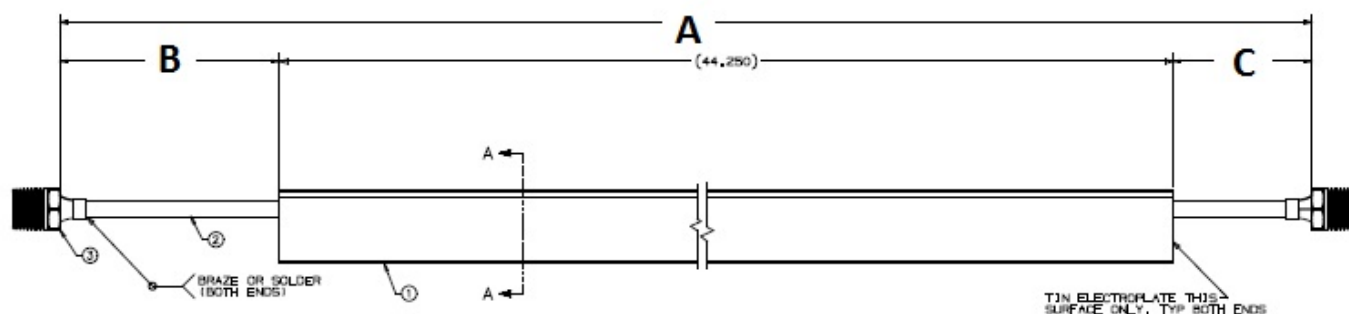




## Reference Drawing: Inner Bus Package Assembly (F00496030)

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



Technician: **Gerik Wysocki**

Date: **3/14/2016**

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.

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

☒ Pass

☐ Fail

Inspector: **Ryan Montiel**

Date: **3/15/2016**

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

Technician: **Kenneth Klotz**

Date: **3/21/2016**

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**

Date: **3/21/2016**

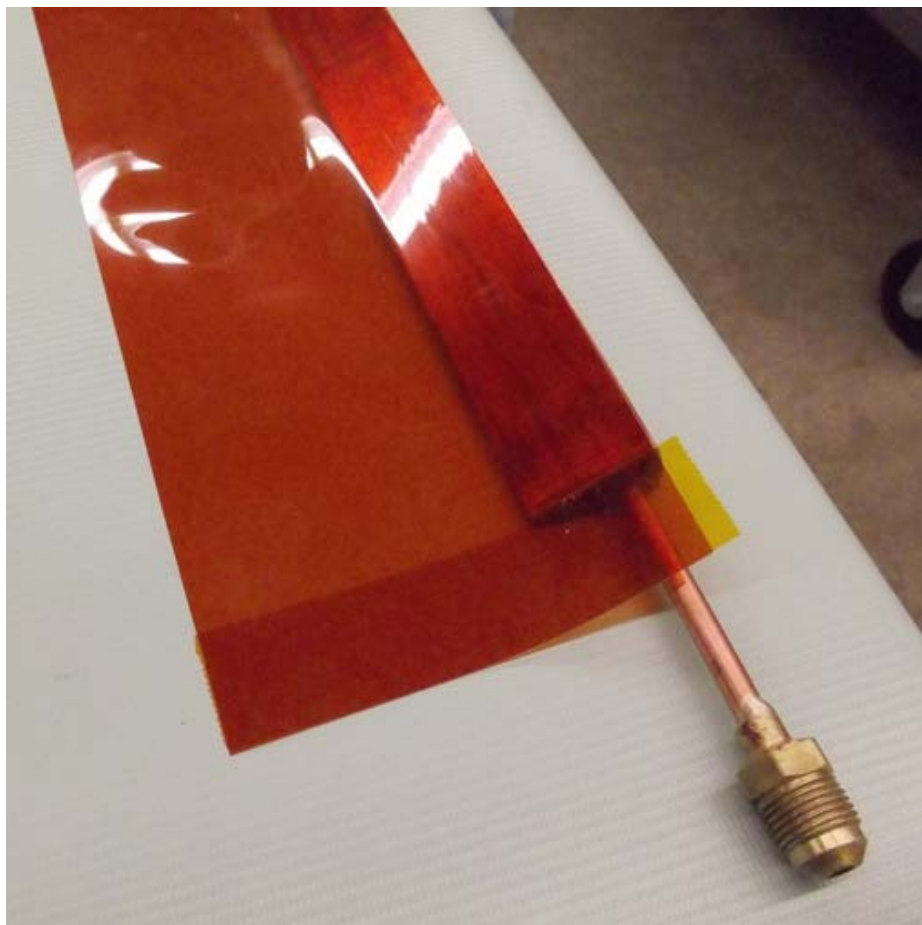
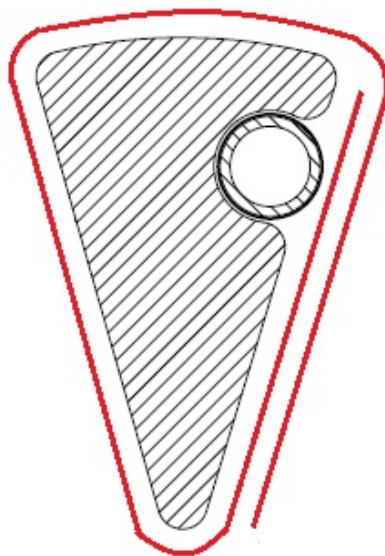
5.5 Prepare Kapton: (11) 0.005" x 4" x 47.25".

Technician: **Sathapat Sukkert**

Date: **3/23/2016**

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.

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

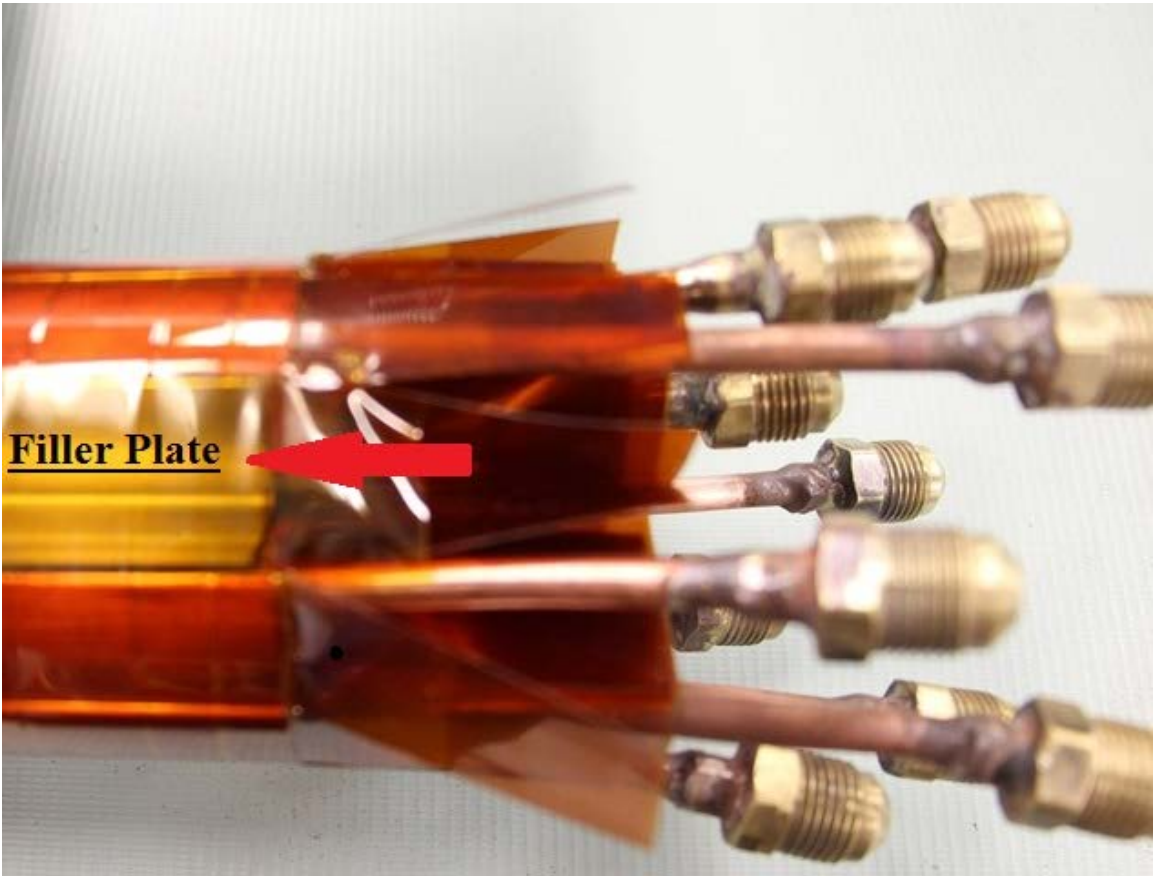
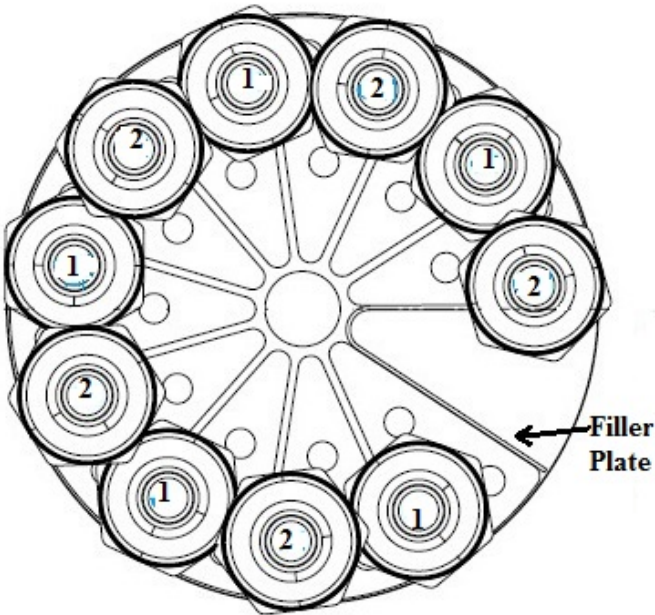
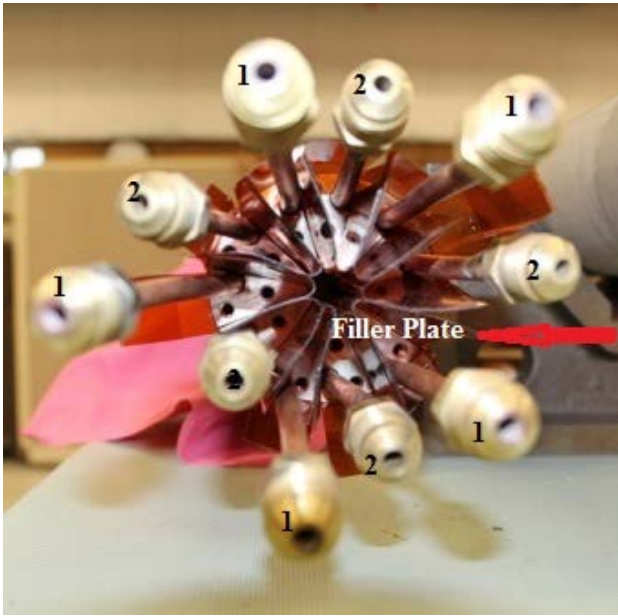


Technician: **Sathapat Sukkert**

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*

Date: *3/25/2016*

## 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*