.2</p>	-	Internet Specimen
3.3a	<p><b>Manufacturing plan - Welding of the VV assembly</b> Providing a planning of the manufacturing procedure of the VV assembly, including camera surveillance operation plan</p> <p><b>General testing plan - MIC</b> Updating the general testing plan for the manufacturing, dimensional inspection and surface properties checks of the welding of the VV assembly</p> <p><b>General testing results - MIC</b> Welding the VV assembly, realizing checks of the manufacturing, key dimensions and surface properties and providing summary documentation (output)</p>	N/A	Up to 3 weeks before starting phase 3.3b	3 weeks	<p><b>Welding and manufacturing of the VV assembly is not allowed to start</b> Rework the plan within 1 week and submit for approval to the Buyer (2 weeks)</p> <p><b>Post processing (if ordered) and FAT are not allowed to start</b></p>	-	Internet
3.3b	<p><b>Weld map</b> Providing an overview of realized individual welding seams of the VV assembly</p> <p><b>Camera surveillance</b> Recording manufacturing with camera surveillance system and storing the result data</p>	Approval of phases 3.2 and 3.3a	Up to 2 weeks after finishing the welding and checks	3 weeks	<p><u>If failure of welder or equipment:</u> Start over phase 3.3 - repair or rework related areas</p> <p><u>If any of checks reveals exceeding required key parameters:</u> Start over phase 3.3 - repair or rework related areas</p>	<b>If surveillance is not possible or accessible.</b>	Internet
3.4a	<p><b>General testing plan - Post processing of prototypes (if ordered)</b> Updating the general testing plan for the post processing procedure on prototypes</p>	N/A	Up to 2 weeks before starting phase 3.4b	2 weeks	<p><b>Post processing of the prototypes is not allowed to start</b> Rework the plan within 1 week and submit for approval to the Buyer (2 weeks).</p> <p><b>Post processing of the VV assembly is not allowed to start</b></p>	-	Internet
3.4b	<p><b>General testing results - Post processing of prototypes (if ordered)</b> Performing the post processing of the prototypes, realizing checks and providing summary documentation and prototypes (output)</p>	Approval of phased 3.4a	4 weeks	2 weeks	<p><u>If failure of post processing technology or parameters:</u> Propose different technology or parameters and start over phase 3.4</p>	-	Internet Specimen

3.5a	<b>General testing plan - Post processing of the VV assembly (if ordered)</b> Updating the general testing plan for the post processing procedure on the VV assembly	N/A	Up to 2 weeks before starting phase 3.5b	2 weeks	<b>Post processing of the VV assembly is not allowed to start</b> Rework the plan within 1 week and submit for approval to the Buyer (2 weeks).	-	Internet
3.5b	<b>General testing results - Post processing of the VV assembly (if ordered)</b> Performing the post processing of the VV assembly, realizing checks and providing summary documentation (output)	Approval of phase 3.4	Up to 2 weeks after finishing the process	2 weeks	<b>FAT are not allowed to start</b> Repair or rework related areas if possible	-	
3.6	<b>Handover</b> Signing of handover document " <i>Handover Protocol of the Manufacturing phase</i> ".	Approval of phase 3	N/A	N/A	-	<b>In case the phase 3 is not finished on time acc. to provided manufacturing plan in phases 3.1 and 3.3a</b>	Internet CD paper
<b>The Seller informs the Buyer 2 months in advance before starting FAT Approved documentation of the phase 3 shall be provided by the Seller and approved by the Buyer (at the latest 2 weeks from end of the phase 3) - Framework Purchase Agreement milestone B</b>						<b>In case the phase 3 is not finished on time acc. to provided manufacturing plan in phases 3.1 and 3.3a</b>	<b>CD</b>

4	<b>Factory Acceptance Tests (FAT) phase</b>						
4.1	<b>Production and engineering documentation</b> Providing an updated version of the production and engineering documentation for all groups  <b>FAT plan</b> Providing complete planning for realization of FAT	Approval of the documentation of the whole phase 3	Up to 2 weeks before the FAT	2 weeks	<b>FAT is not allowed to start</b> Rework the documentation within 1 month and submit for approval to Buyer (2 weeks)	-	Internet
4.2	<b>FAT results</b> Performing FAT and providing summary documentation (output). FAT include: * Dimensional inspection, 3D spatial scan, non-destructive tests, surface roughness measurements * Vacuum leak tests (note that a presence of the Buyer at leak testing is required, otherwise tests cannot be started) * pressure test (heating / cooling system), vacuum cleanliness test * Jigs & tools checks and demonstration	Approval of phase 4.1	N/A	decided instantly / 2weeks	<b>Transportation to Buyer's site is not allowed to start</b> <u>If not fulfilling key requirements:</u> Start over from phase 3 and redo relevant phases (relevant FAT must be repeated)	-	Internet
4.3	<b>Complete documentation</b> Providing first version of complete documentation, including, in particular, the instructions for transport and maintenance	Execution of FAT	2 weeks	2 weeks	<b>Transportation and SAT can not be executed.</b> Rework the documentation within 2 weeks and submit for approval to Buyer (2 weeks)		Internet CD
<b>Transportation starts when the whole phase 4 is approved and the document "<i>Transport Permission</i>" is signed by the Buyer.</b>							

5	<b>Site Acceptance Tests (SAT) phase</b>						
5.1	<b>Production and engineering documentation</b> Providing the final version of the production and engineering documentation for all groups  <b>SAT plan</b> Providing complete planning for realization of SAT	Approval of the documentation of the whole phase 4	Up to 2 weeks before the SAT	2 weeks	<b>SAT is not allowed to start</b> Rework the documentation within 1 month and submit for approval to Buyer (2 weeks)	-	Internet

5.2	<b>SAT results</b> Performing SAT and providing summary documentation (output). SAT include: * Visual inspection, Vacuum cleanliness test, Limited dimensional inspection, 3D psatial scan performed by the Buyer	Approval of phase 5.1	N/A	decided instantly / 2weeks	<b>Handover document cannot be signed</b> <b>If not fulfilling key requirements:</b> a) Defects must be eliminated on site b) Start over from phase 3 and redo relevant phases (relevant FAT/SAT checks must be repeated on agreement with Buyer)	Any exceeding of desired tolerances.  If removal of defects exceeds the total due time for delivery.	Internet
5.3	<b>Complete documentation</b> Providing the final version of complete documentation	Execution of SAT	2 weeks	2 weeks	<b>Handover document cannot be signed</b> Rework the documentation within 1 month and submit for approval to Buyer (2 weeks)		Internet CD paper
5.4	<b>Handover</b> Signing of handover document " <b>Handover Protocol of Acceptance</b> " and officially taking over of the ordered extent of delivery	Approval of phase 5.3	N/A	N/A	-	<b>Delay with handing over the VV basic configuration or any other item.</b>	Internet CD paper

**Final payment**

-	<b>Regular progress report</b> Providing regular progress report and plan	From phase 2	Regularly once per 2 weeks (1 week delay allowed), up to end of the phase 5	1 week	<b>Any production process could be put on hold</b> Comments and objections from the Buyer should be taken into account in the next version of the plan	<b>Missed meeting or minutes not delivered on time.</b>	Internet
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\* For more details see the Framework Purchase Agreement

\*\* For more details see the Technical Specification

Abbreviations	Definitions
VV Basic Configuration	Vacuum Vessel basic configuration - item no. 1
BC	VV Basic Configuration
Group 1	for definition see sheet "Procurement General Time Plan" in this excel file
Group 2	for definition see sheet "Procurement General Time Plan" in this excel file
Internet	Data transfer through the world wide web, e.g. email or data storage service...
CD	Portable physical data storage container, e.g. CD, DVD, flash drive...
Specimen	Physical sample of material or prototype
Paper	Physical copy, e.g. physically printed drawings
Production and engineering documentation - first version	Includes production and engineering drawings + Mill Test Certificates (MTC) + General plan for production and testing
Production and engineering documentation - final version	Includes production and engineering drawings + Mill Test Certificates (MTC) + Updated general plan for production and testing + documentation from SAT
VV assembly	BC including every selected item from the extent of delivery to be fix welded together
Rest of the extend of delivery	Here includes jigs & tools, blank flanges, stabilizer mecanism and VV supports
General plan for production and testing	It includes post processing as well - part of the production documentation
Bill of raw material	List of raw material that will be ordered
MIC	Manufacturing Interim Check
MTC	Mill Test CERTIFICATE