RF Tuner Inner Bus Assembly (PRFTA) 464161 Rev. C by Adam Bracero													
							Series	Serial No.	Job No.	Task No.	Released By	Released Date	Status
							PRFTA	PRFTA-IB-021- 0	508	2103A/2103A.2.1.6	Larry Mitcham	3/9/2016 2:34:35 PM	Closed

- 1.0 Abstract
- 2.0 General Notes
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- 4.0 Parts Kit List
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1.0 Abstract Top

1.1 This procedure/traveler is to be used to perform RF Tuner Inner Bus Assembly

2.0 General Notes Top

2.1 White (Lint Free) Gloves (Fermi stock 2250-1800) or Surgical Latex Gloves (Fermi stock 2250-2494) shall be worn by all personnel when handling all product parts after the parts have been prepared/cleaned.

- 2.2 All steps that require a sign-off shall include the Technician/Inspectors first initial and full last name.
- 2.3 All Discrepancy Reports issued shall be recorded in this traveler next to the applicable step.

3.0 <u>Supporting Documentation</u> <u>Top</u>

3.1 Inner Bus Assembly

F00394847 - Inner Bus Cooling Assembly F00496030 - Inner Bus Assembly Package

4.0 Parts Kit List Top

4.1 Attach the completed Parts Kit List to this traveler. Ensure that the serial number on the Parts Kit List matches the serial number on this traveler. Verify that the Parts Kit received is complete.

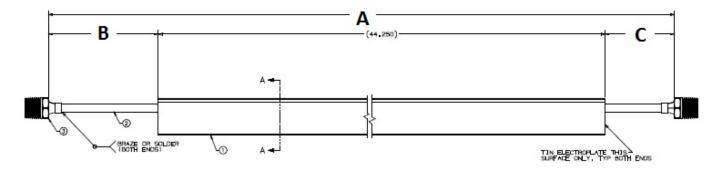
Parts Kit Template Parts Kit List: Link Process Engineering/Designee: Larry Mitcham

5.0 Inner Bus Assembly Top

Date: 3/25/2016

Reference Drawing: Inner Bus Package Assembly (F00496030)

5.1 Trim and hand braze fittings onto Inner Bus Bars per the Inner Buss Bar Cooling Assembly (F00394847).



Technician: Gerik Wysocki

5.2 Perform a hydrostatic/flow Test of all 10 assemblies. Hydro at 500 PSI for 10 minutes. Flow to be greater than 2.5GPM using 100 PSI Contact the Project Engineer if the test fails.

○ Fail

Note: Hydro test may be performed on subassemblies prior to tooling being available.

Pass

Inspector: Ryan Montiel

5.3 Electro-tin plate the ends of each Inner Bus Bar or use "silver paint": DeoxIT or Coolamp.

Technician: Kenneth Klotz

5.4 Wipe with alcohol after tin is applied. Clean plated area by removing brazing oxide, flux, and the electrolyte from the tinning process.

Technician: Kenneth Klotz

Technician: Sathapat Sukkert

5.6 Wrap 0.005" Kapton around each of the Inner Bar Bus Assemblies at the starting point as show in red below. Attach directly to Bus with 0.004" Kapton tape. Overlap Kapton, and tape end at location on picture below.

Date: 3/21/2016

Date: 3/15/2016

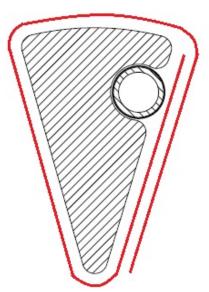
Date: 3/14/2016

Date: 3/21/2016

Date: 3/23/2016

^{5.5} Prepare Kapton: (11) 0.005" x 4" x 47.25".

Note: Tape shall extend beyond the ends of each bus by at least 1.5".

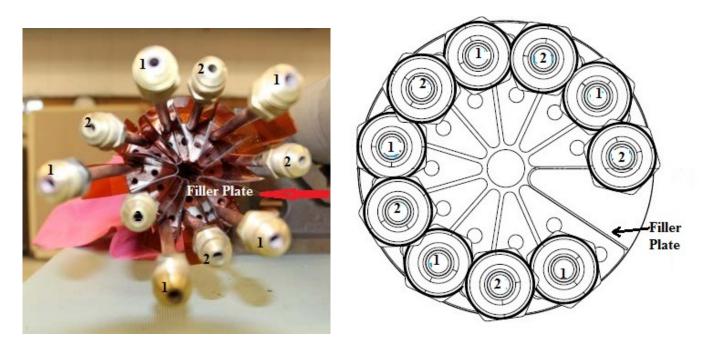




Technician: Sathapat Sukkert

Date: 3/24/2016

5.7 Assemble all the Inner Bus Bar Cooling Assemblies into the Inner Package Assembly (F00496030). Install each of the sub-assemblies and then install the Filler Plate (MB-394872) with (4) 3/8" dowel rods. Ensure the alignment of the ends of the bus bars is within 1/32".





1 - Inner Bus Bar Long (MD-394847 (5) 3 3/4" length 2 - Inner Bus Bar Short (MD-394846) (5) 2 1/2" length

Technician: Sathapat Sukkert

Date: 3/24/2016

5.8 Wrap entire assembly with 0.002" Kapton and overlap at least half of the entire assembly. Ensure wrapped diameter is less than 2.900" with Go/No-Go testing.

Technician: Sathapat Sukkert

Date: 3/24/2016

5.9 Verify the alignment of the bus bar ends are within 1/32".

Inspector: Ryan Montiel

6.0 Production Complete Top

6.1 Process Engineering verify that the Traveler is accurate and complete. This shall include a review of all steps to ensure that all operations have been completed and signed off. Ensure that all Discrepancy Reports, Nonconformance Reports, Repair/Rework Forms, Deviation Index and dispositions have been reviewed by the Responsible Authority for conformance before being approved.

Comments: *NONE*

Process Engineering/Designee: Larry Mitcham

Date: 5/9/2016

Date: 3/25/2016