

GENERAL TECHNOLOGY CORP.  
1450 MISSION AVENUE NE  
ALBUQUERQUE NM 87107  
FSCM 61666

SHIPPER  
SHIPPER NUMBER F17301.9  
SALES ORDER NUMBER F17301  
SHIP DATE 06/15/05  
PAGE 1

S 15356  
O SLAC  
L ACCOUNTS PAYABLE  
D 2575 SAND HILL RD M/S85  
MENLO PARK, CA 94025  
T  
O

B 15356  
I SLAC  
L ACCOUNTS PAYABLE  
L 2575 SAND HILL RD M/S85  
MENLO PARK, CA 94025  
T  
O

-----  
FOB: DEST TERMS: NET 30 DAYS FRT: PREPAID AND ADD

CUSTOMERS PO: 0000053627

RESALE.NO:

-----  
LI# ORDER/QTY UM PART/DESCRIPTION UNITS/PKG SHIP QTY LOT NO  
-----

Special Inspection is required.

1.1	12	EA	LAT-DS-01643 ASSY, UNIT-TEM/TPS S/N: GT113 GLAT1840. QTY DUE...: 8	52	1.00	1	131221
-----	----	----	---	----	------	---	--------

SHIP.VIA: UPSR  
WAYBILL#:

Certificate of Conformance

General Technology Corporation hereby certifies that all items in this shipment have been produced, inspected and found to be in compliance with all applicable customer/military specifications and standards, drawings and purchase order requirements. All documents utilized were to the latest revision in effect on the date of this order, and/or as specified by the buyer. Substantiating records are on file subject to review upon request.

*Sicilia Martiny* (Signature)  
Quality Assurance Signature  
6/15/05 (Date)

SHIP TO: SLAC  
2575 SAND HILL ROAD  
MENLO PARK, CA 94025

END-ITEM DATA PACKAGE – LAT-DS-01643; Serial Number: GT113 GLAT 1840

Fill in blanks ( ) with required information; and check block ( ) when complete ...

- ξ (a) Certificate of Compliance for each TEM/TPS LAT-DS-01643 assembly
- ξ (b) Copy of travelers for each comprising a TEM/TPS unit:

Top Level; TEM/TPS LAT-DS-01643 WO# 113232 ; S/N (above SN)

TPS Unit; LAT-DS-01482 WO# 113211 ; S/N GT111 GLAT1819

TPS CCA; LAT-DS-02388 WO# 112064 ; S/N GT111 GLAT1781

TPS O/P Cable; LAT-DS-02831-01 WO# 112044 ; S/N N/A

TPS I/P Cable; LAT-DS-02830-01 WO# 112043 ; S/N N/A

TEM Unit; LAT-DS-01481 WO# 113113 ; S/N GT112 GLAT 1801

TEM CCA; LAT-DS-01646 WO# 112012 ; S/N GT112 GLAT 1763

TEM I/P Cable; LAT-DS-02588 WO# 112026 ; S/N N/A

- ξ (c) Non-Conformance Reports (Indicate NCR # and applicable assy / part no.)

( N/A )

- ξ (d.1) AS-BUILT Drawing and Parts List Configuration Record

LAT-DS-01643; Rev No. (Dwg/PL - 53 )

LAT-DS-01481; Rev No. (Dwg/PL - 54 )

LAT-DS-01482; Rev No. (Dwg/PL - 55 )

LAT-DS-01646; Rev No. (Drawing - 56 )

LAT-TD-02230; Rev No. (PL - 54 )

LAT-DS-02388; Rev No. (Drawing - 58 )

LAT-TD-02391; Rev No. (PL - 56 )

LAT-DS-02830; Rev No. (Dwg/PL - 53 )

LAT-DS-02831; Rev No. (Dwg/PL - 52 )

LAT-DS-02588; Rev No. (Dwg/PL - 51 )

ξ (d.2) AS-BUILT Parts List (Work Order / Part-Lot number report)

- Top Level: TEM/TPS LAT-DS-01643
- TPS Unit: LAT-DS-01482
- TPS CCA: LAT-DS-02388
- TPS O/P Cable: LAT-DS-02831-01
- TPS I/P Cable: LAT-DS-02830-01
- TEM Unit: LAT-DS-01481
- TEM CCA: LAT-DS-01646
- TEM I/P Cable: LAT-DS-02588

ξ (e.1) SPEA Test Reports (TR generated only when defect noted – indicate TR #)

TR# vs. TEM CCA LAT-DS-01646: Test ID 24626

TR# vs. TPS CCA LAT-DS-02388: Test ID 23604

ξ (g) In-process Inspection Reports (Indicate report # and applicable assy number)

( LAT-DS-01646/29535 LAT-DS-02388/29626, 31721 LAT-DS-02830/29577 )

(h) Connector Mate/Demate logs (primarily SLAC - check for GTC logs)

ξ (i) Digital photos on CD ROM (final views, seven total, 2 Meg min.res.)

TEM CCA LAT-DS-01646 Bottom Side  Top Side

TPS CCA LAT-DS-02388 Bottom Side  Top Side

3/4 view of TEM LAT-DS-01481  3/4 view of TPS Unit LAT-DS-01482


3/4 view of TEM/TPS Unit LAT-DS-01643

Completed by: *Ericia Martinez*

Date: 6-15-05

GTC QA Acceptance: 

Date: 6-15-05

SLAC QAR Acceptance: 

Date: 6-17-05

WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NIK

PAGE 1

PNY/PNS LAT-DS-01643  
UNIT-DEM/TPS

WCS 010201  
REV DATE 08 06 05  
REV DATE 08 10 05  
PC# 0173071-05  
PC# 0100053627

CUST #  
QTY  
PROJECT# 017301  
CUST# 15301

-SERIAL NUMBER-----  
GT113 PLAT 1840

-----APPROVAL-----  
PROD: 415305  
Q/M 5.3.05

-WORKMANSHIP-----  
IPC/PIA-3-STD-0010 CLASS 3, WITH "CS" SPACE SUPPLEMENT  
SLAC CAR MAY CHOOSE TO AUDIT/OBSERVE PROCESS PERFORMANCE  
OF ANY STEP OF THE TRAVELER/WORK ORDER SLAC CAR MAY  
INDICATE OBSERVATIONS BY STAMP MARKING AT THE STEP.  
-gln 03.02 05-----

LI# DEPT MACH# OP# DESCRIPTION..... HOURS.....  
SET-UP RUN LINE-MACH ST-DOI



1 200 00 CONFIG RECORD/KITTING 0.0000 0.0000 0.0000  
CONFID

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
DOCUMENT NUMBER REV PD/PL OUTSTANDING ED'S  
AGGV DWG LAT-DS-01643 53 NONE  
BOM PL (SAME - ON DWG) NONE  
COP/SCW LAT-PS-02815/03078 01 NONE  
VISE/IC NOT APPLICABLE; WAS EX-252; SCW DELETED QTY DO  
ASSY AID LAT-DS-01643 (RELEASED PER ED 2478)  
CUSTOMER NAME: SLAC (STANFORD LINEAR ACCELERATOR CENTER)  
BUILD DOCUMENTS  
USE... WORK ORDER, CONTROLLED ASSEMBLY AID, & DRAWINGS  
\* SEE LAST PAGE OF WO (FOOTER) FOR TRAVELER REV/CHG RECORD \*

DATE... QTY... REMARKS..... STATUS  
5.3.05 \_\_\_\_\_ WCS



2 201 00 STOCKROOM/KITTING AREA 0.0000 0.0000 0.0000  
KITTING

\* PROCESS MATERIAL PER CAA STEP 2.  
DATE QTY... REMARKS..... STATUS  
5/11/05 1 \_\_\_\_\_ WCS  
3004

Handwritten notes and stamps at the bottom right of the page.



WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 2

Y/P/N/LAT-DS-01643  
UNIT-TEM/TPS

WOP 113232  
REQ DATE 03-08-05  
REL DATE 01-21-05  
SOP 117301  
PO# 0000033697

CUST P#  
CITY 1  
PROJECT# 117301  
CUST# 103300

DC# DEPT MACH# OP# DESCRIPTION..... H O U R S  
SET-UP RUN... LINE-MACH ST-LOT:



3 010 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL SCREWS JOINING  
THE TEM & TPS BOX ASSYS:

\* PROCESS ASSY PER CAA STEP 3.

DATE QTY REMARKS..... STATUS  
06/14/05 1 \_\_\_\_\_ Byp(1288)



4 010 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
TORQUE FASTENERS

- \* PROCESS ASSY PER CAA STEP 4.
- \*\* ALERT SLAC CAR TO WITNESS TORQUE PROCESS.\*\*
- \* RECORD ASSIGNED TOOLS USED, AND CAL DUE DATE, BELOW.
- TORQUE TOOL # GTC-A-977
- GTC-E-944 CAL DUE DATE 08/05

DATE QTY REMARKS..... STATUS  
06/14/05 1 \_\_\_\_\_ Byp(1288)

6-14-05 1 WITNESS TORQUE



5 010 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE BODY HEADS

- \* PROCESS ASSY PER CAA STEP 5.
- \* RECORD MATERIAL DATA BELOW:
- ADHSV 0151, GTC P# 31403 EXPIRATION DATE 01/31/07
- CURE DATE/TIME: START-6/14/05 4:20<sup>PM</sup> STOP-6:30 PM

DATE QTY REMARKS..... STATUS  
06/14/05 1 \_\_\_\_\_ Byp(1288)

210  
5-5

- \* RECORD MATERIAL DATA BELOW:
- LOT # 1ST A/B 200409020033
- LOT # 2ND B/C 200407020071
- MIX RECORD 1ST A WGT: 10 gr 2ND B WGT: 0.6 gr
- MARKING DATE/TIME 06/15/05 7:30 AM
- \* THE OCCURS AT STAKING STEP 13.

DATE QTY REMARKS..... STATUS  
06/15/05 1 \_\_\_\_\_ Byp(1288)

.....?.....

Assy/Pkg: LAT-DS-01443  
UNIT-ITEM/129

WC# 111313  
REQ DATE 05-11-08  
REQ DATE 04-21-08  
COP F17301  
PCF 0000033627

CUST PR  
CUST# 18366  
PROJECT# F17301  
CUST# 18366

DI# DEPT MACH# OP# DESCRIPTION..... SEC-UP RUN... LINE-MACH ST-LOT



6 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CPE: SLDR-0 ASSY-122

\* PROCESS ASSY PER CAA STEP 6:

RECORD DEFECT REPORT NO. IF APPLICABLE: \_\_\_\_\_

DATE QTY REMARKS STATUS

6/15/08 1 \_\_\_\_\_  
\_\_\_\_\_



7 290 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
EXAMINE BOX JOINING  
AND SID PACKAGES

\* PROCESS ASSY PER CAA STEP 7

RECORD DEFECT REPORT NO. IF APPLICABLE: \_\_\_\_\_

\* UPON ACCEPTANCE, ADDITIONALLY INDICATE BY STAMPING THE  
END-ITEM-DATA PACKAGE ON THE CHECKSHEET (FORM OIC-112).

DATE QTY REMARKS STATUS

6-15-08 1 GLAT 1840 \_\_\_\_\_  
\_\_\_\_\_



8 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CPE: SLDR-0 ASSY-127

\* PROCESS ASSY PER CAA STEP 8:

\* COLLECT AND ROUTE COPIES OF END-ITEM DATA PACKAGE  
WITH UNIS FOR DELIVERY TO SHIPPING.

RECORD DEFECT REPORT NO. IF APPLICABLE: \_\_\_\_\_

DATE QTY REMARKS STATUS

6/15/08 1 \_\_\_\_\_  
\_\_\_\_\_



WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 4

ASSY/TN# LAC-DS-01643  
PARTY: UNCL-DEM/TER

MO# 113222  
REC DATE 05-02-05  
REL DATE 04-21-05  
SOS 17301  
PO# 0000000027

CUST P#  
QTY  
PROJECT# W17301  
CUST# 10456

\*\*\*\*\*  
LINE DEPT MACH# OP# DESCRIPTION ..... H O U R S  
SET-UP RUN... LINE-MACH SI-LOC



9 299 00 PACKAGING/SHIPPING INSP 0.0000 0.0000 0.0000  
PACKAGING/SHIPPING

\* PROCESS ASSEMBLY TER CAA STEP 9.

DATE	QTY	REMARKS	STATUS
04/15/05	1		ByP(1088)

\*\*\*\*\* TRAVELER REVISION HISTORY RECORD \*\*\*\*\*  
 CREATED BY: MRPWIN FOR ASSY REV. DATE: 04 26 05  
 ASSY CHG CHG  
 REV BY DATE CHANGE DETAIL  
 03 GLH 042605 UPDATED FOR UNITS 4 THRU 22

\*\*\*\*\*END OF TRAVELER REVISION RECORD\*\*\*\*\*

WORK ORDER 013333

NEW

WORK ORDER PICK LIST

PAGE 1

ASSEMBLY # LAD-DS-01843

BY LINE ITEM

SELECTIVITY DATE: 05-03-05

WIP LOCATION: 400

RELEASE DATE: 05-03-05

DATE PRINTED: 05-17-05

PULLED:

PULLED BY:

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STAT	REQUIREMENTS		INVL0C	LOT NUMBER	INVENTORY DETAIL				
					STAT QUANTITY	RESV IN LOT #			QUANTITY	LOT LIFE	SINLOC	SIN QUANTITY	
1	LAD-DS-01843 ASSEMBLY KIT ORIGINAL QUANTITY...	EA	40.00	RSVD	40.00	120307	SKC12 FN-D3	120307	40	05	11.07	IN ASSY	
2	01843 ADHESIVE, NYLON 400 KIT ORIGINAL QUANTITY...	OZ	1.00	BC	1.00		SKC12 FN-D4		0-C				



WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 1

ASSY/PN# LAT-DS-01492  
BLAST: EAG, TFS

WOB 113271  
WORLD DATE 05-16-05  
WORLD DATE 05-16-05  
FC# F-73303  
FC# 000046803

CUST P#  
QTY 1  
PROJECT# F17300  
CUST# 15355

SERIAL NUMBER -----  
G-T III GLAT1819

APPROVAL:---  
PROD: KA/5-3-05  
OP: WMA/5-3-05

WORKMANSHIP:-----  
INC/DIA: STD-0010 CLASS 3: WITH "CS" SPACE SUPPLEMENT  
SLAC CAR MAY CHOOSE TO AUDIT/OBSERVE PROCESS PERFORMANCE  
OF ANY STEP OF THE TRAVELER/WORK ORDER. SLAC CAR MAY  
INDICATE OBSERVATIONS BY STAMP MARKING AT THE STEP

912 09 28 04-----

LINE DEPT MACH# QTY DESCRIPTION..... HOURS  
SET-UP RUN... LINE-MARK ST-LOT



1 100 00 CONFIG RECORD/KITTING 0.0000 0.0000 0.0000  
CONFIR

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
DOCUMENT NUMBER REV ED/PL OUTSTANDING ED'S  
ASSY IWD: LAT-DS-01492 05 NONE  
CUST P#W: (GAMES - ON PNC)  
CUST P#W: LAT-DS-01078 03 NONE  
EAG: (N/A - THIS IS IVEL)  
ASSY AID: LAT-DS-01492 (RELEASED PER EC 2477)  
CUSTOMER NAME: SLAC (STANFORD LINEAR ACCELERATOR CENTER)  
\*\*\*\*\* SOLID DOCUMENTS \*\*\*\*\*  
WPR... WORK ORDER, UNCONTROLLED ASSEMBLY AID, & DRAWINGS.  
\*\*\*\*\* SEE FOOTER OF WORK ORDER FOR REV HISTORY \*\*\*\*\*

DATE	QTY	REMARKS	STATUS
<u>5-3-05</u>			<u>WMA</u>



2 201 00 STOCKROOM/KITTING AREA 0.0000 0.0000 0.0000  
KITTING

\* PROCESS MATERIAL PER CAA STEP 2 \*

DATE	QTY	REMARKS	STATUS
<u>5/17/05</u>	<u>1</u>		<u>WMA</u> <u>3004</u>



ASSY/FUN CAT-03-01481  
ASSY. GLAST. BAG. TPR

NO 113321  
WORK ORDER 05-06-03  
CALIBR 04-20-03  
P17300  
0000048801

CUST PO#  
PROJECT# P17300  
CUST# 18185

LINE DEPT MACH# C# DESCRIPTION..... H C U B S  
SEC-UP RUN. LINE-MACH ST-LOT



3 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
APPLY ADHESIVE

- \* PROCESS ASSY PER CAA STEP 3.
- \* RECORD ADHESIVE DATA BELOW:

CTC PC# 32131 EXP DATE 10/01/05  
 LOT #19. (PT A) 32775 (PT B) 32775  
 MIX RECCD (PART A WONT) 15gr PART B WONT. 1gr

DATE	QTY	REMARKS	STATUS
04/10/05	1		BYP(1288)



4 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
LOG CCA SN TO WORK ORDER  
INSTALL CCA TO BOX

- \* PROCESS ASSY PER CAA STEP 4

INSTALLED CCA SERIAL NUMBER: GT 111

DATE	QTY	REMARKS	STATUS
06/10/05	1		BYP(1288)



5 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
TORQUE FASTENERS

- \* PROCESS ASSY PER CAA STEP 5.
- ALERT SLAC CAR TO WITNESS TORQUE PROCESS.--
- \* RECORD ASSIGNED TOOL# USED, AND CAL DUE DATE, BELOW.

TOOL# GTC-E-95 1/2 CAL DUE DATE 08/05  
 TTC-E-344 CAL DUE DATE 08/05

DATE	QTY	REMARKS	STATUS
04/10/05	1		BYP(1288)
4.10.05	1	WITNESS TORQUE	



TYPE: PRODUCTION

WORK UNDER TRAVELLER - NEW

ASSY/PN: LAT-DS-01482  
CART, P20, T29

WDR: 112211  
REQ DATE: 05-06-05  
REL DATE: 04-20-05  
SOS: P17300  
PC#: 0000048800

CUST #  
QTY: 1  
PROJECT # 111300  
COST # 10380

LINE DEPT MACH# UP# DESCRIPTION..... H O U R S  
SET-UP RUN... LINE-MACH ST-LOT



6 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL J2

- PROCESS ASSY PER CAA STEP 4
  - ALERT SLAC CAR TO WITNESS TORQUE PROCESS. ••
  - RECORD ASSIGNED TOOLS USED, AND CAL DUE DATE, BELOW.
- TOOL # GTC-E-95 1/2 CAL DUE DATE 08/05  
 GTC-E-94 CAL DUE DATE 08/05

DATE	QTY	REMARKS
06/10/05	1	
6-10-05	1	WITNESS TORQUE

STATUS  
Byp(1288)



7 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
SECURE C2 HARNESS

- PROCESS ASSY PER CAA STEP 7.
- DATE... QTY... REMARKS..... STATUS  
 06/10/05 1  
 \_\_\_\_\_  
 \_\_\_\_\_

DATE	QTY	REMARKS
06/10/05	1	

STATUS  
Byp(1288)



8 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0100 0.0000  
INSTALL J1 TO LID

- PROCESS ASSY PER CAA STEP 8.
  - ALERT SLAC CAR TO WITNESS TORQUE PROCESS. ••
  - RECORD ASSIGNED TOOLS USED, AND CAL DUE DATE, BELOW.
- TOOL # GTC-E-95 1/2 CAL DUE DATE 08/05  
 GTC-E-94 CAL DUE DATE 08/05

DATE	QTY	REMARKS
06/10/05	1	
6-10-05	1	WITNESS TORQUE

STATUS  
Byp(1288)

WORK CELL: 1-BIG BUNNER

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER: NEW

PAGE 4

ASSY/EN: 107-05-01482  
DIAS7, DRC, TPR

WOB 113111  
REQ DATE 05-06-05  
REL DATE 04-20-05  
SO# P17300  
PO# 0000048800

CUST P#  
QTY 1  
PROJECT# P17300  
CUST# 15355

LINE DEPT MAC# QTY DESCRIPTION..... H O U S E  
SET-UP RUN... LINE-MACH ST-LOT.



9 210 00 OCA/BLACK BOX ASSY AREA  
STAKE BOLT HEADS & OCA 0.0000 0.0000 0.0000

\* PROCESS ASSY PER CAA STEP 9.

\* RECORD MATERIAL DATA BELOW:

ADHSV 0181: QTY PO# 31403 EXPIRATION DATE 01/31/07

CURE DATE/TIME: START-06/10/05 12:45<sup>PM</sup> STOP- 2:45 PM

DATE	QTY	REMARKS	STATUS
06/10/05	1		ByP(1288)



10 210 00 OCA/BLACK BOX ASSY AREA  
STAKE J2 HARDWARE 0.0000 0.0000 0.0000

\* PROCESS ASSY PER CAA STEP 10.

\* RECORD MATERIAL DATA BELOW:

ADHSV 0181: QTY PO# 31403 EXPIRATION DATE 01/31/07

CURE DATE/TIME: START-06/10/05 12:45<sup>PM</sup> STOP- 2:45 PM

DATE	QTY	REMARKS	STATUS
06/10/05	1		ByP(1288)



11 210 00 OCA/BLACK BOX ASSY AREA  
STAKE J2 CABLE TIES 0.0000 0.0000 0.0000

\* PROCESS ASSY PER CAA STEP 11.

\* RECORD MATERIAL DATA BELOW:

ADHSV 0181: QTY PO# 31403 EXPIRATION DATE 01/31/07

CURE DATE/TIME: START-06/10/05 12:45<sup>PM</sup> STOP- 2:45 PM

DATE	QTY	REMARKS	STATUS
06/10/05	1		ByP(1288)



TYPE: PRODUCTION

WORK ORDER TRAVELLER: NEW

ASSY/FIN# LAT-76-01450  
GLAST, DAO, 750

NO# 113211  
DATE 06/08/06  
NO# 11781  
DATE 06/08/06  
NO# 0000048800

CUST #  
QTY  
PROJECT# 117800  
CUST# 10350

17# DEPT MACH# OP# DESCRIPTION..... SER-09 HOURS  
RGS... LINE-MACH ST-LOT



12 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE J1 HARDWARE

- PROCESS ASSY PER CAA STEP 12.
- RECORD MATERIAL DATA BELOW:

ADSV 0151: GTC PO# 31403 EXPIRATION DATE 01/31/07  
CURE DATE/TIME: START- 06/10/05 12:45 PM STOP- 2:45 PM

DATE	QTY	REMARKS	STATUS
06/10/05	1		Byp (1288)



13 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
MARKING (SN LABEL)

- PROCESS ASSY PER CAA STEP 13

DATE	QTY	REMARKS	STATUS
06/10/05	1		Byp (1288)



14 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CPE: SLDR-3 ASSY-257

- PROCESS ASSY PER CAA STEP 14.

RECORD DEFECT REPORT NO. IF APPLICABLE: \_\_\_\_\_

DATE	QTY	REMARKS	STATUS
06/10/05	1		



15 251 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
EXAMINE ASSY PRE-CLOSE

- PROCESS ASSY PER CAA STEP 15

RECORD DEFECT REPORT NO. IF APPLICABLE: \_\_\_\_\_

DATE	QTY	REMARKS	STATUS
06/10/05	1	GLAT 1819	

WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER + NEW

PAGE 6

ASSY. QTY: 147 06 01483  
WV GLASST. DAO: 173

NO 1113211  
DATE 08/10/05  
TIME 08:00  
CUST. NO.  
PROJECT  
CITY  
STATE  
COUNTRY

CUST. NO.  
PROJECT  
CITY  
STATE  
COUNTRY

LINE DEPT MACHINE OPER DESCRIPTION..... HOURS  
SET-UP RUN... LINE MACHINE ST LOT



16 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL LID

\* PROCESS ASSY PER CAA STEP 16

DATE..... QTY..... REMARKS.....

08/10/05 1

STATUS

Byt (1288)



17 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
TORQUE FASTENERS

\* PROCESS ASSY PER CAA STEP 17

\*\* ALERT SLAC CAR TO WITNESS TORQUE PROCESS \*\*

\* RECORD ASSIGNED TOOLS USED, AND CAL DUE DATE, BELOW.

TOOL = GTC-E 957 1/2 CAL DUE DATE 08/05

GTC-E-944 CAL DUE DATE 08/05

DATE..... QTY..... REMARKS.....

08/10/05 1

STATUS

Byt (1288)

08/10/05 1 WITNESS TORQUE



18 380 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CPE: SLD3-D ASSY-64

\* PROCESS ASSY PER CAA STEP 18

RECORD DEFECT REPORT NO IF APPLICABLE: \_\_\_\_\_

DATE..... QTY..... REMARKS.....

08/10/05 1

STATUS

Byt (1288)

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/TNS DAT 05-01481  
Y GLAST, HQ, TRS

WU# 113211  
REQ DATE 05-06-05  
REL DATE 04-20-05  
CO# F17300  
JOB 0000048800

CUST #  
CITY  
PROJECT#  
CUST#

\*\*\*\*\*  
LINE DEPT MACH# OP# DESCRIPTION..... HOURS  
SET-UP RUN... LINE-MACH ST-LOT



19 210 01 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE BOLT HEADS

- \* PROCESS ASSY PER CAA STEP 19
- \* RECORD MATERIAL DATA BELOW:

ADMSV 0151; GTC PO# 31403 EXPIRATION DATE 01/21/07  
CURE DATE/TIME: START- 06/10/05 10:45<sup>PM</sup> STOP- 2:45<sup>PM</sup>

DATE	QTY	REMARKS	STATUS
06/10/05	1		By P(1288)



20 290 07 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OP# SLD#-0 ASSY-60

- \* PROCESS ASSY PER CAA STEP 20.

RECORD DEFECT REPORT NO. IF APPLICABLE: \_\_\_\_\_

DATE	QTY	REMARKS	STATUS
06/18/05	1		



21 280 02 SOURCE INSPECTION 0.0000 0.0000 0.0000  
CUSTOMER SOURCE INSP.

- \* PROCESS ASSY PER CAA STEP 21.

RECORD DEFECT REPORT NO. IF APPLICABLE: \_\_\_\_\_

DATE	QTY	REMARKS	STATUS
06/13/05	1	GLAT 1819	

\*\*\*\*\* TRAVELLER REVISION HISTORY RECORD \*\*\*\*\*  
 CREATED BY: HEPKIN FOR ASSY REV: 55 DATE: 042805  
 ASSY REV: 003 BY: 003 CHANGE DETAIL: \*\*\*\*\*  
 02 014 003005 RELEASED AT REV 55, AND CAA AT REV 01

\*\*\*\*\*END OF TRAVELLER REVISION RECORD\*\*\*\*\*

AGENCY : 130-BS-01482  
NO QUANTITY : 1  
WIP LOCATION : MOD

BY LINE ITEM

EFFECTIVITY DATE : 06-03-04  
RELEASE DATE : 04-01-08  
DATE PRINTED : 03-01-08

FILLED BY

FILLED BY

LINE	PART NUMBER AND DESCRIPTION	UN	REQUIREMENTS		STATUS	REQ IN	INVOICE NUMBER	INVENTORY DETAIL				
			QUANTITY	STAT				LOT	LOT DATE	SINLOC	QUANTITY	
1	LAC-05-00995 SAC ORIGINAL QUANTITY	EA	1.00	RSVD	1.00	121225	SKOP2 FN-1	121225	1	09-30-07	SLAC	
2	LAC-05-00994 SAC ORIGINAL QUANTITY	EA	1.00	RSVD	1.00	121224	SKOP2 FN-1	121224	1	09-30-07	SLAC	
3	LAC-05-00998 SAC ORIGINAL QUANTITY	EA	1.00	RD	1.00		SKOP2 FN-3		0			
4	WAS135D01-6 SAC ORIGINAL QUANTITY	EA	30.00	RSVD	30.00	115012	SKOP2 FN-4	115012	30	09-27-04	LOT 115	
							FN-1	115012	100	00-13-05	IN ASSY	
5	WAS135D01-6 SAC ORIGINAL QUANTITY	EA	30.00	RD	30.00		SKOP2 FN-4	115012	30			
6	WAS135D04-4 SAC ORIGINAL QUANTITY	EA	20.00	RSVD	20.00	115013	SKOP2 FN-6	115013	20	09-27-04	F17111	
							FN-6	115013	54	12-16-04	IN ASSY	
7	WAS135D04-4 SAC ORIGINAL QUANTITY	EA	20.00	RD	20.00		SKOP2 FN-6	115013	20			
8	WAS135D04-4 SAC ORIGINAL QUANTITY	EA	20.00	RD	20.00		SKOP2 FN-6	115013	20			
9	WAS135D04-4 SAC ORIGINAL QUANTITY	EA	20.00	RD	20.00		SKOP2 FN-6	115013	20			
10	WAS135D04-4 SAC ORIGINAL QUANTITY	EA	20.00	RD	20.00		SKOP2 FN-6	115013	20			
11	WAS135D04-4 SAC ORIGINAL QUANTITY	EA	20.00	RD	20.00		SKOP2 FN-6	115013	20			
12	WAS135D04-4 SAC ORIGINAL QUANTITY	EA	20.00	RD	20.00		SKOP2 FN-6	115013	20			



ASSEMBLY # : LAT-24-11482  
DATE :  
BY :  
W.A. LOCATION : 802

BY LINE ITEM

EFFECTIVITY DATE : 08-01-01  
ISSUED DATE : 08-01-01  
DATE PRINTED : 08-17-08

PULLED:

PULLED BY:

LINE	PART NUMBER AND DESCRIPTION	UNITS	REQUIREMENTS			WBSV IN	LOC	INVENTORY DETAIL									
			QUANTITY	DATE	STATUS			LOT	QTY	DATE	BINLOC	QTY					
1	1700-06-1441 ORIGINAL QUANTITY	EA	2.00	80	2.00		8002 80-13										

*[Handwritten signature]*

LD: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 1

ASSY/TNS LAT-DS-700-4  
PART GLAST, ITS

WOP 112154  
REV DATE 02-10-05  
REL DATE 10-01-04  
R00  
POS 0000018800

CUST #  
QTY  
PROJECT # P17300  
CART# 18366

SERIAL NUMBER  
RTM GLAT1781

APPROVAL  
PRD: V.A. 2/10/05  
02/10/05

WORKMANSHIP  
IPC/ISA-J-STD-0010 CLASS 3; WITH "CS" SPACE SUPPLEMENT  
SLAC QAR MAY CHOOSE TO AUDIT/OBSERVE PROCESS PERFORMANCE  
OF ANY STEP OF THE TRAVELER/WORK ORDER. SLAC QAR MAY  
INDICATE OBSERVATIONS BY STAMP MARKING AT THE STEP.  
\*gjh 01.07.05\*

LINE DEPT MACH# OP# DESCRIPTION ..... HOURS  
SET-UP RUN LINE-MACH ST-LOC



1 000 00 CONFIG RECORD/KITTING 0 0000 0 0000 0 0000

CONFIGURATION DOCUMENTS  
DOCUMENT NUMBER REV #791 OUTSTANDING EQ'S  
LAT-DS-700-4 58 NONE  
LAT-DS-700-4 03 NONE  
LAT-DS-700-4 03 NONE  
LAT-DS-700-4 N/A NONE  
LAT-DS-700-4 N/A NONE  
LAT-DS-02388 - (RELEASED PER EC 2002)  
CUSTOMER NAME: SLAC (STANFORD LINEAR ACCELERATOR CENTER)  
BUILD DOCUMENTS  
USE WORK ORDER, CONTROLLED ASSEMBLY AID, & DRAWINGS  
\*ASSEMBLED BY: GH (DATE:DATE, 01.07.05)\*

428 4-28-05

DATE... QTY... REMARKS..... STATUS

2-10-05

[Signature]



1 000 00 STOCKROOM/KITTING AREA 0 0000 0 0000 0 0000

- \* PROCESS PER QAR STEP 2.
- \* ALL SMT PARTS ROUTE THROUGH THE SMT DRY ROOM.
- \* ALL OTHER PARTS ROUTE TO SECOND ASSY.

DATE... QTY... REMARKS..... STATUS

2-10-05

[Signature]



WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSEMBLY LINE: LAT-05-03393  
PLANT: 129

WO# 1110064  
REQ. DATE 02-11-05  
DEL. DATE 12-31-04  
PC# 0000048800

COST #  
QTY 1  
PROJECT # P17300  
CUR# 13354

PAGE 4

LINE DEPT MACH# OP# DESCRIPTION EST-UT RUN H O U S S  
LINE-MACH 90-100



3 712 70 CCA/BLACK BOX ASSEMBLY AREA  
MARK QCC SW 0.0000 0.0000 0.0000

PROCESS PER CAA STEP 3.

DATE	QTY	REMARKS	STATUS
2-11-05	1		F



4 011 00 SMT ASSY LINE  
PRE-SMT BACKROUT 0.0000 0.0000 0.0000

PROCESS PER CAA STEP 4.

RECORD SAVE DATE-TIME START/STOP BELOW:

SAVE DATE: 2-11-05 START: 12:12 STOP: 12:12

DATE	QTY	REMARKS	STATUS
2-11-05	1		TR



5 15 00 SMT ASSY LINE  
STENCIL BOTTOM SIDE 0.0000 0.0000 0.0000

PROCESS PER CAA STEP 5.

RECORD SOLDER PASTE DATA BELOW:

QCC PC# 31228 EXPIRATION DATE 7-14-05

DATE	QTY	REMARKS	STATUS
2-11-05	1		TR-OR



6 000 00 SMT ASSY LINE  
FLYER-PLACE PARTS 0.0000 0.0000 0.0000

PROCESS PER CAA STEP 6.

DATE	QTY	REMARKS	STATUS
2-11-05	1		TR

2-11-05 0070 C57-0070  
 2-12-05 0078 C-2-0077  
 C-77-0070  
 C-117-0077  
 C-34-0073  
 C-79-0077  
 C-81-0077  
 C-11-0077

Approved by:  
 H.K. 2/17/05  
 H.S. 2/17/05

WORK CELL: K-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

APPY/PNS LAT-06-01358  
BLAST. TFS

WOS 112004  
REQ DATE 02-10-05  
REQ DATE 12-01-04  
COST #  
PROJECT #  
CUST #  
0000048800

PAGE 3

7:3000  
10:250

LIA DEPT MACH# OP# DESCRIPTION.....



1 212 00 SMT ASSY LINE  
SOLDER REFLOW 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 7

DATE	QTY	REMARKS	STATUS
2/1/05	1		KT



2 213 00 SMT ASSY LINE  
SOLDER CLEAN 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 8.

DATE	QTY	REMARKS	STATUS
2/1/05	1		KT



3 220 00 QUALITY ASSURANCE AREA  
SPE: SLDL-1254 ASSY-1045 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 9.

\*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

LR#(S):

DATE	QTY	REMARKS	STATUS
2/1/05	1		KT



4 213 00 SMT ASSY LINE  
SOLDER PASTE STENCIL  
TOP SIDE 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 10.

\* RECORD SOLDER PASTE DATA BELOW:

SMT P# 1 225 EXPIRATION DATE 7-17-05

DATE	QTY	REMARKS	STATUS
2/1/05			KT

D4 - 0074  
 D500 - 0076  
 C550 - 0077  
 R611 - 0076  
 L14 - 0079

Solder Paste Data Log  
 Since 1/30/05  
 Aug 2 0076  
 Ranger 0095  
 - File name: B-  
 File  
 File  
 2/10/05



WORK CELL: 4-MIXED

CUSTOMER: ELAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PNY/END LAC-02-12333  
BLAST: 1P2

WO# 1122064  
SFO DATE 01-10-05  
DEL. DATE 12-01-04  
SOM  
POM 0000744800

CUST #  
QTY 1  
PROJECT# P17300  
CURTA 18385

PAGE 4

\*\*\*\*\* DEPT MACHS OPR DESCRIPTION \*\*\*\*\* H O U R S  
SRT-UP AID... LINE-MATH ST-LOC.



11 213 00 SMT ASSY LINE PICK-N-PLACE 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 11:

DATE	QTY	REMARKS	STATUS
2/23/05	1	Test	PF



12 213 00 SMT ASSY LINE SOLDER REFLOW 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 12:

DATE	QTY	REMARKS	STATUS
2/23/05	1		PF



13 213 01 SMT ASSY LINE AQUEOUS CLEAN 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 13:

DATE	QTY	REMARKS	STATUS
2/23/05	1		PF



14 290 00 QUALITY ASSURANCE AREA SFR 81DR-1471 ASSY-786 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 14:

\*\* SECOND DEFECT RECORD REPORT NUMBER(S) BELOW:

CR#19 296216

DATE	QTY	REMARKS
2/23/05	1	



in trace pt = 2.01  
A. 1.0000 2.0000  
Wrong in: Q599, Q699

03/09/05 Installed Q599.E  
Q699 correctly. 03/09/05

WORK CELL: 4 MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 5

ASSY EN# LAT-DS-02000  
CLAS# TFS

MO# 110364  
REL DATE 03-15-05  
REL DATE 11-31-04  
SOP  
PC# 000006800

CUST DR  
CITY 1  
PROCESSOR 117201  
CCSR 19200

LINE DEPT MACH# OF# DESCRIPTION..... SET-UP RUN HOURS ST-LOT



15 010 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
LIN THRU-HOLE PARTS

- PROCESS PER CAA STEP 10.
- SPECIAL IN-PROCESS QA EXAMINATION OF IC LEAD PREP AND SMD WIRE PREP.
- RECORD DEFECT RECORD REPORT NUMBER(S) BELOW

DATE	QTY	REMARKS	STATUS
3/14/05	1	Added Parts	10/24/05
3/14/05		Trimmed Leads	TR 1698

03/10/05 Installed DS00&D600  
inspection of DS00 & D600  
3/23/05

strip wires 03-15-05 M.D.  
3/15/05 35 inspect stripped wires  
3/17/05 35 inspect terminated wires



16 010 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
MECH ASSY - RTSNYS/VRS

- PROCESS PER CAA STEP 14.
- RECORD ADHESIVE DATA BELOW:  
GTC PO# 31450 EXPIRATION DATE 05/17/05
- RECORD ASSIGNED TOOLS USED, AND CAL DUE DATE, BELOW:  
TOOL # GTC-A-985 CAL DUE DATE 04/28/05

DATE	QTY	REMARKS	STATUS
03-20-05	1		



17 010 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
TERMINATE VRS

- PROCESS PER CAA STEP 17
- | DATE     | QTY | REMARKS    | STATUS |
|----------|-----|------------|--------|
| 03-22-05 | 1   | making VRS |        |



← special in-process QA examination of wires

03-22-05 strip & terminate wires for VRS



M.E. 4-7-05 checked wires for VRS 3/22/05

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

APRV/NS IAT-OS-02188  
CLASS: 000

WOB: 112064  
REQ DATE: 02-10-05  
REL DATE: 12-01-04  
SOC:  
PCB: 0000048900

CUST #:  
QTY: 1  
PROJECTS: P17300  
CUST#: 15356

PAGE 6

LINE DEPT MACHS OPS DESCRIPTION..... HOURS  
SET-UP RUN... LINE-MACH ST-CUT



18 000 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL/SOLDER R1, R2

\* PROCESS PER CAA STEP 18.

DATE	QTY	REMARKS	STATUS

*Moved to install + solder to step 26.  
ME 4-7-05*



19 000 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL/SOLDER I/O WIRES

\* PROCESS PER CAA STEP 19.

DATE	QTY	REMARKS	STATUS
3/23/05	1	Solder wires to the board	GTC 592



20 000 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OPE: SLDR-70 ASSY-41

\* PROCESS PER CAA STEP 20.

\*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DEFECTS:

DATE	QTY	REMARKS	STATUS
3/23/05	1		



21 000 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
MTRX ASSY-BOTTOM I/O

\* PROCESS PER CAA STEP 21

\* RECORD ADHESIVE DATA BELOW

GTC ID: 31450 EXPIRATION DATE 05/17/05

\* RECORD ASSIGNED TOOLS USED, AND CAL DUE DATE BELOW.

TOOL = GTC-A-985 CAL DUE DATE 06/28/05

DATE	QTY	REMARKS	STATUS
05-23-05	1		GTC 592

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: FABRICATION

WORK ORDER TRAVELLER - NEW

ASSY/TN# LAT-DS-00388  
CAGE# 799

W# 112054  
REQ DATE 02-10-05  
REL DATE 12-01-04  
CO#  
PO# 0000048801

CUST PW  
QTY 1  
PROJECT# P17100  
CUST# 18366

PAGE 1

CCA DEPT MACH# CPE DESCRIPTION SET-UP RUN W O U R S LINE-MACH ST-LOT



210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL/SOLDER WIRES-IC8

\* PROCESS PER CAA STEP 23.

DATE QTY REMARKS  
03/23/05 1



210 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CPE: SLD8-38 ASSY-28

\* PROCESS PER CAA STEP 23.

\*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW

ERR#(S):

DATE QTY REMARKS STATUS  
3/23/05 1



210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL/SOLDER Q504, Q604

\* PROCESS PER CAA STEP 24.

\*\* RECORD ADHESIVE DATA BELOW:

GTC FC# 31450 EXPIRATION DATE 05/17/05

DATE QTY REMARKS  
03/23/05 1 put adhesive on Q504 & Q604  
03/23/05 1 installed & soldered Q504 & Q604



210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL/SOLDER CAPS

\* PROCESS PER CAA STEP 25.

DATE QTY REMARKS  
03/24/05 1





WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 8

ATTN/ENR LAT-05-11339  
GLAST, TFS

WOB 113040  
REQD DATE 03-10-05  
CUST DA 12-01-04  
PGR 0000049910

CUST DA 113040  
PROCESS 113040  
CUST# 101300

LINE DEPT MACH# DFN DESCRIPTION.....



25 210 00 00A/BLACK BOX ASSY AREA  
INSTALL/SOLDER P. K T 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 24.  
DATE 03-24-05 QTY 1 REMARKS R1 + R2 ME 4-7-05  
STATUS (55%) M.D.



26 210 00 00 QUALITY ASSURANCE AREA  
CPRT SLDK-76 ASSY-32 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 27.  
\*\* RECORD DEFECT RECORD REPORT NUMBER (A) BELOW.  
DEF# (S):  
DATE 3/24/05 QTY 1 REMARKS



27 210 00 00 SFEA INT  
SFEA TEST 0.00000 0.00000 0.00000

\* PROCESS PER CAA STEP 28.  
\*\* RECORD TEST DEFECT RECORD REPORT NUMBER (S) BELOW  
TEST# (S): 23604  
DATE 03/24/05 QTY 1 REMARKS SN: GT III  
3.25.05 1 6N: GT III CHC  
STATUS FAILED PASSED



28 210 00 00 00A/BLACK BOX ASSY AREA  
INSTALL/SOLDER P. K T 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 29.  
DATE 3-22-05 QTY 1 REMARKS Rows 3-2 (except for fine print) solder  
3-25-05 1 Row 1 solder not  
STATUS HG = 1441

3-25-05 1 rows 2 & 3 impact solder  
3/25/05 1 rows 1 impact solder



WJKA BELL 4-MIXED

CUSTOMER: SLAC

TYPE: REDUCTION

WORK ORDER TRAVELLER - NEW

PAGE 3

FORM/TN: LAT-US-02388  
CLASS: TSS

W.O. NO 112144  
W.O. DATE 03-10-05  
W.O. DATE 12-01-04  
JOB NO  
P.O. NO VVVU48600

CUST # 1  
QTY 1  
PROJECT # 1217150  
CUST # 1217150

LINE DEPT MACH# OP# DESCRIPTION ..... H O U R S  
SET-UP RUN LINE-MACH SI-LOT



30 210 00 OCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL/SOLDER O/P CABLE  
SLDR O/P-ROW 1-CHECK 3-28-05-MD  
SLDR O/P-ROW 2-CHECK 3-28-05-MD  
SLDR O/P-ROW 3-CHECK 3-28-05-MD  
SLDR O/P-ROW 4-CHECK 3-28-05-MD

3/28/05  
3/28/05  
3/28/05  
3/28/05

\* PROCESS PER CAA STEP 30

DATE QTY REMARKS STATUS  
03-28-05 1 MD 57C 582



31 297 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OP: SLDR-98 ASSY-107

\* PROCESS PER CAA STEP 31  
\*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW:  
ERR#(S)

DATE QTY REMARKS STATUS  
3/28/05 1 MD 57C 582



32 310 00 OCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
HANDS CLEAN

\* PROCESS PER CAA STEP 32

DATE QTY REMARKS STATUS  
3-28-05 1 MD 57C 582

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER: NEW

PAGE 10

ASSY: P/N: LAT-DS-02316  
C/A: GLAST. TFS

MOB 112166  
REV DATE 02-10-05  
REL DATE 12-01-04  
PC# 0000048900

CUST #  
QTY  
PROJECT# P17300  
COST# 15356

LINE DEPT MAIN# C/A DESCRIPTION ..... HOURS  
SET-UP MIN... LINE-RATE ST-LOT



33 200 00 COATINGS/POURING AREA  
POT WITH RTV - CABLE  
D06-1104 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 31:

RTV D06-1104: QTY PO# 31695 EXPIRATION DATE 8-21-05

SEE ADHESIVE 018: APPLICATION FOR CURE DATA.

DATE	QTY	REMARKS	STATUS
3-29-05	1		PD 1946



34 210 00 C/A BLACK BOX ASSY AREA  
STAKE WITH RTV - VRS  
D06-1104 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 34 MC 3-14-05

ME 3-14-05 REMOVE DEFECT RECORD REPORT NUMBER(S) BELOW - ME 3-14-05  
DRAWT# RTV D06-1104 POT# 31695 EXP Date: 8-21-05

DATE	QTY	REMARKS	STATUS
3-29-05	1		PD 1946



35 210 00 C/A BLACK BOX ASSY AREA  
POURING/STARTING TCS 0.0000 0.0000 0.0000

\* PROCESS CAA PER CAA STEP 35 MC 3-15-05

AT 3-14-05 OPEN CURE DATE POT# 31695 START DATE 8-21-05  
STOP DATE 3-14-05

DATE	QTY	REMARKS	STATUS
3-29-05	1		PD 1946

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/PKG CAT: DS-0238  
CLASS: TFS

NO: 112056  
REV DATE: 02-10-05  
REV DATE: 12-01-04  
SO: 0000048800  
PO: 0000048800

CUST PO: 1017000  
QTY: 102000  
PROJECT: 102000  
CUST: 102000

PAGE 11

LINE DETAIL MATCH: OPR DESCRIPTION..... H O U R S  
SET-UP RUN... LINE-MACH ST-LOT



36 310 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE HARDWARE - NUTS,  
WASHERS, STUDS, SCREWS

\* PROCESS PER CAA STEP 36

ADHESIVE DISP: GTC PO# 31403 EXPIRATION DATE 1/31/07  
DURE DATE 3-29-05 START 4 00 STOP 6 00

DATE... QTY... REMARKS..... STATUS  
3-29-05 1 ..... P.O. 1946



37 310 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL/STAKE SUPPORTS

\* PROCESS PER CAA STEP 37

ADHESIVE DISP: GTC PO# 31403 EXPIRATION DATE 1/31/07  
DURE DATE 3-31-05 START 4 00 STOP 6 00

DATE... QTY... REMARKS..... STATUS  
3-31-05 1 ..... P.O. 1946



38 310 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE COMPONENTS - Q&A  
L990 P2+PS

\* PROCESS PER CAA STEP 38

ADHESIVE DISP: GTC PO# 31403 EXPIRATION DATE 1/31/07  
DURE DATE 3-31-05 START 4 00 STOP 6 00

DATE... QTY... REMARKS..... STATUS  
3-31-05 1 ..... P.O. 1946



WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER: NEW

ASSY/TNS DAT-DS-02388  
START, TPE

W# 121009  
REQ DATE 08-10-05  
REQ DATE 12-01-04  
SOL  
PC# 0000048807

COST #  
QTY 1  
PROJECT# P17300  
CURTS 15386

PAGE 11

LINE LIST MACHINE OPER DESCRIPTION HOURS  
SET-UP RUN LINE-MACH ST-LOT



39 210 00 20A/BLACK BOX ASSY AREA  
STAKE INDUCTORS 0.0000 0.0000 0.0000

\* PROCESS PER OAA STEP 30.

ADHESIVE 0151, GTC FOR 31403 EXPIRATION DATE 1-31-07

CURE DATE 3-31-05 START 4:00 STOP 6:00

DATE	QTY	REMARKS	STATUS
3-31-05	1		P.D. 1946



40 210 00 20A/BLACK BOX ASSY AREA  
STAKE CAPACITORS AND R22, R1 & R2 0.0000 0.0000 0.0000

\* PROCESS PER OAA STEP 40.

ADHESIVE 0151, GTC FOR 31403 EXPIRATION DATE 1-31-07

CURE DATE 3-31-05 START 7:00 STOP 6:00

DATE	QTY	REMARKS	STATUS
3-31-05	1		P.D. 1946
4-28-05	1	staked R22, R1 & R2	P.D. 1946
4-28-05	1	baked R22, R1 & R2	P.D. 1946

843 4-28-05

P.O. # 31403 exp. date 1/31



41 290 00 QUALITY ASSURANCE AREA  
SFB- SLCR-0 ASSY-97 0.0000 0.0000 0.0000

\* PROCESS PER OAA STEP 41.

\*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW

DEFECTS

DATE	QTY	REMARKS	STATUS
3-31-05			
4/1/05	1		P.D. 1946

REV/ING: LAT-05-01390  
SLAC, TOS

MIR 112064  
MIR DATE 02-10-06  
MIR DATE 12-01-04  
PUB# 000049900

JUST #  
PROJECT# 017800  
CUST# 103900

LINE DEPT MACH# QTY DESCRIPTION ..... H O U R S  
SET-UP RUN LINE-MARK ST-LOC



42 280 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
SLAC CAR INSPECTION - MIP

\* PROCESS PER CAA STEP 42  
100% MANDATORY INSPECTION POINT - MIP

DATE	QTY	REMARKS	STATUS
4/5/05	1	GLAT 1781	LAT TO QA
		R2 THERMISTOR NOT	
		LAYING ON BOARD	

REMARKS CONT'D.  
\* PART IS NOT DAMAGED.  
\* PROCESS INDICATOR  
\* HANDLING PROCESS MUST  
BE INVESTIGATED TO  
PREVENT POTENTIAL DAMAGE



43 290 00 PACKAGING/SHEETING INSP 0.0000 0.0000 0.0000  
PACKAGE & SHIP TO CUSTOMER FOR TEST & CUSTOMER

\* PROCESS PER CAA STEP 43

DATE	QTY	REMARKS	STATUS
5/5/05	1	PACKAGING	AD



44 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
RECEIVING INSPECTION

\* PROCESS PER CAA STEP 44

\*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

ERR# (S) 31721

DATE	QTY	REMARKS	STATUS
5/7/05	1		X
6/6/05	1		



45 210 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
SLAC CAR PRE-COAT INSP  
MANDATORY INSPECTION  
POINT TEST POINT

\* PROCESS PER CAA STEP 45

DATE	QTY	REMARKS	STATUS
6/05	1	GLAT 1781	

WARR CELL 4-MIXED

CUSTOMER: SLAC

TYPE: FALLOUTION

WORK ORDER TRAVELLER - NEW

ACCY/IN: LAC DS 00349  
CAA: SLAST, 775

WCR 112054  
WRO DATE 02-10-08  
WDL DATE 12-01-04  
WOB 0000048800

PAGE 14

CUST P  
PROJECT  
CUST  
117300  
10350

.....  
LINE MACH: OP: DESCRIPTION..... HOURS  
SET-UP RUN... LINE-MACH ST:LOT



46 000 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000

CAV CLEAN AND TEST  
FOR CLEANLINESS OF CCA  
ATTACH RESULTS REPORT TO  
THE TRAVELER/NO.

- \* PROCESS CAA PER CAA STEP 46
- \* ATTACH CLEANLINESS TEST RECORD TO WORK ORDER.

DATE	QTY	REMARKS	STATUS
6-8-05	1		MY:742
6/8/05	1	Cleanliness	SPG



47 000 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000

CPV SLDR-0 ASSY-7

- \* PROCESS PER CAA STEP 47
- \*\* RECORD DEFECT RECORD NUMBER(S) BELOW.

DRKS:

DATE	QTY	REMARKS	STATUS
6/8/05	1		



48 150 00 COATING/POTTING AREA 0.0000 0.0000 0.0000

BAKE-OUT AND MASK

- \* PROCESS CAA PER CAA STEP 48
- RECORD BAKE DATE-TIME START-STOP BELOW:

BAKE DATE: 6/08/05 START: 3:30pm END: 4:30pm

DATE	QTY	REMARKS	STATUS
6/08/05	1	mask iBAKE	SPG

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

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ASSY/PN: LAT-06-00389  
CAA: ULAST. 1FS

W# 112164  
REQ DATE 04-10-05  
REL DATE 12-01-04  
SOS  
PO# 0000048500

CUST P#  
PROJECT# F17930  
CUST# 18386

104 DEPT MACH# 098 DESCRIPTION..... M O U R E  
SET-UP RUN LINE-MACH ST-LOC.



41 250 00 COATING/POTTING AREA  
CONFORMAL COATING 0.0000 0.0000 0.0000

\* PROCESS CAA PER CAA STEP 49.

CONFORMAL COATING PO# 31201 EXPIRATION DATE 6/30/05  
AIR CURE DATE 6-8-05 START 1:30pm STOP 7:30pm

DATE... QTY... REMARKS... STATUS  
6/8/05 1 LOAST HIW



51 251 02 COATING/POTTING AREA  
OVEN CURE/TOUCHUP 0.0000 0.0000 0.0000

\* PROCESS CAA PER CAA STEP 50.

OVEN CURE DATE 6/09/05 START 6:30am STOP 7:30am  
OVEN CURE DATE 6/09/05 START 8:00am STOP 9:20am

DATE... QTY... REMARKS... STATUS  
6/09/05 1 TU SPK



91 297 00 QUALITY ASSURANCE AREA  
SPE: SLDR-0 ASSY-7 0.0000 0.0000 0.0000

\* PROCESS CAA PER CAA STEP 91.

REFER TO CAA FOR DOCUMENTATION REQUIREMENTS TO ATTACH OR  
ADVANCE WITH THIS WORK ORDER. ITEMS MAY, OR WILL, INCLUDE  
THE FOLLOWING

- COPIES OF CERTIFICATIONS
- AREA TEST REPORTS
- INSPECTION REPORTS
- NON CONFORMANCE REPORTS
- END-ITEM DATA PACKAGE FORM
- DIGITAL PHOTOGRAPHS, RECORDS (NISO CD...)

DATE... QTY... REMARKS... STATUS  
6/9/05 1 \_\_\_\_\_ SPK





WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 14

ASSY/PN: LAT-DS-02344  
C/A: GLAST, TFS

WOB 112064  
WROD DATE 02-10-05  
WROL DATE 12-01-04  
PCB 000048800

CUST QTY 1  
PROJECT# 117900  
CUST# 13356

LINE DEPT MACH# C/A DESCRIPTION ..... HOURS  
SET-UP RUN... LINE MACH ST-LOT



50 360 00 SOURCE INSPECTION 0 0000 0 0000 0.0000

\* PROCESS CAA PER C/A STEP 52

NOTE: NEXT ASSEMBLY IS LAT-DS-01444.

DATE	QTY	REMARKS	STATUS
5.9.05	1	GLAT 1781	



-----SERIAL NUMBER-----

-----APPROVAL-----  
PROD: \_\_\_\_\_  
CA: \_\_\_\_\_

\*\*\*\*\*WORKMANSHIP\*\*\*\*\*  
PRO/ETA/CUST#-0010 CLASS 3, WITH "CS" SPACE SUPPLEMENT  
SLAC CAR MAY CHOOSE TO AUDIT/OBSERVE PROCESS PERFORMANCE  
OF ANY STEP OF THE TRAVELLER/WORK ORDER. SLAC CAR MAY  
INDICATE OBSERVATIONS BY STAMP MARKING AT THE STEP.  
\*\*\*\*\*

ASSEMBLY # : LAT-DS-02308  
NO QUANTITY :  
WIP LOCATION: W02

BY LINE ITEM

EFFECTIVITY DATE: 02-10-09  
RELEASE DATE : 12-31-09  
DATE PRINTED : 07-11-08

TR PULLED: \_\_\_\_\_ PULLED BY: \_\_\_\_\_

LINE#	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STATUS	RESV IN LOT #	INVTLOC NUMBER	INVENTORY DETAIL		
							LOT QUANTITY	LOT DATE	BIN
1	LAT-DS-02308 PWS, GLAST, TPS ORIGINAL QUANTITY...	EA	1.00			SK2 FN-D1	0.00		
				RSVD	1.00 120308	SKCF2 120308	18.00	09-11-07	
2	LAT-DS-02830-01 ASSY, CABLE, TPS I/P ORIGINAL QUANTITY...	EA	1.00	BO	1.00	SK2 FN-(D2) 17 J2	0.00		
						SKCF2	0.00		
3	LAT-DS-02465 HEAT SHK, TPS ORIGINAL QUANTITY...	EA	4.00			SK2 FN-D3	0.00		
				RSVD	4.00 115014	SKCF2 115014	66.00	06-29-07	
4	LAT-DS-02831-01 ASSY, CABLE, TPS O/P ORIGINAL QUANTITY...	EA	1.00	BO	1.00	SK2 FN-(D4) 18 J1	0.00		
						SKCF2	0.00		
5	LAT-DS-03598 SUPPORT, CABLE HARNESS ORIGINAL QUANTITY...	EA	2.00			SK2 FN-D24	0.00		
				RSVD	2.00 115020	SKCF2 115020	14.00	08-27-04	
						120308	23.00	09-11-07	IN ASSY
6	LAT-DS-05518 LABEL, SN ORIGINAL QUANTITY...	EA	1.00	BO	1.00	SK2 FN-D22	0.00		
						SKCF2	0.00		
7	NAS1149CN432R WASHER ORIGINAL QUANTITY...	EA	4.00			SK2 FN-D5	0.00	07-31-01	A47
				RSVD	4.00 115016	SKCF2 115016	131.00	08-27-04	LOT 115
8	NAS57106 WASHER, SN FAC ORIGINAL QUANTITY...	EA	19.00	RSVD	19.00 122500	SK2 FN-6	548.00	02-08-05	

109

ASSEMBLY # : LAT-DS-02389  
NO QUANTITY : 1  
WIP LOCATION: W03

BY LINE ITEM

EFFECTIVITY DATE: 01-10-05  
RELEASE DATE : 12-01-04  
DATE PRINTED : 02-11-05

PULLED: \_\_\_\_\_

PULLED BY: \_\_\_\_\_

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STATUS	RSVD IN LOT #	INVL0C NUMBER	LOT NUMBER	INVENTORY DETAIL		
								LOT QUANTITY	LOT DATE	BINLOC QUANTITY
8	NAS07106 NUT #6 SM.PAT Cont from prior page.	EA	19.00				117413	57.00	11-04-04	B2H
						FN-6	PULLED			
						FN-6	PULLED	910.00	02-02-05	
						FN-6	PULLED	500.00	02-03-05	
						FN-6	PULLED	500.00	03-03-05	
						SKCF2	44571	18.00	08-19-00	CF9D
							PULLED			
							116770	403.00	10-28-04	
							PULLED			
9	NAS1162N16-6 SCREW ORIGINAL QUANTITY...	EA	7.00				SK2 FN-D7	0.00		
							PULLED			
				RSVD	7.00	115011	SKCF2	115011	121.00	03-27-04
							PULLED			
10	NAS1162N04-6 SCREW ORIGINAL QUANTITY...	EA	4.00				SK2 FN-D8	0.00		
							PULLED			
				RSVD	4.00	114932	SKCF2	114932	534.00	09-23-04 LOT 125
							PULLED			
								712.00	10-27-04	IN ASSY
							PULLED			
11	NAS1149CN032R WASHER ORIGINAL QUANTITY...	EA	19.00				SK2 FN-D9	0.00		
							PULLED			
				RSVD	19.00	115010	SKCF2	115010	327.00	09-27-04
							PULLED			
12	NAS07104 NUT HEX. SS. PASS. 4-10THRD ORIGINAL QUANTITY...	EA	4.00	RSVD	4.00	122091	SK1 FN-D10	133.00	01-20-05	HW7
							PULLED			
							FN-D10	64.00	01-20-05	
							PULLED			
							FN-D10	280.00	01-21-05	
							PULLED			
							FN-D10	2000.00	02-04-05	
							PULLED			
							FN-D10	320.00	02-17-05	
							PULLED			

ASSEMBLY # : LAT DS-02188  
WO QUANTITY : 1  
WIP LOCATION: W02

BY LINE ITEM

EFFECTIVITY DATE: 02-10-05  
RELEASE DATE : 12-01-04  
DATE PRINTED : 02-11-05

PULLED BY: \_\_\_\_\_

PULLED BY: \_\_\_\_\_

LINE	PART NUMBER AND DESCRIPTION	REQD QTY	CURR STATUS	RESV IN	INVLCC	LOT NUMBER	INVENTORY DETAIL		
							LOT QTY	LOT DATE	BIN
12	NAS87104 NUT, HEX, SS, PASS, 4-40XRD Cont from prior page.	EA	4.00			123597	610.00	02-07-05	
						FN-D10			
						123512	80.00	02-07-05	
						FN-D10			
						123521	188.00	02-07-05	
						FN-D10			
						123522	140.00	02-07-05	
						FN-D10			
						123591	700.00	02-07-05	
						FN-D10			
						SKCF2 115009	31.00	09-27-04	LOT 116
						FN-D10			
13	TV-2946 RTV MURIL TECH ORIGINAL QUANTITY...	OZ	1.00	BC	1.00	SK2 FN-D11		0.00	
						SKCF2		0.00	
14	0101 ADHESIVE, NY501, 4OZ KIT ORIGINAL QUANTITY...	OZ	1.00	BC	1.00	SK2 FN-D12		0.00	
						SKCF2		0.00	
						FN-D15		0.00	
						SKCF2		0.00	
15	5750 CONFORMAL COATING UREthane ORIGINAL QUANTITY...	OZ	1.00	BO	1.00	SK2 FN-D17		0.00	
						SKCF2		0.00	
17	DC6-1114 ADHESIVE ORIGINAL QUANTITY	OZ	1.00	BO	1.00	SK2 FN-D18		0.00	
						SKCF2		0.00	
18	W11759/11-21-8 WIRE, 24AWG, WHITE ORIGINAL QUANTITY...	IN	1.00	25VD	1.00	46193 FN-D19	250.00	02-14-00	SK2 R4



ASSEMBLY # : LAT-DG-02088  
WO QUANTITY : 1  
WIP LOCATION: W02

BY LINE ITEM

EFFECTIVITY DATE: 02-10-05  
RELEASE DATE : 12-01-04  
DATE PRINTED : 02-11-05

PULLED:

PULLED BY:

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STATUS	REQUIREMENTS	RESV IN LOT #	INVLIN	LOT NUMBER	INVENTORY DETAIL		
									QUANTITY	LOT DATE	BIN
	WIRE, 14AWG, WHITE Cont from prior page.	IN					SKCF2	115299	17716.00	10-01-04	LOT152
								PULLED:			
18	LAT-DG-04101 HEATSINK ORIGINAL QUANTITY...	EA	2.00				SK2 FN-D20		0.00		
			2.00				SKCF2	120304	94.00	09-11-07	
				RSVD	2.00	120304		PULLED:			
20	ASF451 IC FILTER ORIGINAL QUANTITY...	EA	1.00				SK2 FN-34 VXS		1.00		
			1.00				SKCF2	114559	1.00	02-27-04	
				RSVD	1.00	114559		PULLED:			
21	MAX724ECK IC ORIGINAL QUANTITY...	EA	7.00				SK2 FN-36 US U7 U8 U10 U15 U17 U18		0.00		
			7.00				SKCF2	114961	149.00	09-27-04	
				RSVD	7.00	114961		PULLED:			
22	5562R86663501VXC ORIGINAL QUANTITY...	EA	5.00				SK2 FN-35 U20 U559 U560 U659 U660		0.00		
			5.00				SKCF2	120301	5.00	12-16-04	MAX-10
				RSVD	5.00	120301		PULLED:			
23	55812400TKV DIPIC ORIGINAL QUANTITY...	EA	7.00				SK2 FN-19 D1 D2 D3 D4 D5 D19 D20		0.00		
			7.00				SKCF2	114948	210.00	09-27-04	
				RSVD	7.00	114948		PULLED:			
24	JANTXVIN4153UR-1 DIPIC ORIGINAL QUANTITY...	EA	8.00				SK2 FN-20 D502 D503 D509 D599 D602 D603 D509 D609		0.00		
			8.00				SKCF2	114949	21.00	09-27-04	
				RSVD	8.00	114949		PULLED:			
25	JANTXVIN6487US DIPIC INSULOUS ORIGINAL QUANTITY...	EA	8.00				SK2 FN-21 U501 D504 D507 D509 D511 D512 U501 U512		0.00		
			8.00				SKCF2	114950	12.00	09-27-04	
				RSVD	8.00	114950		PULLED:			
26	JANTXVIN6487US DIPIC ORIGINAL QUANTITY...	EA	8.00				SK2 FN-23 CR1 CR3 CR4 CR6 CR8 CR9		0.00		
			8.00					PULLED:			



ASSEMBLY # : IAT 05 02386  
WO QUANTITY : 1  
WIP LOCATION: 402

BY LINE ITEM

EFFECTIVITY DATE: 02-10-05  
RELEASE DATE: 12-01-04  
DATE PRINTED: 02-11-05

FULLED:

FULLED BY:

LI#	PART NUMBER AND DESCRIPTION	UN	REQUIRED QUANTITY	CURR STAT	REQUIREMENTS	RESV IN LOT #	INVL0C NUMBER	INVENTORY DETAIL						
								LOT	LOT DATE	SIN	BIN			
	DIODE Cont from prior page.	EA		RSVD	6.00	114952	SKCF2 114952	140.00	09-27-04					
27	JANTXV1N4106UR-1 DIODE ORIGINAL QUANTITY...	EA	4.00				SK2 FN-24 CWS D30 D505 D605 FULLED:	0.00						
			4.00	RSVD	4.00	114953	SKCF2 114953 FULLED:	61.0	09-27-04					
28	JANTXV1N4494US DIODE ORIGINAL QUANTITY...	EA	1.00				SK2 FN-26 D500 FULLED:	0.00						
			1.00	RSVD	1.00	114955	SKCF2 114955 FULLED:	14.00	09-27-04					
29	JANTXV1N4485US DIODE ORIGINAL QUANTITY...	EA	1.00				SK2 FN-22 CR2 FULLED:	0.00						
			1.00	RSVD	1.00	114951	SKCF2 114951 FULLED:	11.0	09-27-04					
30	JANTXV1N3339 TRANSISTOR ORIGINAL QUANTITY...	EA	4.00				SK2 FN-81 C506 C550 C64 C600 FULLED:	0.00						
			4.00	RSVD	4.00	115006	SKCF2 115006 FULLED:	82.0	09-27-04					
44	5562R3582602VXC IC ORIGINAL QUANTITY...	EA	6.00				SK2 FN-38 U1 U2 U21 U22 U561 U661 FULLED:	0.00						
			6.00	RSVD	6.00	120302	SKCF2 120302 FULLED:	104.0	12-16-04	DRY-10				
32	CRJ28X103BK1S CAP 0.01UF 100V 10% ORIGINAL QUANTITY...	EA	22.00				SK2 FN-4 C1 C5 C8 C31 C33 C36 C37 C38 C63 C66 C73 C76 C115 C114 C119 C165 C504 C596 C595 C615 C696 C698 FULLED:	0.00						
			22.00	RSVD	22.00	114937	SKCF2 114937 FULLED:	820.0	09-27-04					
33	CM205H2106KCB CAPACITOR ORIGINAL QUANTITY...	EA	4.00				SK2 FN-5 C620 C627 C650 C657 FULLED:	0.00						
			4.00	RSVD	4.00	114939	SKCF2 114939 FULLED:	108.0	09-27-04					
34	M38005/22-0107H CAPACITOR ORIGINAL QUANTITY...	EA	37.00				SK2 FN-5 C1 C2 C3 C4 C5 C6 C7 C8 C9 C10 C11 C12 C13 C14 C15 C16 C17 C18 C19 C20 C21 C22 C23 C24 C25 C26 C27 C28 C29 C30 C31 C32 C33 C34 C35 C36 C37 C38 C39 C40 C41 C42 C43 C44 C45 C46 C47 C48 C49 C50 C51 C52 C53 C54 C55 C56 C57 C58 C59 C60 C61 C62 C63 C64 C65 C66 C67 C68 C69 C70 C71 C72 C73 C74 C75 C76 C77 C78 C79 C80 C81 C82 C83 C84 C85 C86 C87 C88 C89 C90 C91 C92 C93 C94 C95 C96 C97 C98 C99 C100 FULLED:	0.00						
			37.00											











ASSEMBLY # : LAT-US-02388  
MO QUANTITY : 1  
WIP LOCATION: W02

BY LINE ITEM

EFFECTIVITY DATE: 02-10-04  
RELEASE DATE : 12-01-04  
DATE PRINTED : 02-11-04

PULLED:

PULLED BY:

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STATUS	RESV IN LOT #	INVOLOC	LOT NUMBER	INVENTORY DETAIL	
								QUANTITY	LOC
49	M55342K0684E75R RESISTOR ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00 84926	SK2 FN-53 R509 R509		0.00	510A
						SKCF2 91326		67.00	09-24-03
						PULLED:			
						114981		488.00	09-27-04
						PULLED:			
50	M55342K068E07R RESISTOR ORIGINAL QUANTITY...	EA	1.00	RSVD	1.00 119010	SK2 FN-56 R14		25.00	11-30-04
						SKCF2 114934		144.00	09-27-04
						PULLED:			
51	M55342K069E25R RESISTOR ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00 84926	SK2 FN-57 R3 R10		12.00	04-10-03
						SKCF2 114989		62.00	09-27-04
						PULLED:			
52	M55342K06B10FR RESISTOR, CPID, 100K, 10K 0 ORIGINAL QUANTITY...	EA	21.00	RSVD	21.00 114930	SK2 FN-55 R55 R55 R57 R502 R118 R522 R55C R551 R502 R618 R522 R55C R651 ZR24 ZR26 ZR63 ZR68 ZR95 ZR00 ZR97 ZR98		117.00	09-23-04
						SKCF2 114987		65.00	09-27-04
						PULLED:			
						91324		58.00	09-24-03
						PULLED:			
53	C03049X104AKUS CAP, .1UF, 50V ORIGINAL QUANTITY...	EA	32.00	RSVD	32.00 114936	SK2 FN-1 C8 C9 C10 C19 C158 C159 C160 C170 C171 C172 C173 C174 C175 C176 C177 C178 C179 C180 C181 C182 C183 C184 C185 C186 C187 C188 C189 C190 C191 C192 C193 C194 C195 C196 C197 C198 C199 C200		303.00	09-27-04
						SKCF2 114936			
						PULLED:			
54	C03018X102BKUS CAPACITOR ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00 114936	SK2 FN-3 C520 C620		0.00	
						SKCF2 114936		274.00	09-27-04
						PULLED:			
55	H03018X102BKUS CAPACITOR ORIGINAL QUANTITY...	EA	14.00	RSVD	14.00 114936	SK2 FN-3 C200 C201 C202 C203 C204 C205 C207 C211 C212 C213 C214 C215 C216 C217 C218 C219 C220 C221 C222 C223 C224 C225 C226 C227 C228 C229 C230 C231 C232 C233 C234 C235 C236 C237 C238 C239 C240 C241 C242 C243 C244 C245 C246 C247 C248 C249 C250 C251 C252 C253 C254 C255 C256 C257 C258 C259 C260 C261 C262 C263 C264 C265 C266 C267 C268 C269 C270 C271 C272 C273 C274 C275 C276 C277 C278 C279 C280 C281 C282 C283 C284 C285 C286 C287 C288 C289 C290 C291 C292 C293 C294 C295 C296 C297 C298 C299 C300		840.00	09-27-04
						SKCF2 114936			
						PULLED:			

ASSEMBLY # : LAT-DS-02388  
MO QUANTITY : 1  
WIP LOCATION: W02

BY LINE ITEM

EFFECTIVITY DATE: 02-10-06  
RELEASE DATE : 12-01-04  
DATE PRINTED : 02-11-03

FULLED: \_\_\_\_\_

FULLED BY: \_\_\_\_\_

LT#	PART NUMBER AND DESCRIPTION	UM	REQUIREMENTS			INVLOC	LOT NUMBER	INVENTORY DETAIL					
			REQUIRED QUANTITY	CURR STAT	RESV IN QUANTITY			LOT	LOT DATE	SIN	QUANTITY		
56	CDR338K2238KUS CAPACITOR ORIGINAL QUANTITY...	EA	4.00			SK2 FN-7 C603 C651 C603 C651	0.00						
			4.00	RSVD	4.00	114940						248.00	09-27-04
57	CDR338K4738KUS CAPACITOR ORIGINAL QUANTITY...	EA	7.00			SK2 FN-9 C6 C7 C82 C86 C83 C74 C77	0.00						
			7.00	RSVD	7.00	114799						1252.00	09-25-04
												333.00	02-27-04
58	CDR318F4708KUS CAPACITOR ORIGINAL QUANTITY...	EA	4.00			SK2 FN-10 C102 C512 C561 C661	0.00						
			4.00	RSVD	4.00	115090						951.00	09-28-04
59	CW033FC176KDR CAPACITOR	EA	89.00			SK2 FN-11 C11 C12 C13 C14 C15 C16 C17 C18 C19 C20 C21 C22 C23 C24 C25 C26 C27 C28 C29 C30 C31 C32 C33 C34 C35 C36 C37 C38 C39 C40 C41 C42 C43 C44 C45 C46 C47 C48 C49 C50 C51 C52 C53 C54 C55 C56 C57 C58 C59 C60 C61 C62 C63 C64 C65 C66 C67 C68 C69 C70 C71 C72 C73 C74 C75 C76 C77 C78 C79 C80 C81 C82 C83 C84 C85 C86 C87 C88 C89 C90 C91 C92 C93 C94 C95 C96 C97 C98 C99 C100	0.00						
	ORIGINAL QUANTITY...		89.00	RSVD	89.00	114943						175.00	09-27-04
60	CDR318P1018KUS CAPACITOR ORIGINAL QUANTITY...	EA	4.00			SK2 FN-12 C621 C607 C637 C612	0.00						
			4.00	RSVD	4.00	114944						510.00	09-27-04
61	JANIXV16488US DIODE ORIGINAL QUANTITY...	EA	1.00			SK2 FN-25 D500	0.00						
			1.00	SO	1.00							-0.00	
62	DXE110 FUSE, POLYMER ORIGINAL QUANTITY...	EA	2.00			SK2 FN-33 F4 F5	0.00						
			2.00	RSVD	2.00	114952						45.00	09-27-04
63	RAX998R010FR RESISTOR ORIGINAL QUANTITY...	EA	1.00			SK2 FN-43 R10	0.00						
			1.00										



ASSEMBLY # : LAT-DS-02388  
 NO QUANTITY : 1  
 WIP LOCATION: W02

EFFECTIVITY DATE: 02-10-05  
 RELEASE DATE : 12-01-04  
 DATE PRINTED : 02-11-05

PULLED: \_\_\_\_\_ PULLED BY: \_\_\_\_\_

LINE	PART NUMBER AND DESCRIPTION	EA	REQUIREMENTS			SKC#	LOT #	INVENTORY DETAIL		
			REQUIRED QUANTITY	CURR STAT	RESV IN QUANTITY			LOT QUANTITY	LOT DATE	BIN
	RESISTOR Cont from prior page.		RSVD	1.00	114966	SKCF2	114966	93.00	09-27-04	
64	M55342K06B1B21A RESISTOR ORIGINAL QUANTITY...	EA		4.00		SK2	FN-49 R20 R53 R56 R61	0.00		
			RSVD	4.00	114970	SKCF2	114970	222.00	09-27-04	
65	M55342K06D2B21A RESISTOR ORIGINAL QUANTITY...	EA		6.00		SK2	FN-51 R37 R40 R64 R65 R66 R67	0.00		
			RSVD	6.00	114979	SKCF2	114979	443.00	09-27-04	
66	M55342K06D1C20R RESISTOR ORIGINAL QUANTITY...	EA		4.00		SK2	FN-60 R243 R544 R643 R644	0.00		
			RSVD	4.00	114920	SKCF2	114920	54.00	09-23-04	
							114988	212.00	09-27-04	
67	M55342K06B1B20K RESISTOR ORIGINAL QUANTITY...	EA		3.00		SK2	FN-61 R18 R35 R16	0.00		
			RSVD	3.00	114989	SKCF2	114989	132.00	09-27-04	
68	M55342K06B1B20R RESISTOR CHIP 100W 10K 0 ORIGINAL QUANTITY...	EA	1.00	RSVD	1.00	4905	SK2	4905	140.00	05-26-04
							FN-62 R19			
						SKCF2	114990	63.00	09-27-04	
69	M55342K06B1B21A RESISTOR ORIGINAL QUANTITY...	EA		2.00		SK2	FN-63 R231 R547	0.00		
			RSVD	2.00	114991	SKCF2	114991	132.00	09-27-04	
70	M55342K06B20B2R RESISTOR 20K0000 ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00	17105	SK2	17105	300.00	05-25-04
							FN-64 R505 R507 R510 R528 R535 R536 R537 R538 R539 R540			
							48973	100.00	09-27-04	
							FN-64 R505 R507 R510 R515 R516 R517 R518 R519 R520			



ASSEMBLY # : LAT-DS-02388  
WO QUANTITY : 1  
WIP LOCATION: W02

BY LINE ITEM

EFFECTIVITY DATE: 02-10-05  
RELEASE DATE : 12-31-04  
DATE PRINTED : 02-11-05

PULLED: \_\_\_\_\_

PULLED BY: \_\_\_\_\_

LINE DESCRIPTION	UM	REQUIREMENTS		RESV IN LOT #	INVL0C NUMBER	INVENTORY DETAIL		
		REQUIRED QUANTITY	CURR STATUS			LOC	LOT DATE	BIN
RESISTOR, 20KOHMS Cont from prior page.	EA				SKCF2 114992	208.00	09-27-04	
					PULLED:			
71 RESISTOR ORIGINAL QUANTITY...	EA	1.00			SK2 FN-65 R511	0.00		
					PULLED:			
			RSVD 1.00	114993	SKCF2 114993	137.00	09-27-04	
					PULLED:			
72 RESISTOR ORIGINAL QUANTITY...	EA	5.00	RSVD 5.00	50590	SK2 50590	33.00	12-18-00	W5G
					FN-66 R14 R45 R512 R556 R612			
					PULLED:			
					SKCF2 50591	10.00	12-18-00	55G
					PULLED:			
					114994	272.00	09-27-04	
					PULLED:			
73 RESISTOR ORIGINAL QUANTITY...	EA	1.00			SK2 FN-67 R566	0.00		
					PULLED:			
			RSVD 1.00	114995	SKCF2 114995	134.00	09-27-04	
					PULLED:			
74 RESISTOR, 49.9KOHMS ORIGINAL QUANTITY...	EA	6.00	RSVD 6.00	83542	SK2 83542	303.00	04-31-03	51R
					FN-68 R27 R42 R598 R599 R698 R699			
					PULLED:			
					SKCF2 114996	269.00	09-27-04	
					PULLED:			
75 RESISTOR ORIGINAL QUANTITY...	EA	1.00	RSVD 1.00	84266	SK2 84266	17.00	04-15-03	51R
					FN-69 R667			
					PULLED:			
					SKCF2 114997	144.00	09-27-04	
					PULLED:			
76 RESISTOR, CHIP, 100W 100 OH ORIGINAL QUANTITY...	EA	4.00	RSVD 4.00	104427	SK2 104427	240.00	04-27-04	57H
					FN-70 R501 R530 R601 R610			
					PULLED:			
					SKCF2 114922	3428.00	09-23-04	
					PULLED:			
					114998	0.00	09-27-04	
					PULLED:			
77 RESISTOR, CHIP, 1014, 100K ORIGINAL QUANTITY...	EA	12.00			SK2 FN-71 R6 R7 R202 R203 R204 R205 R206	0.00		50G
					R216 R207 R513 R107 R613 R637			
					PULLED:			







ASSEMBLY # : LAT-DS-02388  
NO QUANTITY :  
WIP LOCATION: #02

BY LINE ITEM

EFFECTIVITY DATE: 02-10-05  
RELEASE DATE : 12-01-04  
DATE PRINTED : 02-11-05

PULLED: \_\_\_\_\_

PULLED BY: \_\_\_\_\_

LT#	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	REQUIREMENTS		REQ IN LOT #	INVLOC	LOT NUMBER	INVENTORY DETAIL		
				CURR STAT	QUANTITY				LOT QUANTITY	LOT DATE	BIN
64	JANTXVINE1907AUB TRANSISTOR ORIGINAL QUANTITY...	EA	2.00				SK2 FN-82	0599 0699 PULLED:	0.00		
				RSVD	2.00	115007	SKCF2	115007 PULLED:		85.00	09-27-04
65	M55342K0994E29R RESISTOR ORIGINAL QUANTITY...	EA	2.00				SK2 FN-54	R519 R619 PULLED:	0.00		
				RSVD	2.00	114982	SKCF2	114982 PULLED:		219.00	09-27-04
66	M55342K0685E11R RESISTOR ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00	60670	SK2 FN-55	60670 R108 R608 PULLED:	44.00	59-07-01	997
							SKCF2	74-829 PULLED:	9.00	08-19-04	
							SKCF2	114983 PULLED:	204.00	09-23-04	
							SKCF2	114983 PULLED:	232.00	09-27-04	
67	M55342K09D100R RESISTOR ORIGINAL QUANTITY...	EA	1.00				SK2 FN-58	R611 PULLED:	0.00		
				RSVD	1.00	114986	SKCF2	114986 PULLED:		237.00	09-27-04



CCA PIN: LAT-DS-02388 LLAT1781 GT111

W.O. #: 112064

CC Tech: HW (Initial / Employee #)

Date: 6/8/05

## MIX RATIOS

Coating TYPE: ARATHANE Mfr: HUNTSMAN

Lot Number: AKA6-B8013A Expiration Date: 6/30/05

MIX RATIOS: 18 PBW 5750-A To 100 PBW 5750-B

AIR CURE: 6/8/05

OVEN CURE: 6/8/05 6:30 pm

WESTEK

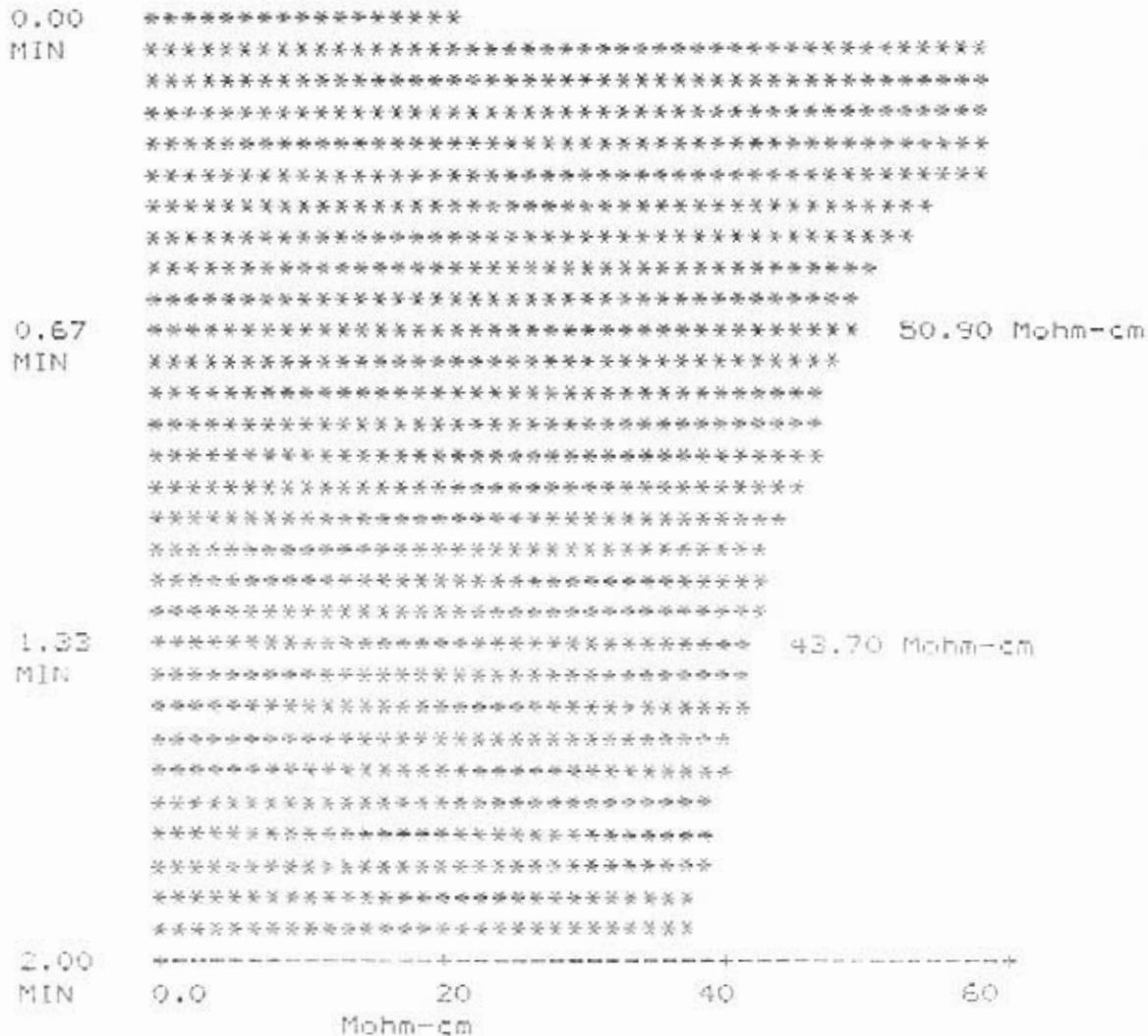
Operator :STEPHANIE  
06/08/05  
14:07:11

Test Type : Test  
Test name : 'Manual Test'  
Board # GT111 has P A S S E D

TEST TIME : 2.00 min  
TEST VOLUME : 8820 ml  
BOARD AREA : 220.5 sq in  
COMP. AREA : 0.00 sq in  
VOL/SQ. IN : 40 ml/sq. in  
F/F LIMIT : 10.07 ug/sq in  
: 7.70 Mohm-cm

Initial Resistivity : 47.80 Mohm-cm  
NaCl Equivalence (Final) : 1.06 ug/sq in

TIME vs RESISTIVITY



Final Resistivity : 39.90 Mohm-cm  
NaCl Removed : 0.25 ug/sq in



# DEFECT RECORD REPORT

ID: 31721

PART NUMBER: LA1-DS-02268

WORK ORDER: 112054

SALES ORDER: F17300

QUANTITY: 1 RWQTY: 0

CUSTOMER: SLAC

INSPECTION TYPE: RECEIVING

INSPECTION LEVEL: 1

INSPECTOR: EMARTINEZ

OFF SOLDER: 0

OFF ASSEMBLY: 0

DATE: 5/17/2005

WEEK CODE: 22

SERIAL NO	QUANTITY	OPERATOR	DEFECT CODE	WORKCELL	DEFECT DESCRIPTION	REF DES	PIN NOTES
GT11	1	A379		I-BIG RUNNER	CONTAMINATION / FOD IN OR ON COATING		BY C45,76,23, CUSTOMER RESPONSIBILITY

SENT TO SLAC FOR REWORK ON 5-20-05  
 Received Back to GTC AFTER REWORK ON 6-3-05  
 JAC [Signature] 6-3-05  
 E208

# DEFECT RECORD REPORT

ID: 29626  
 PART NUMBER: LATDS 0238H      INSPECTION TYPE: POST REFLOW      OFE SOLDER: 1421  
 WORK ORDER: 117064      INSPECTION LEVEL: 1      OFE ASSEMBLY: 786  
 SALES ORDER: F17300      INSPECTOR: EMARTINEZ      DATE: 2/23/2005  
 QUANTITY: 1      RW QTY: 1      WEEK CODE: 10  
 CUSTOMER: SLAC

SERIAL NO	QUANTITY	OPERATOR	DEFECT CODE	WORKCELL	DEFECT DESCRIPTION	REF DES	PIN NOTES
✓ 111	1	1858	A305		MISSING COMPONENT	L2	<i>Print is in the bag.</i>
✓ 111	1	1858	S402		INSUFFICIENT SOLDER	L14	
✓ 111	2	1858	S412		< 75% HEEL FILLET AT 10X MAGN	D1,20	

*03/08/05 Rework done by [Signature] 03/08/05*

*[Signature] 3/9/05*

*[Signature]*








# REWORK TRAVELER

SO NO: F17300	PART NO: LAT-DS-02388 TPS	REV: 57
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ASSEMBLY NAME: SLAC TPS	QTY: 19
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**APPROVAL**

G. Pozzi <i>G. Pozzi</i>	G. Hefkin <i>G. Hefkin</i>	M. Mora <i>M. Mora</i>	P. Lujan <i>P. Lujan</i>
4-25-05	4-25-05	4-25-05	4-25-05
PREPARED BY	DATE	ENG MGR	DATE
		QA MGR	DATE
		Source Insp.	DATE

STEP	OPERATION	Operator Sign Off.	Date	Time spent
	<i>RE. NCMR 2323. gnr</i>			
1	Record serial numbers Affected: __ GT-104 Glat-1774 Thru GT-122 Glat-1792 __ Serial Number <u>GT 111</u> <u>G L A T 1781</u>	 <i>AMP</i>	<i>04/25/05</i>	
2	REMOVE ALL CABLE TIE WRAPS ON HARNESSSES.	 <i>AMP</i>	<i>05/02/05</i>	
3	REPLACE ALL CABLE TIE WRAPS USING THE PANDUIT CABLE TIE WRAP TOOL ON SETTING "STANDARD", AT LEVEL "7".	 <i>AMP</i>	<i>05/02/05</i>	
4	TRIM CABLE TIES FLUSH TO THE STRAP HEAD ADD A DROP OF ADHESIVE TO THE CUT STRAP SO THAT THE ADHESIVE FLOWS DOWN INTO THE LOCKING MECHANISM. USE HYSOL 0151 ADHESIVE <i>PREFER TO CAA LAT-DS-02388</i>	 <i>AMP</i>	<i>05/02/05</i>	
5	Hysol 0151 data:  DATE MIXED <u>05/02/05</u> Expiration Date <u>01/31/07</u> PO# <u>31403</u>	 <i>AMP</i>	<i>05/02/05</i>	
6	Inspection	 <i>AMP</i>	<i>4/3/05</i>	
7	Source Inspection	 <i>AMP</i>	<i>5/3/05</i>	






# REWORK TRAVELER

SO NO: F17300	PART NO: SLAC LAT-DS-02388	REV: 57
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ASSEMBLY NAME: TPS CCA	QTY: 1
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APPROVAL					
G. POZZI	4-28-05	G. HEFKIN	K. BERGTHOLDT	P. LUJAN	4-28-05
PREPARED BY	DATE	ENG MGR	DATE	QA MGR	DATE
				SLAC SOURCE	DATE

STEP	OPERATION	Operator Sign Off.	Date	Time spent
1	Record serial numbers: __ TPS LAT-DS-02388 SN GT- <u>111</u> GLAT- <u>1781</u>	 BLP	04/28/05	
2	OPERATOR: STAKE R22 PER CAA-LAT-DS-02388, STEP 40. CURE PER INSTRUCTION IN STEP 40	L.D. 1946	4/28/05	
3	INSPECTION: INSPECT FOR BOARD CLEANLINESS. NO SOLDER BALLS ALLOWED.		5/3/05	
4	SOURCE INSPECTION		5/3/05	















# REWORK TRAVELER

SO NO: F17300	PART NO: SLAC LAT-DS-02388 TPS	REV: 57
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ASSEMBLY NAME: SLAC CCA'S	QTY: ALL
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APPROVAL							
G. POZZI	4-22-05	G. HEFFKIN	4-22-05	BERGTHOLT	4/21/05	P. LUJAN	4-21-05
PREPARED BY	DATE	ENG MGR	QA MGR	PROD MGR	DATE	SOURCE	DATE

STEP	OPERATION	Operator Sign Off.	Date	Time spent
1	Record serial numbers: TPS LAT-DS-02388 SN's GT- <u>111</u> , GLAT- <u>1781</u>	 EYP	04/23/05	
2	<p><b>OPERATOR:</b></p> <p>REMOVE Q10, Q11, AND Q12. USE THE HAKO FM202 PARALLET REMOVAL SOLDERING IRON WITH 5/16" BLADE TIPS</p> <p>PLACE PARTS INTO AN ESD BAG AND RECORD BOARD SERIAL NUMBER ON BAG.</p> <p>KEEP PARTS WITH REWORK TRAVELER THEN ROUT TO QUALITY ENGINEERING WITH A COPY OF THE REWORK TRAVELER.</p>	 EYP  EYP  EYP	05/02/05 05/02/05 05/02/05	
3	<p><b>OPERATOR:</b></p> <p>VERIFY PADS HAVE NO DAMAGE.</p>	 5/2/05  EYP	05/02/05	
3	<p><b>OPERATOR:</b></p> <p>SOLDER Q10, Q11, AND Q12 ONTO BOARD</p> <p>USE THE METCAL SOLDERING IRON WITH A .5" BLADE TIP.</p>	 EYP	05/02/05	
4	<p><b>OPERATOR:</b></p> <p>HAND CLEAN BOARDS USING ALCOHOL.</p>	 EYP	05/02/05	
5	<p><b>INSPECTION:</b></p> <p>INSPECT PARTS FOR WORKMANSHIP AND BOARD CLEANLINESS</p>	 EYP	5/3/05	
6	SOURCE INSPECTION		5/3/05	



# REWORK TRAVELER

SO NO: F17300	PART NO: SLAC LAT-DS-02388	REV: 57
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ASSEMBLY NAME: TPS CCA	QTY: 1
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Original signed edition - RESERVED FOR COPYING

APPROVAL G. POZZI <i>[Signature]</i>	G. HEFKIN <i>[Signature]</i>	K. BERGTHOLDT <i>[Signature]</i>	P. LUJAN <i>[Signature]</i>
PREPARED BY	DATE	ENG MGR SUP.	DATE
	4-18-05		4-18-05
		QA MGR ENTL.	DATE
			4-19-05

STEP	OPERATION	Operator Sign Off.	Date	Time spent
1	Record serial numbers: __ TPS LAT-DS-02388 SN GT- <u>111</u> GLAT- <u>1781</u>	BYP	04/23/05	
2	<b>OPERATOR: INSPECT FOR CLEANLINESS AND DEBRIS</b> USE A SOLUTION OF 75% ALCOHOL AND 25% DE-IONIZED WATER. PLACE BOARDS INTO SOLUTION AND USE A SOFT BRISTLE BRUSH TO REMOVE ALL SOLDER BALLS. VIEW BOARDS UNDER A 10X SCOPE AND RECLEAN UNTIL ALL SOLDER BALLS HAVE BEEN REMOVED. <b>NO SOLDER BALLS ALLOWED.</b>	BYP	05/02/05	
3	AQUEOUS CLEAN USING RECIPE #3	BYP	05/02/05	
	<b>INSPECTION: INSPECT FOR BOARD CLEANLINESS. NO SOLDER BALLS ALLOWED.</b>		5/3/05	
5	SOURCE INSPECTION		5/3/05	



# GTC TEST DEFECT RECORD REPORT

TEST ID: 23604

PART NUMBER: LAT-DS-02388

TEST TYPE: SPEA

WO: 112064 WC: 4-MIXED

TEST LEVEL: 1ST

SO: F17300

TEST TECH: STEFFEN BODE

TEST QTY: 1

CUSTOMER: SLAC

FAIL QTY: 1

PROGRAM NAME: LAT-DS-02388

DATE: 3/24/2005

SERIAL # QTY DEFECT CODE

DEFECT DESCRIPTION

REF DES

GT111 1 T300

WRONG COMPONENT USED

R231

TEST INFO

RW INFO

REWORKED BY INSPECTED BY

REWORK NOTES (OPTIONAL):

*R231 Resistor was within correct per drawing  
NO REWORK REQUIRED Bsn: R 2018*

RETEST NOTES (OPTIONAL):

RETESTED BY:

RETEST DATE: P F

*dehase*

*3.25.06*

*X*



MARK CELL: 1-MIXED

CUSTOMER: SLAC

TY REDUCTION

WORK ORDER TRAVELLER - NEW

PAGE 1

ASSY/PN# LAT-DS-02831-01  
ASSY. CABLE: TFS O/P PWR

WOB 112044  
REQ DATE 02-08-05  
REL. DATE 02-02-05  
SQ#  
PO# 0000048800

CUST #  
QTY 19  
PROJECT# F17300  
CUST# 15356

-SERIAL NUMBER LISTING:-

N/A

APPROVAL  
PROD: 2/10/05  
CA: MDR, 2-9-05

-WORKMANSHIP:-

ANSI-J-STD-001C CLASS 3; OTHER;  
(DEFAULT WORKMANSHIP UNLESS INDICATED OTHERWISE, ABOVE.)

LOT NO.	LOT QTY	SERIAL NUMBERS	SEQ NO.	REASON	APPRV DATE
A <sup>1</sup>	13	N/A	3		mm 3/1/05
B	4	N/A	3	To make	mm 3/2/05
A <sup>2</sup>	2	N/A	6	To move	mm 3/18/05
A <sup>1B</sup>	2	N/A	7	To move	mm 3/2/05
A <sup>1A2</sup>	6	N/A	7	To move	3/1/05

(vohdr rev 05.19.04 gih)

LT# DEPT MACH# QP# DESCRIPTION HOURS  
SEP-09 RUN... LINE-MACH ST-LOT



.00 00 CONFIG RECORD/KITTING 0.0000 0.0000 0.0000  
CONFIG

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
 ASSY & PL: DOCUMENT NUMBER REV FD/PL OUTSTANDING EO'S  
 (REFERENCE ASSY/PL LAT-DS-02831 S2 NONE  
 (REFERENCE ASSY/PL LAT-DS-02388 FOR RTV APPLICATION ROT)  
 TEST SPEC: N/A  
 ASSY AID: N/A  
 CUSTOMER NAME: SLAC  
 \*\*\*\*\* BUILD DOCUMENTS \*\*\*\*\*  
 USE ... TRAVELER AND DRAWING  
 (REV'D)/PREP'D BY: JH (DATE)DATE: 02.03.05

DATE: QTY: REMARKS: STATUS:

2705

MDR





WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 2

AS W# LAT-US-02621-01  
ASSY. CABLE. TFS O/P FWR

W# 112044  
REQ DATE 02-08-05  
REL DATE 02-02-05  
SO#  
PO# 0000048800

CUST P#  
QTY 19  
PROJECT# 717700  
CUST# 15256

\*\*\*\*\*  
L# DEPT MACH# OP# DESCRIPTION ..... H O U R S  
SET-UP RUN... LINE-MACH ST-TOT.



1 201 00 STOCKROOM/KITTING AREA 0.0000 0.0000 0.0000  
KIT PARTS/MATERIALS

\* WIRE, CRIMP PINS, CONNECTOR, AND RTV.

QTY.	REMARKS.....	STATUS
19		

*Handwritten signature*

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

J. JNS LAT-DS-02221-01  
ASSEMBLY, CABLE, TPA C/P FWK

WOB 112044  
REQ DATE 02-08-05  
REL DATE 02-22-05  
SCF  
POS 0000048800

CUST P#  
QTY 19  
PROJECT# P17300  
CUST# 15356

PAGE 3

LINE DEPT MACH# OP# DESCRIPTION SET-UP RUN... LINE-MACH ST-LOT



3 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
CUT WIRE, STRIP WIRE,  
CRIMP SOCKET CONTACTS,  
TIN LEADS.

\* CRIMP TEST SETUP - GTC-2081.

CUT 6 PIECES OF WIRE @ 6" TO 9" LONG, FOR FULL TESTS.  
USE 3 PCS EACH FOR PRE-CRIMP AND POST-CRIMP TESTS.

\* STRIPPING METHOD -- ALL ASSEMBLY AND TEST ACTIVITY...

USE ~~SCHEMATIC~~ ENTHUSIASTIC WIRE STRIPPER SET UP WITH  
24 AWG STRIP BLADES, A STRIP LENGTH OF ~~1/8"~~ 7/16 (.128)  
AND LEAVES THE INSULATION SLOG IN PLACE.

\* PRE-ASSY CRIMP TEST...

STRIP AND CRIMP THREE CONTACTS USING TEST WIRE. TEST THE  
SAMPLE CRIMPS PER GTC-2081. RECORD RESULTS. IF FAIL  
CONTACT ENGINEERING.

CRIMP TEST: BY: RM1970 DATE: 2/16/05 STATUS Pass Crimp Tensile Strength paper attached  
RM1970

\* ASSEMBLY ACTIVITY...

- 1) FEED WIRE DIRECTLY OFF THE SPOOL TO THE STRIPPER.
- 2) STRIP THE INSULATION LEAVING THE SLOG. ~~1/8" LONG~~ 7/16 (.128) AT 2-15-05
- 3) CUT THE WIRE OFF AT THE INDICATED LENGTH, AND QUANTITY.  
\* CUT 78 WIRES TO 8-1/2" (8.50") LONG.  
3.6.05 crimp test H.G.#1941 pre-assy  
3.7.05 crimp test H.G.#1941 pre-assy  
3.18.05 post assy crimp test H.G.#1941
- 4) STRIP SECOND END USING THERMAL TWEEZERS, 1/4".
- 5) TIN SECOND END BY SOLDER DIP. CLEAN WITH ALCOHOL.
- 6) FULL INSULATION SLOG AND CRIMP CONTACT (22D) ONTO LEAD.  
USE M22520/2-01 CRIMPER W/ M22520-2-06 TURRET/LOCATOR.  
K:41

\* POST-ASSY CRIMP TEST...

STRIP AND CRIMP THREE CONTACTS USING TEST WIRE. TEST THE  
SAMPLE CRIMPS PER GTC-2081. RECORD RESULTS. IF FAIL  
CONTACT ENGINEERING.

CRIMP TEST: BY: RM1970 DATE: 2/16/05 STATUS Pass

DATE	QTY	REMARKS	STATUS
2/15/05	4	78 wires x 4 = 312	RM1970
3.7.05	2	156 wires	
<del>3/4/05</del>	<del>4</del>	<del>4 wires</del>	<del>300</del>

- 3.22.05 strip, tin, crimp H.G.#1941 (133)
- 3.27.05 strips H.G.#1941 (815)
- 3.23.05 crimp, tin, clean H.G.#1941 (492)
- 3.28.05 tin & clean H.G.#1941 (315)

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 4

AG. # LAT-DS-C2631-01  
ASSY. CABLE. TFS O/P FWR

WO# 112044  
REQ DATE 02-08-05  
REL. DATE 02-02-05  
SOM  
PC# 0000048800

CUST #  
QTY 19  
PROJECT# P17300  
CUST# 15355

LINE DEPT MACH# OP# DESCRIPTION..... HOURS  
SET-UP RUN... LINE-MACH ST-LOT.



4 250 00 QUALITY ASSURANCE AREA  
OP# SLDR-78 ASSY-312 0.0000 0.0000 0.0000

- \* INSPECT WIRE COUNT, STRIPS, CRIMPS, TINNING, AND CLEANING.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DATE	QTY	REMARKS	STATUS
2/17/05	4	78 wires x 4	
<del>2/17/05</del>	<del>2</del>	<del>156 wires</del>	
3/17/05	2	Strip & crimps	



5 210 00 CCA/BLACK BOX ASSY AREA  
INSERT WIRE/CONTACTS TO CONNECTOR 0.0000 0.0000 0.0000

- \* INSERT TERMINATED WIRES TO CONNECTOR IN ALL POSITIONS.
- ...ASSURE CONTACT IS SEATED AND LOCKED INTO CONNECTOR.

DATE	QTY	REMARKS	STATUS
2/17/05	4		
3/17/05	2		
3/24/05	2		

H.G. #1441  
checked strips 375 wires 3/22/05  
+ 1440  
Checked crimps & tin 3/24/05  
Checked wires for tinning 3/5 2m 1544  
492



6 250 00 QUALITY ASSURANCE AREA  
OP# SLDR-0 ASSY-78 0.0000 0.0000 0.0000

- \* INSPECT LEAD AND CONTACT INSERTION TO CONNECTOR.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DATE	QTY	REMARKS	STATUS
2/17/05	4	Inspect step 5	
3/17/05	2		
3/24/05	2		
3-25-05	6	Check socket retention	
4/21/05	5	" " "	

Rm 1970  
H.G. #1941  
H.G. #1941  
3/25/05 (6) H.G. #1441



WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 5

ISS. # LAT-DG-02831-01  
ASSY. CABLE, TFS O/P SWR

WOB 112044  
REQ DATE 02-08-05  
REL DATE 02-02-05  
SO#  
PO# 0000049900

CUST P#  
QTY 19  
PROJECT# F17300  
CUST# 15356

LIST DEPT MACH# OP# DESCRIPTION..... HOURS  
SET-UP RUN... LINE-MACH ST-LOT



7 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
POT WIRES AT CONNECTOR

- \* APPLY RTV, DGS-1104, TO WIRES EXITING CONNECTOR SHELL, FROM THE SHELL DOWN THE WIRES 1/2" (.5").
- \* TRANSFER RTV TO AN EPD SYRINGE TUBE, OR PLUNGER TYPE SYRINGE, TO AID APPLICATION.
- \* ALIGN WIRES WITH KAPTON TAPE IN AN AREA ABOUT 2 TO 4 INCHES AWAY FROM THE CONNECTOR. THIS IS INTENDED TO KEEP WIRES COMING STRAIGHT OUT OF THE CONNECTOR, AS AN AID FOR LATER TERMINATION TO THE CCA.
- \* APPLY RTV TO CONNECTOR BACKSHELL SURFACE, AT INSIDE ROWS FIRST, WORKING OUT, AND UP, TO THE APPROXIMATE 1/2" POINT.
- \* RECORD RTV MATERIAL PO# AND EXPIRATION DATE BELOW:  
PO# 31695 EXP. DATE 07/10/05
- \* CURE APPLIED RTV IN OVEN FOR 2 HOURS AT 120 DEG F (50 C).
- \* RECORD CURE DATE, START/STOP TIME BELOW:

DATE \_\_\_\_\_ START \_\_\_\_\_ STOP \_\_\_\_\_

DATE	QTY	REMARKS	STATUS
3/24/05	2		12/12/02
3/28/05	6	save lot of RTV used as above	H.G. #1941
4/22/05	6		12/12/02



8 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OP# SLDG-0 ASSY-7

- \* INSPECT POTTING/CURING OF LEAD ASSEMBLY.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW
- DRR#(S) \_\_\_\_\_
- \* ROUTE FOR NO CLOSURE AND NEXT ASSY - LAT-DG-02831.

DATE	QTY	REMARKS	STATUS
4/23/05	5		





WORK ORDER : 112044

( NEW )

WORK ORDER PICK LIST

PAGE: 1

A LY # : LAT-DS-02831-01  
M LOCATION : 19  
WZ LOCATION: W02

BY LINE ITEM

EFFECTIVITY DATE: 02-08-05  
RELEASE DATE : 02-02-05  
DATE PRINTED : 02-09-05

DATE PULLED: \_\_\_\_\_

PULLED BY: \_\_\_\_\_

LINE	PART NUMBER AND DESCRIPTION	UOM	REQUIREMENTS		RESV IN	LOT #	INVLOC	LOT NUMBER	INVENTORY DETAIL					
			QUANTITY	STAT QUANTITY					QUANTITY	LOT DATE	BIN	BINLOC	QUANTITY	
1	20650-1 CONN (202407-SS-B-15) ORIGINAL QUANTITY...	EA	100	BO	19.00			SKCF2 FN-1		0.00				
<p>The following parts have been defined as alternates for 20650-1:            Line 1.1 2112407-SS-B-15 1 PER            Partial quantity replacements are allowed.</p> <p><i>Handwritten: \$ JB LAT-DS-02831 10 # 114947</i></p>														
2	M22159/11-24-9 WIRE, 24AWG, WHITE ORIGINAL QUANTITY...	IN	260.00	RSVD	16340.00	115259		SKCF2 FN-3	115259	34056.00	10-01-04	LOT1152		
3	206071-1 CONTACT (206071-1) ORIGINAL QUANTITY...	EA	26.84	BO	972.00			SKCF2 FN-2		0.00				
<p>The following parts have been defined as alternates for 206071-1:            Line 3.1 00881 1 PER            Partial quantity replacements are allowed.</p>														
3.1	00881 CONTACT (206071-1) ORIGINAL QUANTITY...	EA	51.16	RSVD	972.00	115021		SKCF2 FN-2	115021	972.00	09-27-04			
<p>This line is an alternate part for line 3. 00881 is used in a 1 to 1 ratio to 206071-1. Partial quantity replacements are allowed.</p>														
4	DC6-1104 ADHESIVE ORIGINAL QUANTITY...	OZ	1.00	BO	19.00			SKCF2 REQUIREMENT SHOWS ON LAT-DS-02831. APPLY HERE.		0.00				

0710

## CRIMP TENSILE STRENGTH LAT-05-02831-01

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	POST - PROD
CRIMP OPERATOR NAME/EMP #:	RHODA MARINO 1970	TEST DATE
CONTACT PN:	206071-1	2-16-05
WIRE PN:	M22759/111-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520/2-01 (GTC-A830)	Rhoda Marino
DIE/LOCATOR PN (GTC Tool #):	M22520/2-06 (GTC-A834)	WORK ORDER NO.
SELECTOR VALUE:	3	112044
TEST EQUIP # (Last CAL date):	APHATTION MPF 2004 (6-17-04)	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.5	13.8	13.6
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL
	Type of Separation Observed		
SLIP (pull out) {a}	✓	✓	✓
CONDUCTOR BROKEN IN CRIMP AREA (some or all) {b}			
CONTACT BROKEN IN CRIMP AREA (some or all) {c}			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) {d}			
CONTACT BROKEN OUTSIDE OF CRIMP AREA {e}			
OTHER (define) {f}			
SPECIAL INSTRUCTIONS (as reqd):			



1000

## CRIMP TENSILE STRENGTH

LAT-DS-02831-01

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	POST - PROD
CRIMP OPERATOR NAME/EMP #:	1	TEST DATE
CONTACT PN:		2/16/05
WIRE PN:		TESTED BY
CRIMP TOOL PN (GTC Tool #):	(GTC- )	Ryota Marston
DIE/LOCATOR PN (GTC Tool #):	(GTC- )	WORK ORDER NO.
SELECTOR VALUE:		112044
TEST EQUIP # (Last CAL date):	( )	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.7	13.6	13.6
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL
	Type of Separation Observed		
SLIP (pull out) {a}	✓	✓	✓
CONDUCTOR BROKEN IN CRIMP AREA (some or all) {b}			
CONTACT BROKEN IN CRIMP AREA (some or all) {c}			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) {d}			
CONTACT BROKEN OUTSIDE OF CRIMP AREA {e}			
OTHER (define) {f}			
SPECIAL INSTRUCTIONS (as reqd):			





1:10 P.M.

## CRIMP TENSILE STRENGTH CAT-05-02831-01

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	<input checked="" type="radio"/> PRE-PROD	<input type="radio"/> POST-PROD						
CRIMP OPERATOR NAME/EMP #:	Herbie Gray 1#1941	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td>TEST DATE</td><td>3.16.05</td></tr> <tr><td>TESTED BY</td><td>Herbie Gray</td></tr> <tr><td>WORK ORDER NO.</td><td>112044</td></tr> </table>	TEST DATE	3.16.05	TESTED BY	Herbie Gray	WORK ORDER NO.	112044
TEST DATE	3.16.05							
TESTED BY	Herbie Gray							
WORK ORDER NO.	112044							
CONTACT PN:	206071-1							
WIRE PN:	M22759 / 11-24-9							
CRIMP TOOL PN (GTC Tool #):	M22520 / 201 (GTC #102)							
DIE/LOCATOR PN (GTC Tool #):	M22520 / 2-06 (GTC #692)							
SELECTOR VALUE:	3							
TEST EQUIP # (Last CAL date):	Alptra MP1-200A (6-17-04)							
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:						

### OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.4	13.3	13.4
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL
Type of Separation Observed			
SLIP (pull out) {a}			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) {b}		✓	✓
CONTACT BROKEN IN CRIMP AREA (some or all) {c}			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) {d}	✓		
CONTACT BROKEN OUTSIDE OF CRIMP AREA {e}			
OTHER (define) {f}			
SPECIAL INSTRUCTIONS (as reqd):			

1:15 p.m.

**CRIMP TENSILE STRENGTH** CAT-DS-0283101

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	<input checked="" type="radio"/> PRE-PROD	<input type="radio"/> POST-PROD
CRIMP OPERATOR NAME/EMP #:	DeLoia M 1#1262	TEST DATE
CONTACT PN:	20671-1	3-16-05
WIRE PN:	M77759 / 11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M77520 / 2-01 (GTC 4-1011)	Harvie Gray
DIE/LOCATOR PN (GTC Tool #):	M77520 / 2-06 (GTC A833)	WORK ORDER NO.
SELECTOR VALUE:	3	117044
TEST EQUIP # (Last CAL date):	Hydram MPT-2001 (6-17-04)	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

**OBSERVATIONS/VALUES**

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.5	13.4	13.4
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL
	Type of Separation Observed		
SLIP (pull out) {a}			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) {b}			✓
CONTACT BROKEN IN CRIMP AREA (some or all) {c}			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) {d}	✓	✓	
CONTACT BROKEN OUTSIDE OF CRIMP AREA {e}			
OTHER (define) {f}			

SPECIAL INSTRUCTIONS (as reqd):



10:36 a.m.

for build of (E)

### CRIMP TENSILE STRENGTH *LT-15-0283/01*

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	<b>POST</b> PROD
CRIMP OPERATOR NAME/EMP #:	<i>Herbie Gray 1#1941</i>	TEST DATE
CONTACT PN:	<i>20671-1</i>	<i>3-18-05</i>
WIRE PN:	<i>M22759 / 11-24-9</i>	TESTED BY
CRIMP TOOL PN (GTC Tool #):	<i>M22520 12-01 (GTC 1102)</i>	<i>Herbie Gray</i>
DIE/LOCATOR PN (GTC Tool #):	<i>M22520 12-06 (GTC 1696)</i>	WORK ORDER NO.
SELECTOR VALUE:	<i>3</i>	<i>112044</i>
TEST EQUIP # (Last CAL date):	<i>Alabon MPF200A (6/7/04)</i>	

PULL RATE: 1" +/- .25" per min. OTHER PULL RATE:

### OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	<i>10</i>	<i>10</i>	<i>10</i>
MEASURED TENSILE STRENGTH:	<i>13.6</i>	<i>13.6</i>	<i>13.4</i>
PASS/FAIL (circle test result)	<b>PASS</b> FAIL	<b>PASS</b> FAIL	<b>PASS</b> FAIL
Type of Separation Observed			
SLIP (pull out) (a)			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) (b)	✓		
CONTACT BROKEN IN CRIMP AREA (some or all) (c)			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) (d)		✓	✓
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			

SPECIAL INSTRUCTIONS (as reqd):

11:00 A.M.

Build A (12)

CRIMP TENSILE STRENGTH CAT-DS-02381-01			
MIL-STD-1344; METHOD 2003.1			
TEST TYPE (circle one):	<input checked="" type="radio"/> PRE-PROD		POST-PROD
CRIMP OPERATOR NAME/EMP #:	Harvie Gray 1#141		TEST DATE
CONTACT PN:	206071-1		9.22.05
WIRE PN:	M22759/11-24-9		TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520/2-01 (GTC#142)		Harvie Gray
DIE/LOCATOR PN (GTC Tool #):	M22570/2-06 (GTC#553)		WORK ORDER NO.
SELECTOR VALUE:	3		112044
TEST EQUIP # (Last CAL date):	Alphatron MP-200A (6/7/04)		
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:	
OBSERVATIONS/VALUES			
SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.4	13.4	13.4
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS	<input type="radio"/> FAIL	<input checked="" type="radio"/> PASS
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# CRIMP TENSILE STRENGTH

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	<b>PRE - PROD</b>	<b>POST - PROD</b>
CRIMP OPERATOR NAME/EMP #:	Hester Gray #1941	
CONTACT PN:	206071-1	
WIRE PN:	M22759 / 11-24-9	
CRIMP TOOL PN (GTC Tool #):	M22520 / 7-01 (GTC #1012)	
DIE/LOCATOR PN (GTC Tool #):	M22520 / 7-05 (GTC #833)	
SELECTOR VALUE:	3	
TEST EQUIP # (Last CAL date):	Alpator 2004 (6/24/04)	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

TEST DATE	3.23.05
TESTED BY	Hester Gray
WORK ORDER NO.	112044

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.1	13.7	13.4
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL
Type of Separation Observed			
SLIP (pull out) (a)			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) (b)			
CONTACT BROKEN IN CRIMP AREA (some or all) (c)			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) (d)	✓	✓	✓
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			

SPECIAL INSTRUCTIONS (as reqd):





# CRIMP TENSILE STRENGTH Assy - LAI - D3 - 02831-01

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	<b>POST - PROD</b>
CRIMP OPERATOR NAME/EMP #:	Matha Villa 1742	TEST DATE
CONTACT PN:	206071-1	4-20-05
WIRE PN:	m 22759/11-249	TESTED BY
CRIMP TOOL PN (GTC Tool #):	m 22502/2-01 (GTC# 833)	Matha Villa
DIE/LOCATOR PN (GTC Tool #):	m 22520-206 (GTC# 833)	WORK ORDER NO.
SELECTOR VALUE:	3	112094
TEST EQUIP # (Last CAL date):	7-6-05 ( )	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10.0	10.0	10.0
MEASURED TENSILE STRENGTH:	13.4	13.4	13.4
PASS/FAIL (circle test result)	<b>PASS</b> FAIL	<b>PASS</b> FAIL	<b>PASS</b> FAIL
	Type of Separation Observed		
SLIP (pull out) (a)	✓	✓	
CONDUCTOR BROKEN IN CRIMP AREA (some or all) (b)			✓
CONTACT BROKEN IN CRIMP AREA (some or all) (c)			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) (d)			
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			
SPECIAL INSTRUCTIONS (as reqd):			

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELER: N/A

NO. LAT-DS-02830-01  
USG: CARLIS, TTPS I/P 1900

MO# 112043  
REQ DATE 02-03-05  
REF. DATE: 02 04 05  
SQ#  
PO# 0000048800

CUST #  
QTY 10  
PROJECT# 117300  
CUST# 15356

PAGE 1

SERIAL NUMBER LISTING

N/A

APPROVAL

PROD: KH/2/3/05  
CA: KH/2.9.05

WORKMANSHIP

ANSI-Z-39-18 CLASS 3, OTHER:  
(DEFAULT WORKMANSHIP UNLESS INDICATED OTHERWISE, ABOVE)

LOT NO.	LOT QTY	SERIAL NUMBERS	SEQ NO.	REASON	APPRV DATE
A	13	N/A	6		mm 3/1/05
B	4	N/A	6	TO move	mm 3/1/05
A <sup>2</sup>	2	N/A	6	TO move	mm 3/1/05

(whdr rev 05.19.04 gih)

LINE DEPT MACH# OP# DESCRIPTION SET-UP RUN HOURS LINE-MACH ST-LOT



200 00 CONFIG RECORD/KITTING 0.0000 0.0000 0.0000

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
 DOCUMENT NUMBER REV FD/PL OUTSTANDING EO'S  
 ASSY & PL: LAT-DS-02830 53 NONE  
 (REFERENCE ASSY/PL LAT-DS-02388 FOR RTV APPLICATION ROT)  
 TEST SPEC: N/A  
 ASSY AID: N/A  
 CUSTOMER NAME: SLAC  
 \*\*\*\*\* BUILD DOCUMENTS \*\*\*\*\*  
 USE... TRAVELER AND DRAWING  
 (REV'D)/PREP'D BY: GH (DATE) DATE: 02.03.05



DATE QTY REMARKS STATUS

2-9-05



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 2

Asst/PN: LAT-DS-02930-01  
ARBY, CABLE, TFS I/P DWR

WOB 112043  
REQ DATE 02-09-05  
REL DATE 02-03-05  
COST 0000048600

CUST P#  
QTY 19  
PROJECT# P17300  
CUST# 15356

LI# DEPT MACH# OP# DESCRIPTION..... HOURS  
SET UP RUN... LINE-MACH ST-LOT



2 201 00 STOCKROOM/KITTING AREA 0.0000 0.0000 0.0000  
KIT PARTS/MATERIALS

\* WIRE, CRIMP PINS, CONNECTOR, AND RTV.

21905-19

REMARKS.....

STATUS

*Handwritten signature/initials*

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

AL / PNA LAT-DS-02930-01  
ASSY. CABLE, TPS 1/1 PWR

WOB 112043  
REQ DATE 02-09-05  
REL DATE 02-03-05  
SO#  
PO# 000048800

CHART #  
QTY 10  
PROJECT# P17300  
CUST# 14356

PAGE 3

LT# DEPT MACH# OP# DESCRIPTION..... SET-UP HOURS  
RUN... LINE-MACH ST-LOT



1 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
CUT WIRE, STRIP WIRE,  
CRIMP PIN CONTACTS,  
TIN LEADS.

..... THIS LEAD ASSY USES TWISTED-PAIR (RED/WHT) WIRE .....  
\* CRIMP TEST SETUP - GTC-2081.

CUT 6 PIECES OF WIRE @ 6" TO 9" LONG, FOR PULL TESTS.  
USE 3 PCS EACH FOR PRE-CRIMP AND POST-CRIMP TESTS.

\* STRIPPING METHOD -- ALL ASSEMBLY AND TEST ACTIVITY...

... USE SCHEIDTGER INSERMATIC WIRE STRIPPER SET UP WITH  
24 AWG STRIP BLADES, A STRIP LENGTH OF 1/8" (1.125"),  
AND LEAVES THE INSULATION SLUG IN PLACE.

*ELBAMPS SMALL MCAZ #4900-1*  
*1/11 (1.125")*

\* PRE-ASSY CRIMP TEST...

STRIP AND CRIMP THREE CONTACTS USING TEST WIRE. TEST THE  
SAMPLE CRIMPS PER GTC-2081. RECORD RESULTS. IF FAIL,  
CONTACT ENGINEERING.

CRIMP TEST: BY: Rm1970 DATE: 2/17/05 STATUS Pass

\* ASSEMBLY ACTIVITY...

- 1) FEED WIRE DIRECTLY OFF THE SPOOL TO THE STRIPPER.
- 2) STRIP THE INSULATION LEAVING THE SLUG, 1/8" (1.125").
- 3) CUT THE WIRE OFF AT THE INDICATED LENGTH, AND QUANTITY.  
\* CUT 10 PAIRS TO 9-1/2" (9.50") LONG.
- 4) STRIP SECOND END USING THERMAL TWEEZERS, 1/4".
- 5) TIN SECOND END BY SOLDER DIP. CLEAN WITH ALCOHOL.
- 6) PULL INSULATION SLUG AND CRIMP CONTACT (220) ONTO LEAD.  
USE M22520-2-01 CRIMPER W/ M22520-2-03 TURRET/LOCATOR.

*1/11 (1.125")*

*116-3.8.05 #1941*  
*L.H. 3/8/05*  
*205 (Q.A.)*

\* POST-ASSY CRIMP TEST...

STRIP AND CRIMP THREE CONTACTS USING TEST WIRE. TEST THE  
SAMPLE CRIMPS PER GTC-2081. RECORD RESULTS. IF FAIL,  
CONTACT ENGINEERING.

CRIMP TEST: BY: Rm1970 DATE: 2/18/05 STATUS Pass

DATE	QTY	REMARKS	STATUS
2/18/05	4	4 sets of 10 - 10	Rm1970
3/8/05	1	1 set of 10 - 10 (Rework)	Cvi1920
3/17/05	2	2 set of 10	MV, DM, mm. (60?)
3-16-05	4	set of 10	MV 1743
3/16/05		4 sets of 10 strip only	

WORK CELL: 4-MIXED

CUSTOMER: SLAC

7 PRODUCTION

WORK ORDER TRAVELLER - NEW

MOU/PNS 1AT-05-02810-01  
ASSY, CADIR, TFS I/P PWR

WOP 112043  
REQ DATE 02-09-05  
DEL DATE 02-03-05  
COST 0000048800

PAGE 4  
COST P#  
QTY 10  
PROJECT# F17300  
CUST# 15356

LI# DEPT MACH# OP# DESCRIPTION..... HOURS  
SET UP RUN... LINE-MACH ST-LOT



4.290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OFF: SLDR-20 ASSY-R0

- \* INSPECT WIRE COUNT, STRIPS, CRIMPS, TINNING, AND CLEANING.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DR#(S)

DATE	QTY	REMARKS	STATUS
2/22/05	40/300		STRIPPED
3/1/05	10	Restripped ok	SLV



5.210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0100  
INSERT WIRES AND CONTACTS TO CONNECTOR

- \* INSERT TERMINATED WIRES TO CONNECTOR IN POSITIONS 1-20.

WIRE PAIR	CLR	PIN#
PAIR #1	WHT	1
	RED	3
PAIR #2	WHT	3
	RED	4
PAIR #3	WHT	5
	RED	6
PAIR #4	WHT	7
	RED	8
PAIR #5	WHT	9
	RED	10
PAIR #6	WHT	11
	RED	12
PAIR #7	WHT	13
	RED	14
PAIR #8	WHT	15
	RED	16
PAIR #9	WHT	17
	RED	18
PAIR #10	WHT	19
	RED	20

- \* FILL THE REMAINING OPEN POSITIONS WITH AN UNUSED CONTACT.  
(REMAINING OPEN LOCATIONS - 21, 22, 23, 24, 25, 26.)

...ASSURE CONTACT IS SEATED AND LOCKED INTO CONNECTOR.

DATE	QTY	REMARKS	STATUS
3.8.05	1	complete	H.6.#1941
3.16.05	2	complete	H.6.#1941

WORK CELL: 4-MIXED

CUSTOMER: SIAC

TV PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSEMBLY # 1AT-DS-02830-01  
ASSY. CABLE, TFS 1/P PWR

WO# 112043  
REQ DATE 02-09-05  
REL DATE 02-03-05  
SO#  
PO# 0000048600

CUST PM  
QTY 10  
PROJECT# F17300  
CUST# 16356

PAGE 5

LT# DEPT MACH# OP# DESCRIPTION..... SET-UP RUN... HOURS LINE-MACH ST-LOT.



A 200 00 QUALITY ASSURANCE AREA  
OPER SLDR-0 ASSY-26 0.0000 0.0000 0.0000

- INSPECT LEAD AND CONTACT INSERTION TO CONNECTOR.
- RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DRR#(S)

DATE 3/8/05 QTY 1 REMARKS..... STATUS KH.285

DATE 3/9/05 QTY 3 REMARKS.....  
DATE 3/14/05 QTY 2 REMARKS.....



7 210 00 CCA/BLACK BOX ASSY AREA  
POT WIRES AT CONNECTOR. 0.0000 0.0000 0.0000

- APPLY RTV, DC6-1104, TO WIRES EXITING CONNECTOR SHELL, FROM THE SHELL DOWN THE WIRES 1/2" (1.9").
- TRANSFER RTV TO AN EPD SYRINGE TUBE, OR PLUNGER TYPE SYRINGE, TO AID APPLICATION.
- ALIGN WIRES WITH KAPTON TAPE IN AN AREA ABOUT 2 TO 4 INCHES AWAY FROM THE CONNECTOR. THIS IS INTENDED TO KEEP WIRES COMING STRAIGHT OUT OF THE CONNECTOR, AS AN AID FOR LATER TERMINATION TO THE CCA.
- APPLY RTV TO CONNECTOR BACKSHELL SURFACE, AT INSIDE ROWS FIRST, WORKING OUT, AND UP, TO THE APPROXIMATE 1/2" POINT.

RECORD RTV MATERIAL PPM AND EXPIRATION DATE BELOW:  
PPM 31695 EXP. DATE 7-10-2005

- WIRE APPLIED RTV IN OVEN FOR 2 HOURS AT 120 DEG F (40 C).
- RECORD CURE DATE, START/STOP TIME BELOW:

DATE \_\_\_\_\_ START \_\_\_\_\_ STOP \_\_\_\_\_

DATE 3-16-05 QTY 2 REMARKS..... STATUS ME/PM 1262

CLEAR Defect Report #29541  
for 8 wires  
M.B. 2-25-05

3-14-05 22 17 post clips  
and tin rod length



air cured overnight.  
MC 3-17-05



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

W.../FN: LAT-DS-02830-01  
ASSY. CABLR, TPS I/P PWR

WOB 112043  
REQ DATE 02-03-05  
REL DATE 02-03-05  
SOP  
POM 0000048800

UNIT #  
QTY 10  
PROJECT# F17300  
COST# 19356

PAGE 4

\*\*\*\*\*  
LT: DEPT MACH# OP# DESCRIPTION..... HOURS  
SET-UP RUN... LINE-MACH ST-LOT.



8 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OPE: SLDR-0 ASSY-7

- \* INSPECT FOTTING/CURING OF LEAD ASSEMBLY.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DR#(S) \_\_\_\_\_

- \* ROUTE FOR WQ CLOSURE AND NEXT ASSY - LAT-DS-02389.

DATE	QTY	REMARKS	STATUS
3/12/05	2		OK

WORK ORDER : 112043

( NEW )

WORK ORDER PICK LIST

PAGE: 1

ASSEMBLY # : LAT-DS-02830-01  
QUANTITY : 19  
LOCATION: W02

BY LINE ITEM

EFFECTIVITY DATE: 02-08-05  
RELEASE DATE : 02-03-05  
DATE PRINTED : 02-09-05

DATE PULLED: \_\_\_\_\_

PULLED BY: \_\_\_\_\_

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIREMENTS		ASSY IN LOT #	INVLOC NUMBER	INVENTORY DETAIL		
			REQUIRED QUANTITY	CURR STATUS			LOT	LOT DATE	BIN
1	<del>206500</del> CONN (311P407-2P-B-15) ORIGINAL QUANTITY...	EA	1.00	BO	19.00	SKCF2 FN-1	0.00		
			19.00						

S/B LAT-DS-02830

PULLED: 1 0 19

The following parts have been defined as alternates for 206500-1:  
LIS 1.1 311P407-2P-B-15 1 PER

107# 114944

2	M22759/11-24-2/9 WIRE, 24AWG RED/WHIT ORIGINAL QUANTITY...	IN	300.00	RSVD	5700.00	115300	SKCF2 FN-2	11997.00	10-01-04
			5700.00						

5700 in

3	204370-8 PIN, CRIMP ORIGINAL QUANTITY...	EA	20.00	RSVD	380.00	114796	SKCF2 FN-3	451.00	09-23-04 IN ASSY
			380.00						

380

						115041	SKCF2 FN-3	32.00	09-27-04 F17200

The following parts have been defined as alternates for 204370-8:  
LIS 3.1 GOSP1 1 PER

4	DC6-1104 ADHESIVE ORIGINAL QUANTITY...	OZ	1.00	BO	19.00		SKCF2	0.00	
			19.00						

REQUIREMENT SHOWS ON LAT DS-02830.  
APPLY HERE.  
PULLED: 0

Assy

# CRIMP TENSILE STRENGTH LAT-DS-02830-01

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	<b>POST - PROD</b>
CRIMP OPERATOR NAME/EMP #:	Martha Villa 1112	TEST DATE
CONTACT PN:	204370-8	3-16-05
WIRE PN:	1732157/11-21-2/9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	1732530 12-01 (GTC-A 1014)	113043
DIE/LOCATOR PN (GTC Tool #):	1732530 12-01 (GTC-A 831)	WORK ORDER NO.
SELECTOR VALUE:	3	Martha Villa
TEST EQUIP # (Last CAL date):	( )	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10.0	10.0	10.0
MEASURED TENSILE STRENGTH:	12.6	12.5	12.4
PASS/FAIL (circle test result)	<b>PASS</b>	FAIL	<b>PASS</b>
	FAIL	<b>PASS</b>	FAIL
	<b>PASS</b>	FAIL	<b>PASS</b>
	FAIL	<b>PASS</b>	FAIL
Type of Separation Observed			
SLIP (pull out) (a)			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) (b)	✓	✓	✓
CONTACT BROKEN IN CRIMP AREA (some or all) (c)			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) (d)			
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			

SPECIAL INSTRUCTIONS (as reqd):





# DEFECT RECORD REPORT

ID 29547

PART NUMBER: LAT-05-02830-01

INSPECTION TYPE: CRIMPING

OFE SOLDER: 20

WORK ORDER: 112043

INSPECTION LEVEL: 1

OFE ASSEMBLY: 30

SALES ORDER: F17300

INSPECTOR: VANDEVER

DATE: 2/22/2005

QUANTITY: 40 RW QTY: 8

WEEK CODE: 10

CUSTOMER: SLAC

SERIAL NO	QUANTITY	OPERATOR	DEFECT CODE	WORKCELL	DEFECT DESCRIPTION	REF DES	PINNOTES
NA	2	1970	A315	4-MIXED	CUTS OR NICKS	WIRES	Twisted wires. Feed/wire
NA	6	1970	A325	4-MIXED	IMPROPER CABLE LENGTH	WIRES	Twisted wires. Red/wire

*Em...*

3/8/05

WORK CELL: 1-310 RUNNER

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 1

/FN# LAT-DS-01481  
MAY, GLAST. FAC. - RV

WOB 111113  
REQ DATE 04-29-05  
REL DATE 04-04-05  
SOM F11200  
PCW 0000048799

CUST #  
QTY  
FRACLEN  
CUST#

\*\*\*\*\*SERIAL NUMBER\*\*\*\*\*  
G-T112 GLATISCI

\*\*\*\*\*APPROVAL\*\*\*\*\*  
FROM RLH/4/27/05  
CA/4/27/05

\*\*\*\*\*WORKMANSHIP\*\*\*\*\*  
IPC/EIA-3-STD-001C CLASS 3; WITH "CS" SPACE SUPPLEMENT  
SLAC CAR MAY CHOOSE TO AUDIT/OBSERVE PROCESS PERFORMANCE  
OF ANY STEP OF THE TRAVELER/WORK ORDER. SLAC CAR MAY  
INDICATE OBSERVATIONS BY STAMP MARKING AT THE STEP.

\*\*\*\*\*PIN IS 12.04\*\*\*\*\*

LINE DEPT MACH# QPH DESCRIPTION ..... HOURS  
SEC-UP RUN. LINE-MACH ST-LOC



1 200 00 CONFIG RECORD/KITTING 0.0000 0.0000 0.0000  
CONFIG

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
ASSY ING DOCUMENT NUMBER REV FO/PL OUTSTANDING EC'S  
BOM PL LAT-DS-01481 04 NONE  
(CAMS - ON DWG)  
CUST SCH. LAT-DS-02815 03 NONE  
PSS TEST: (N/A THIS LEVEL)  
ASSY AID: LAT-DS-01481 (RELEASED PER EC 2419)  
CUSTOMER NAME: SLAC (STANFORD LINEAR ACCELERATOR CENTER)  
BUILD DOCUMENTS  
USE ... WORK ORDER, CONTROLLED ASSEMBLY AID, & DRAWINGS  
\*\*\* SEE FOOTER OF WORK ORDER FOR REV HISTORY \*\*\*

DATE QTY REMARKS STATUS  
4/27/05 \_\_\_\_\_ RLH



2 201 00 STOCKROOM/KITTING AREA 0.0000 0.0000 0.0000  
KITTING

\*\*\*\*\* PROCESS MATERIAL PER CAR STEP 2. \*\*\*\*\*

DATE QTY REMARKS STATUS  
4/27/05 \_\_\_\_\_ RLH





TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PN# LAT-DS-01481  
CLAST, DAD, TEM

WOB# 113113  
REQ DATE 04-28-05  
REL DATE 04-24-05  
SCT 117200  
POL 0333048753

CUST #  
CITY 1  
PROJ# 1173300  
COST# 180826

LINE DEPT MACH# QP# DESCRIPTION..... H O U R S  
SET-UP RUN... LINE-MACH ST-LOT



3 212 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
APPLY ADHESIVE

- PROCESS ASSY PER CAA STEP 3.
- RECORD ADHESIVE DATA BELOW.

OTC PO# 32131 EXP. DATE 10/01/05  
 LOT # S: (PT A) 32775 (PT B) 32775  
 MIX RECORD (PART A WGHT) 15gr (PART B WGHT) 1gr

DATE	QTY	REMARKS	STATUS
<u>04/24/05</u>	<u>1</u>		<u>Exp (1280)</u>



4 212 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
LOG CCA IN TO WORK ORDER  
CHASE SCREW THREADS  
INSTALL CCA TO BOX

- PROCESS ASSY PER CAA STEP 4.
- INSTALLED CCA SERIAL NUMBER: G-T 112

DATE	QTY	REMARKS	STATUS
<u>04/24/05</u>	<u>1</u>		<u>Exp (1280)</u>



5 212 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
TORQUE FASTENERS.

- PROCESS ASSY PER CAA STEP 5.
  - ALERT SLAC QAR TO WITNESS TORQUE PROCESS.\*\*
  - RECORD ASSIGNED TOOLS USED, AND CAL DUE DATE, BELOW.
- TORQUE TOOL # GTC-95112  
 OTD-E-946 CAL DUE DATE 05/05

DATE	QTY	REMARKS	STATUS
<u>04/24/05</u>	<u>1</u>		<u>Exp (1280)</u>
<u>04.10.05</u>	<u>1</u>	<u>WITNESS TORQUE</u>	<u>LAT TO 03</u>

WORK CELL: 1-DIG RUNNER

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - N&W

PAGE 1

PN# LAT-DS-01461  
U. GLAST. DAG. TEM

WCR 113113  
REQ DATE 04-29-05  
REL DATE 04-04-05  
COP# 017201  
PC# 000046799

CUST #  
QTY 1  
PROJECT# 217201  
CURTS 19356

LINE DEPT MACH# OP# DESCRIPTION SET-UP RUN... LINE-MACH ST-LOT



6 210 00 CCA/BLACK BOX ASSY AREA  
SOAK BOLT HEADS. 0.0000 0.0000 0.0000

- PROCESS ASSY PER CAA STEP 6.
- RECORD MATERIAL DATA BELOW:

ADHSV 1151: GTC P# 31403 EXPIRATION DATE 01/31/07  
CURE DATE/TIME: START 06/13/05 8:30AM STOP

DATE	QTY	REMARKS	STATUS
06/13/05	1		ByP(1288)



7 210 00 CCA/BLACK BOX ASSY AREA  
ASSY MARKING 0.0000 0.0000 0.0000

- PROCESS ASSY PER CAA STEP 7.
- RECORD MATERIAL DATA BELOW:

INK 50-100R: GTC P# 31201 EXPIRATION DATE 04/27/07

LOT # (PT A): 200409086033

LOT # (PT B): 200407020071

MIX RECORD (PT A WGT): 10gr (PT B WGT): 0.6gr

MARKING DATE/TIME: 06/13/05

CURE OCCURS AT STANING STEP 13.

DATE	QTY	REMARKS	STATUS
06/13/05	1		ByP(1288)



8 210 00 QUALITY ASSURANCE AREA  
DEF. PDR-0 ASSY-127 0.0000 0.0000 0.0000

- PROCESS ASSY PER CAA STEP 8.

RECORD DEFECT REPORT NO. IF APPLICABLE:

DATE	QTY	REMARKS	STATUS
6/13/05	1		

WORK CELL: 1-RIG RUNNER

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 4

PN# LAT-D9-11481  
PLANT: DAO, TEM

MO# 113113  
REQ DATE 04-29-05  
REL DATE 04-04-05  
CO# P17200  
PO# 0000048799

CUST #  
PROJ# 1  
COST# 177200  
COST# 13386

LT# DEPT MACH# OP# DESCRIPTION ..... H O U R S  
SET-UP MIN... LINE-MACH ST-LOT



00 00 SOURCE INSPECTION EXAMINE BOX ASSY 0.0000 0.0000 0.0000

- PROCESS ASSY PER CAA STEP 9.
- EXAMINE BOX ASSEMBLY PRIOR TO CLOSE.

DATE	QTY	REMARKS	STATUS
6.13.05	1	GLAT 1801	LAT 1801



00 00 COA/BLACK BOX ASSY AREA INSTALL LID 0.0000 0.0000 0.0000

- PROCESS ASSY PER CAA STEP 10.

DATE	QTY	REMARKS	STATUS
06/13/05	1		Byp (1288)



00 00 COA/BLACK BOX ASSY AREA TORQUE FASTENERS 0.0000 0.0000 0.0000

- PROCESS ASSY PER CAA STEP 11.
  - ALERT SLAC CAR TO WITNESS TORQUE PROCESS...
  - RECORD ASSIGNED TOOLS USED, AND CAL DUE DATE, BELOW.
- TORQUE TOOL # GTC-A-977 / GTC-E-9511/2  
 GTC-B-944 CAL DUE DATE 01/26/06 08/05

DATE	QTY	REMARKS	STATUS
06/13/05	1		Byp (1288)
6.13.05	1	WITNESS TORQUE	



00 00 QUALITY ASSURANCE AREA (FF-STD-C ASSY-94) 0.0000 0.0000 0.0000

- PROCESS ASSY PER CAA STEP 12
- RECORD DEFECT REPORT NO. IF APPLICABLE:

DATE	QTY	REMARKS	STATUS
6/13/05	1		



WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

TYPE PRODUCTION

WORK ORDER TRAVELLER - NEW

Assy: GLAT, D42, TEM

NO# 113113  
REV. DATE 04-29-05  
REV. DATE 04-04-05  
C# 017800  
C# 0000000199

CUST #  
QTY 1  
PROJECT # 113113  
CUST# 101200

PAGE 5

LINE DEPT MACH# OP# DESCRIPTION ..... HOURS  
SET-UP RUN... LINE-MACH ST-LDD



13 210 00 CAA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE BOLT HEADS

- PROCESS ASSY PER CAA STEP 13.
- RECORD MATERIAL DATA BELOW:

ADRSV 0151: GTC NO# 31403 EXPIRATION DATE 01/31/07  
CURE DATE/TIME: START- 06/13/05 4:30<sup>PM</sup> STOP- 6:30<sup>PM</sup>

DATE	QTY	REMARKS	STATUS
06/13/05	1		Buy(288)



14 200 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CPE- SLDR-0 ASSY-37

- PROCESS ASSY PER CAA STEP 14.

RECORD DEFECT REPORT NO. IF APPLICABLE: \_\_\_\_\_

DATE	QTY	REMARKS	STATUS
6/14/05	1		



15 240 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
CUSTOMER SOURCE INSP

- PROCESS ASSY PER CAA STEP 15:

RECORD DEFECT REPORT NO. IF APPLICABLE: \_\_\_\_\_

DATE	QTY	REMARKS	STATUS
6/14/05	1	GLAT 1801	

TRAVELLER REVISION HISTORY RECORD

CREATED BY: \_\_\_\_\_ FOR ASSY REV: \_\_\_\_\_ DATE: 03.21.05

REV	BY	DATE	CHANGE DETAIL
54	TFH	03/21/05	RELEASED AT REV 54. NOT CAA AT REV

\*\*\*\*\*END OF TRAVELLER REVISION RECORD\*\*\*\*\*

WORK ORDER 113113

NEW

WORK ORDER PICK 1130

PAGE 1

WFLY # 1AT-DS-01460  
ACTIVITY  
LOCATION 402

BY LINE ITEM

INSPECTIVITY DATE: 0041-01-01  
RETRACT DATE: 0041-01-01  
DATE PRINTED: 0041-01-01

DATE FILLED:

FILLED BY:

LINE	PART NUMBER AND DESCRIPTION	EA	REQUIRED QTY	REQUIREMENTS		RESV IN LOT #	INVLOC NUMBER	LOT	INVENTORY DETAIL			
				QTY	STATUS				QTY	LOT	DATE	BIN
1	LAT-DS-01464 TEM BOX BASE ORIGINAL QUANTITY...	EA	1.00	1.00	RSVD	120298	SK2 FN-1 PULLED	0.00	15.0	12-16-04	SLAC	
							SKCF2 PULLED:					
2	LAT-DS-01466 TEM BOX BASE ORIGINAL QUANTITY...	EA	1.00	1.00	RSVD	120297	SK2 FN-1 PULLED	0.00	15.0	12-16-04	SLAC	
							SKCF2 PULLED:					
3	LAT-DS-01464 OCA SLAC TEM ORIGINAL QUANTITY...	EA	1.00	1.00	BO		SK2 FN-3 PULLED	0.00				
							SKCF2 PULLED:					
4	NA01352N03184 HARDWARE ORIGINAL QUANTITY...	EA	26.00	26.00	RSVD	114831	SK2 FN-4 PULLED	0.00	27.0	09-23-04		
							SKCF2 PULLED:					
	NA01352N04-6 SCREEN ORIGINAL QUANTITY...	EA	29.00	29.00	RSVD	114832	SK2 FN-5 PULLED	0.00	187.00	09-23-04	LOC 118	
							SKCF2 PULLED:					
									712.00	09-27-04	IN ASSY	
									100.00	04-13-05		
5	NA01352N1-8 HARDWARE ORIGINAL QUANTITY...	EA	1.00	1.00	RSVD	114833	SK2 FN-6 PULLED	0.00	21.0	09-23-04		
							SKCF2 PULLED:					
6	WFLY-2448 WFLY-2448 TEM ORIGINAL QUANTITY...	OC	1.00	1.00	BO		SK2 FN-7 PULLED	0.00				
							SKCF2 PULLED:					





WORK CELL: 4-MIXED

CUSTOMER: SLAC

7: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 1

WPN# LAC-DS-01646  
CAA, GLASGOW, IEM

NO# 118012  
WRO DATE 02-03-05  
WREL DATE 12-01-04  
SCL#  
PCV 0001049799

CUST PA  
CITY 1  
PROJECT# 811200  
CUST# 10006

SERIAL NUMBER: GT112  
APPROVAL: GT 2/3/05  
WMA 2/3/05  
GLAT 1763

MEMBERSHIP: 1P2-DIA-C-STD-2010 CLASS 3, WITH '00' SPACE SUPPLEMENT  
SLAC CAR MAY CHOOSE TO AUDIT/OBSERVE PROCESS PERFORMANCE  
OF ANY STEP OF THE TRAVELER/WORK ORDER. SLAC CAR MAY  
INDICATE OBSERVATIONS BY STAMP MARKING AT THE STEP  
\*12.02.05\*

LINE DEPT MATHS OPS DESCRIPTION HOURS  
SET-UP RUN... LINE-MACH ST-LOC



1 200 00 CONFIG RECORD/KITTING 0.0000 0.0000 0.0000  
CONFIG

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
DOCUMENT NUMBER REV ED/ED OUTSTANDING ED'S  
ASSY DWG. 118012 04 NONE  
BOM PL 118012 04 NONE  
TEST SW: 118012 04 NONE  
SERV AID: 118012 04 NONE  
CUSTOMER NAME: SLAC (RELEASED PER EC 0083)  
STANFORD LINEAR ACCELERATOR CENTER  
BUILD DOCUMENTS  
USE WORK ORDER, CONTROLLED ASSEMBLY AID, & DRAWINGS.  
\* (REV'D)/PREP'D BY: GH (DATE) DATE: 02 02 05 \*

DATE	QTY	REMARKS	STATUS
2-7-05			WMA



1 201 00 STOCKROOM/KITTING AREA 0.0000 0.0000 0.0000  
KIT PARTS

- PROCESS PER CAA STEP 2.
- ALL HARDWARE, NON-SMT PARTS, AND CONSUMABLE MATERIALS, ARE TO BE COLLECTED AND MOVED TO POST-SMT PROCESSING.
- ALL SMT PARTS MOVE THROUGH THE SMT DRY ROOM.

DATE	QTY	REMARKS	STATUS
2/11/05			WMA

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 2

WNS LAT-DS-01646  
CAA: BLAST, TEM

W# 112012  
REV DATE 02-03-05  
REL DATE 12-21-04  
SCA  
PO# 001049799

CUST #  
PROJECT# 17400  
CUST# 13356

LINE DEPT MACH# OP# DESCRIPTION..... H O U R S  
SET-UP RUN... LINE-MACH SC-LOC.



3 213 00 CCA/BLACK BOX ASSY AREA BOARD MARKING 1.3300 1.3300 1.3300

\* PROCESS PER CAA STEP 3.

DATE	QTY	REMARKS	STATUS
2-7-05	1		PF



4 213 00 SMT ASSY LINE PRE-SMT OVEN BAKE 2.0000 2.0000 2.0000

\* PROCESS PER CAA STEP 3

BAKE DATE: 2-7-05  
START TIME: 11:00 AM  
STOP TIME: 1:00 PM

DATE	QTY	REMARKS	STATUS
2-7-05	1	10	OK 1648
2-7-05		Out	OK



5 213 00 SMT ASSY LINE SOLDER PASTE STENCIL ONLY TOP SIDE GETS PARTS 5.6300 5.6300 5.6300

\* PROCESS PER CAA STEP 5.

\* RECORD SOLDER PASTE DATA BELOW

OTC PO# 31768 EXPIRATION DATE 7/5/07

DATE	QTY	REMARKS	STATUS
2-7-05	1		PF 1600

1156 - .0065  
 453 - .0065  
 R391 - .0065  
 C361 - .0065  
 C374 - .0065  
 1153 - .0061  
 1152 - .0061  
 1158 - .0062

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TRMT: PRODUCTION

WORK ORDER TRAVELLER - NEW

ENY LAT-DS-0164A  
COAT CLAST. TEM

W# 112013  
RDO DATE 02-13-05  
REL DATE 12-21-04  
ROR  
POR 0000148799

PAGE 3  
CUST #  
QTY  
PROJECT# 417200  
CUST# 19359

LINE DEPT MACH# OP# DESCRIPTION..... M O U A S  
SET-UP RIN... LINE-MACH ST-LOT



6 213 00 SMT ASSY LINE PICK-N-PLACE PARTS 10 0000 10.0000 10 1000

\* PROCESS PER CAA STEP 6

\*\* RECORD SERIAL NUMBERS OF LISTED ASIC DEVICES:

FN-19 US 1693 IN 1795 US 1692 US 1687  
FN-23 US4 1685 US5 1695 US6 1697 US7 1711  
US9 1675 US0 1678 D40 1701 US2 1700

DATE... QTY... REMARKS..... STATUS  
2-9-05 1 70-11 BF 150



7 213 00 SMT ASSY LINE SPIDER REFLOW 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 7.

\*\* DO NOT LET BOARD SIT OVERNIGHT WITHOUT CLEANING \*\*

DATE... QTY... REMARKS..... STATUS  
2/9/05 1 WA



8 213 00 SMT ASSY LINE AQUEOUS CLEAN 0.1000 0.1000 0.1000

\* PROCESS PER CAA STEP 8.

\*\* RECORD WASH EVENT ON LOG PER EA-24

DATE... QTY... REMARKS..... STATUS  
2/9/05 1 WA



WORK CELL 4 MIXED

CUSTOMER: SLAC

WORK: PRODUCTION

WORK ORDER TRAVELLER - NEW

ENR LAT-05-01548  
CCA, BLAST, T&M

WOB 112010  
R&D DATE 12-13-04  
REL. DATE 12-11-04  
PCE 0000048793

CUST PR  
PROJECT 1  
COST# 151200  
COST# 16185

PAGE 4

LINE DEPT MACH# OP# DESCRIPTION SET-UP HOURS RUN... LINE-MACH ST-LOT



9 290 00 QUALITY ASSURANCE AREA 0.4400 0.4400 0.4400  
OFF: SLDR-4163 ASSY-8203

\* PROCESS PER CAA STEP 9.

\*\* RECORD DEFECT RECORD NUMBER(S) BELOW:

ERR# (S)

29535

DATE QTY. REMARKS  
2/19/05 1 112



10 310 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
PRE-WAVE BAKEOUT

\* PROCESS PER CAA STEP 10.

BAKE DATE: 3/30/05 START: 10:40 STOP: 12:40

DATE QTY. REMARKS STATUS  
3/30/05 1 1337



11 310 00 CCA/BLACK BOX ASSY AREA 2.4000 2.4000 2.4000  
THRU-HOLE INSTALL

\* PROCESS PER CAA STEP 11.

\*\* RECORD ASSIGNED TOOL# USED, AND CAL DUE DATE, BELOW:

TOOL: GTC A-912 CAL DUE DATE 8/5 (ASC-BOX) GTC-E-744

DATE QTY. REMARKS STATUS  
3/30/05 1 1337



12 318 00 WAVESOLDER 0.5000 0.5000 0.5000  
WAVE SOLDER

\* PROCESS PER CAA STEP 12.

DATE QTY. REMARKS STATUS  
3-30-05 1 75

WORK CELL: 8-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 3

/BNS LAT-DG-01045  
CCA, BLAST, TEM

WOP# 112012  
REC DATE 02-03-05  
WRL DATE 12-21-04  
COP#  
PO# 0010048799

CUST #  
PROJECT# 417200  
CUST# 123200

LINE DEPT MACH# QTY DESCRIPTION ..... H O U R S  
SET-UP RUN... LINE-MACH ST-LOT



13 215 00 WAVESOLDER 0.0000 0.0000 0.0000  
CONTINUOUS CLEAN

\* PROCESS PER CAA STEP 13.

DATE	QTY	REMARKS	STATUS
3/30/05	1	112	nr 1337



14 200 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CPE: SLDK-600 ASSY-55

\* PROCESS PER CAA STEP 14.

\*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW:

DEF#(S)

DATE	QTY	REMARKS	STATUS
3/31/05	1		nr



15 110 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
TOUCHUP

\* PROCESS PER CAA STEP 15.

DATE	QTY	REMARKS	STATUS
3/31/05	1		nr 1337



16 200 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
AT CONCL/DI CLEAN

\* PROCESS PER CAA STEP 16.

DATE	QTY	REMARKS	STATUS
3/31/05	1		nr 1337

WUAK CELL 4-MIXED

CUSTOMER: SLAC

TITLE: PRODUCTION

WORK ORDER TRAVELER - NEW

4/20# INT-DS-01646  
CAA: GLAST, TEM

WOB# 112012  
RDO DATE 02-03-05  
REL DATE 12-21-04  
SCH  
POS 0000048799

COST P#  
PROCESOR# 1071800  
CUST# 10390

PAGE 6

17# DEPT MACH# OF# DESCRIPTION..... H O U R S  
SET-UP RUN... LINE-MACH ST-LOT



17 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0010  
OF# 810R-200 ASSY-0

\* PROCESS PER CAA STEP 17.

\*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW:

ERR#(S): \_\_\_\_\_ S/N 112

DATE	QTY	REMARKS	STATUS
3/21/05	1		OK
_____	_____	_____	_____
_____	_____	_____	_____



18 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0010  
POST WAVE ASSY-FPGAS

\* PROCESS PER CAA STEP 18:

ADHESIVE POC 31450 EXP DATE 5/17/05  
FPGA SERIAL #19, U45 40506 U62 50148

DATE	QTY	REMARKS	STATUS
5/4/05	1		OK
_____	_____	_____	_____
_____	_____	_____	_____



19 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0010  
SOLDER FPGA LEADS

\* PROCESS PER CAA STEP 19:

DATE	QTY	REMARKS	STATUS
3/4/05	1		OK 1337
_____	_____	_____	_____
_____	_____	_____	_____



20 210 10 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
POST WAVE ASSY-DS, D4, D5

\* PROCESS PER CAA STEP 20:

DATE	QTY	REMARKS	STATUS
5/4/05	1		OK 1337
_____	_____	_____	_____
_____	_____	_____	_____



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 7

WIP/ENR DATE: 05-01-04  
CAA, GLAST, CM

WOB 111000  
REQ DATE 02-03-05  
REL DATE 12-21-04  
SCY  
PO# 000018799

CUST #  
QTY 1  
PROJECT# 717000  
COST# 15355

LINE DEPT MACH# OFF DESCRIPTION SET-UP RUN... LINE-MACH ST-DCT



21 210 00 CCA/BLACK BOX ASSY AREA  
POST WAVE ASSY-R1, R2 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 21.

DATE	QTY	REMARKS	STATUS
5/4/05	1	S/A 112	core 1337



22 217 00 CCA/BLACK BOX ASSY AREA  
ALCOHOL/OI CLEAN 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 22.

DATE	QTY	REMARKS	STATUS
5/4/05	1		



23 290 00 QUALITY ASSURANCE AREA  
DPE: SLDK-217 ASSY-217 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 23.

\*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DRR#(S)

DATE	QTY	REMARKS	STATUS
5/5/05			



24 045 00 SPEA IOT  
SPEA TEST 0.0100 0.0100 0.0100

\* PROCESS PER CAA STEP 24

\*\* RECORD TEST DEFECT RECORD REPORT NUMBER(S) BELOW.

TRF# S: 24626

DATE	QTY	REMARKS	STATUS
05/07/05	1	SN: G7112	failed
05/04/05	1	SN: G7112	passed



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 9

WPN: LAD-DS-01646  
CCA: GLAST, TEM

WPN# 113012  
MATERIAL DATE 12-01-05  
MATERIAL DATE 11-11-04  
PDR# 0000048799

CUST # 1  
PROJECT# 1  
COST# 101000  
10300

LINE DEPT MACH# OP# DESCRIPTION ..... HOURS  
SET-UP RUN... LINE-MACH ST-LOT



27 200 00 COATING/POTTING AREA  
POTTING/STAKING 0.6000 0.6000 0.6000

- \* PROCESS PER CAA STEP 27.
- \*\* RECORD MATERIAL DATA BELOW:

RTV DCS-2104, QTY PO# 31695 EXPIRATION DATE 8-21-05  
ADHBY 3151, QTY PO# 31403 EXPIRATION DATE 1-31-07

WISS AGGRESSIVE MIX RECORD (RECORD PER BATCH)

	BATCH #1	BATCH #2	BATCH #3	BATCH #4
RESIN WGT	<u>6.5g</u>			
HARDENER WGT	<u>2.0g</u>			

CURE DATE: 5-13-05 START: 7:50 10:10 STOP: 8:50 12:10

DATE	QTY	REMARKS	STATUS
<u>5-13-05</u>	<u>1</u>	<u>oven cured @ 120°F</u>	<u>PO.1946</u>



28 00 QUALITY ASSURANCE AREA  
QTY: 920R-0 ASSY-104 0.1000 0.1000 0.1000

- \* PROCESS PER CAA STEP 28.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DATE	QTY	REMARKS	STATUS
<u>5/16/05</u>	<u>1</u>		



29 00 SOURCE INSPECTION  
MIP - SLAC CAR INSPECTION  
BEFORE SHIPMENT TO SLAC. 0.0000 0.0000 0.0000

- \* PROCESS PER CAA STEP 29
- \*\* PLEASE RETURN CCA TO QA FOR SHIPMENT.

DATE	QTY	REMARKS	STATUS
<u>5-17-05</u>	<u>1</u>	<u>GLAT 1763</u>	



WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: EVALUATION

WORK ORDER TRAVELLER - NEW

ENV: LAT-23-01646  
CCA: GLAST, TEM

WG 112012  
MATERIAL 1120-03-00  
DATE 11-01-04  
# 0000048799

CUST #  
PROJ #  
CUST #  
10111000  
10111000

PAGE 10

LINE DEPT WACH# QTY DESCRIPTION..... SET-UP RUN HOURS LINE-MACH ST-LOT:



30 299 00 PACKAGING/SHIPPING INSP 0.0000 0.0000 0.0000  
PACK & SHIP CCA

\* PROCESS PER CAA STEP 30.

DATE	QTY	REMARKS	STATUS
5/19/05	1		BC-1587



31 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CCA RECEIVING INSPECTION

\* PROCESS PER CAA STEP 31

\*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DRR#(S):

IN THE INSTANCE OF REJECTION, DO NOT CAUSE OR ALLOW ANY  
REWORK TO BE PERFORMED WITHOUT AUTHORIZATION PROVIDED BY  
APPROVED REMARK INSTRUCTIONS (NOMR REQUIRED).

DATE	QTY	REMARKS	STATUS
6/6/05	1		



32 250 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
SLAC GAR PRE-COAT INSP.  
MANDATORY INSPECTION  
POINT

\* PROCESS PER CAA STEP 11.

DATE	QTY	REMARKS	STATUS
6-7-05	1	GLAT 1763	

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 11

CAA # 01544  
LAST: JEM

WOT 112012  
REV DATE 12-01-05  
REL DATE 12-21-04  
CO# 0000048799

CUST ID  
QTY 1  
PROCESS 112010  
COST# 10300

LINE DEPT MACH# OP# DESCRIPTION... SET-UP... RUN... HOURS... LINE-MACH... ST-LOT.



33 010 00 CCA/BLACK BOX ASSY AREA  
ALCOHOL/DI CLEAN AND TEST  
THE CLEANLINESS OF CCA. 0.2000 0.2000 0.2000

- PROCESS PER CAA STEP 33.
- \*\*\* WEAR PROTECTIVE GLOVES WHEN HANDLING CCA \*\*\*
- ATTACH CLEANLINESS TEST RECORD TO WORK ORDER

DATE	QTY	REMARKS	STATUS
4/8/05	1		9m1262
6-8-05	1	Passed	PL



34 490 00 QUALITY ASSURANCE AREA  
SPE: SLDR-0 ASSY-11 0.0000 0.0000 0.0000

- PROCESS PER CAA STEP 34.
- RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DEF#(S)

DATE	QTY	REMARKS	STATUS
6/8/05	1		



35 150 00 COATING/POTTING AREA  
WASH & CONFORMAL COATING 0.5000 0.5000 0.5000

- PROCESS PER CAA STEP 35.
- \*\*\* WEAR PROTECTIVE GLOVES WHEN HANDLING CCA \*\*\*

RECORD BAKE DATE-TIME START/STOP BELOW:

BAKE DATE: 6-8-05 START: 14:30 STOP: 1:30

DATE	QTY	REMARKS	STATUS
6-8-05	1	Bake + Mask	PL

WORK CELL: 4-MIXED

CUSTOMER: SIAC

\*\*\*\*\* PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 13

COA: GLASS, TRM

MO# 112013  
REV DATED 02-03-05  
REV DATED 12-21-04  
PO# 0000048799

CUST #  
CITY  
PROJECTS  
CITY

LINE DEPT MACH# OP# DESCRIPTION SEC-UP RUN HOURS LINE-MACH ST-LOC



36 250 00 COATING/POTTING AREA 0.0000 0.0000 0.0000  
SPRAY CONFORMAL COAT

\* PROCESS PER CAA STEP 36

CONFORMAL COAT MATERIAL PO#: 3/201  
EXP. DATE: 6/30/05

TWO (2) HOUR AIR CURE (BEFORE OVEN BAKE):  
DATE: 6/8/05 START: 3:35 STOP: 4:40

DATE: 6/8/05 QTY: 1 REMARKS: COAT STATUS: DM/1035



37 250 00 COATING/POTTING AREA 0.0000 0.0000 0.0000  
FOURHP / OVEN BAKE

\* PROCESS PER CAA STEP 37

FIRST BAKE DATE: 6-9-05 START: 6:30 STOP: 7:30  
THIRD BAKE DATE: 6-9-05 START: 8:10 STOP: 9:30

DATE: 6-9-05 QTY: 1 REMARKS: STATUS: 4/2



WORK CELL: 4-MIXED

CUSTOMER: SLAU

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 13

W.O. # LAT-DS-01486  
C.A. # SLAU-001

WO# 112312  
REQ. DATE 02-03-05  
MFG. DATE 11-21-04  
JOB# 0000048759

CUST. # 1  
PROJ. # 1  
CUST. # 112312

LINE DEPT MACH# OP# DESCRIPTION SET-UP RUN HOURS LINE-MACH ST-LOT



00 200 00 QUALITY ASSURANCE AREA 0 5000 0 5000 0 5000  
LFE: SLDR-0 Assy-25

- \* PROCESS PER CAA STEP 39.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW

DATE: \_\_\_\_\_ QTY: \_\_\_\_\_ REMARKS: \_\_\_\_\_ STATUS: \_\_\_\_\_

REFER TO CAA FOR DOCUMENTATION REQUIREMENTS TO ATTACH OR ADVANCE WITH THIS WORK ORDER. ITEMS MAY, OR WILL, INCLUDE THE FOLLOWING:

- MATERIAL CERTIFICATIONS...
- SPEA TEST DEFECT REPORTS...
- INSPECTION DEFECT REPORTS...
- NON CONFORMANCE REPORTS...
- FORM #7C-103 (DOC REV RECORD)...
- NOI LOGS REPORT...
- DIGITAL PHOTOGRAPHS, RECORDED ONTO CD...

DATE: 6/9/05 QTY: 1 REMARKS: \_\_\_\_\_ STATUS: \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_



00 200 00 SOURCE INSPECTION 0 0000 0 0000 0 0000  
CST

- \* PROCESS PER CAA STEP 39.
- NOTE: NEXT ASSEMBLY IS LAT-DS-01481.
- \*\* PLEASE RETURN INSPECTED CCA TO QA UPON COMPLETION \*\*

DATE: 6.9.05 QTY: 1 REMARKS: GLAT 1763 STATUS: \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_



WORK ORDER - 112012

( NEW )

WORK ORDER PICK LIST

PAGE: 1

TYGLY # : LAT-DS-01646  
QUANTITY : 1  
LOCATION : W02

BY LINE ITEM

EFFECTIVITY DATE : 02-03-05  
RELEASE DATE : 04-01-05  
DATE PRINTED : 02-04-05

DATE PULLED: \_\_\_\_\_

PULLED BY: \_\_\_\_\_

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIREMENTS			INVLOC	LOT NUMBER	INVENTORY DETAIL				
			REQUIRED QUANTITY	CURR STAT	STATUS QUANTITY			RESV IN LOT #	LOT QUANTITY	LOT DATE	BINLOC	BIN QUANTITY
1	LAT-DS-01646 PWB. TEM ORIGINAL QUANTITY...	EA	1.00	RSVD	1.00	120299	SKCF2 FN-D1	120299	18.00	09-11-07		1
2	LAT-DS-01626 PLATE. CONN. TEM ORIGINAL QUANTITY...	EA	1.00	RSVD	1.00	114784	SKCF2 FN-D6	114784	18.00	05-19-07		1
3	LAT-DS-01611 PIN. CONNECTOR. TEM ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00	114785	SKCF2 FN-D7	114785	38.00	05-19-07		2
4	NAS1352N02-8 SCREW ORIGINAL QUANTITY...	EA	26.00	RSVD	26.00	114786	SKCF2 FN-D3	114786	546.00	09-23-04		26
5	LAT-DS-03882 STANDOFF ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00	114787	SKCF2 FN-D5	114787	36.00	09-23-04		2
6	MS21557-12 SCREW. PHD. 4-40 X .25 ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00	93945	SKCF2 FN-D10	93945	291.00	11-24-03	D3F	
							FN-D10	114788	78.00	09-23-04		2
7	NAS820-C2 WASHER ORIGINAL QUANTITY...	EA	52.00	RSVD	52.00	114789	SKCF2 FN-D2	114789	1052.00	09-23-04		52
8	MS24671-2 SCREW ORIGINAL QUANTITY...	EA	4.00	RSVD	4.00	114790	SKCF2 FN-D8	114790	84.00	09-23-04		4
9	NAS671-C4 NUT ORIGINAL QUANTITY...	EA	26.00	RSVD	26.00	114791	SKCF2 FN-D4	114791	520.00	09-23-04		26
10	LAT-DS-02586 ASSY. CABLE. CONN. TEM ORIGINAL QUANTITY...	EA	1.00	BO	1.00		SKCF2 FN-1D9	125.00	0.00			
11	0151 ADHESIVE. HYPO. 400 KIT ORIGINAL QUANTITY...	OZ	1.00	BO	1.00		SKCF2 FN-D11		0.00			
12	CV 2946 RTV. NSI. 1500 ORIGINAL QUANTITY...	OZ	1.00	BO	1.00		SKCF2 FN-D12		0.00			
13	8750 CONFORMAL COATING URELANE ORIGINAL QUANTITY...	OZ	1.00	BO	1.00		SKCF2 FN-D13		0.00			





EMBL # : LAT-DS-01646  
QUANTITY : 1  
LOCATION: W02

BY LINE ITEM

EFFECTIVITY DATE: 02-03-04  
RELEASED DATE : 02-04-04  
DATE PRINTED : 02-04-04

DATE PULLED: \_\_\_\_\_

PULLED BY: \_\_\_\_\_

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STAT	STATUS	RESV IN LOT #	REQUIREMENTS		INVENTORY DETAIL					
							QUANTITY	LOT #	LOT	DATE	LOT LIFE	SINLOC	QUANTITY	
25	SM0055 FUSE, RAYCHEM/POLYSWICH ORIGINAL QUANTITY...	EA	4.00	RSVD		114807	4.00	114807	SKCP2 FN-12	U7 U8 U9 U10 U11 U12 F2 F4 F6 F8	100.00	09-23-04		4
26	SM0075 IC ORIGINAL QUANTITY...	EA	4.00	RSVD		114926	4.00	114926	SKCP2 FN-13	U1 U2 U3 U4 U5 U6 F3 F5 F7 F9	100.00	09-24-04		4
27	MAX145A2UA IC ORIGINAL QUANTITY...	EA	36.00	RSVD		120266	36.00	120266	SKCP2 FN-15	U7 U8 U9 U10 U11 U12 U16 U17 U18 U19 U20 U21 U26 U27 U28 U29 U30 U31 U36 U37 U38 U39 U40 U41 U42	451.00	12-15-04		30
28	MAX5121A2EE IC ORIGINAL QUANTITY...	EA	2.00	RSVD		114810	2.00	114810	SKCP2 FN-16	U1 U2 U3	47.00	09-23-04		2
29	LAT-DS-02895 IC ORIGINAL QUANTITY...	EA	1.00	BO			1.00		SKCP2 FN-17	U45 U46	0.00			0
	LAT-DS-02894 IC ORIGINAL QUANTITY...	EA	1.00	BO			1.00		SKCP2 FN-18	U47 U48	0.00			0
31	LAT-TD-01814 IC ORIGINAL QUANTITY...	EA	4.00	RSVD		114813	4.00	114813	SKCP2 FN-19	U3 U4 U5 U6 U7	82.00	09-23-04		4
32	5842R8568101VXC IC ORIGINAL QUANTITY...	EA	1.00	RSVD		114814	1.00	114814	SKCP2 FN-20	U83 U84	32.00	09-23-04	DRY-10	1
33	5862R9852030YC IC ORIGINAL QUANTITY...	EA	5.00	BO			5.00		SKCP2 FN-22	U46 U47 U48 U49 U50 U51 U52 U53 U54 U55	0.00			0
34	LAT-TD-01812 IC ORIGINAL QUANTITY...	EA	8.00	RSVD		114816	8.00	114816	SKCP2 FN-23	U56 U57 U58 U59 U60 U61 U62 U63 U64 U65	162.00	09-23-04		8
35	H705CPX000 TRICK FILM JUMPER ORIGINAL QUANTITY...	EA	151.00	RSVD		114817	151.00	114817	SKCP2 FN-24	U66 U67 U68 U69 U70 U71 U72 U73 U74 U75 U76 U77 U78 U79 U80 U81 U82 U83 U84 U85 U86 U87 U88 U89 U90 U91 U92 U93 U94 U95 U96 U97 U98 U99 U100	450.00	09-23-04		151
	M85143Y128183OR RESISTOR, CHIP, 100K, 1K, 5K ORIGINAL QUANTITY...	EA	55.00	RSVD		114818	55.00	114818	SKCP2 FN-25	U101 U102 U103 U104 U105 U106 U107 U108 U109 U110 U111 U112 U113 U114 U115 U116 U117 U118 U119 U120 U121 U122 U123 U124 U125 U126 U127 U128 U129 U130 U131 U132 U133 U134 U135 U136 U137 U138 U139 U140	155.00	09-23-04		55



ORIGINAL QUANTITY... 4.00

PULLED-  
114826  
FN-21 U49 US1 US1 US2  
PULLED:

4.00 09-23-04 DRY-10

4 ✓







General Technology Corporation

# CONFORMAL COATING DATA SHEET

CCA P/N: LAT-DS-01646 GT112

W.O. #: 112012

CC Tech: Dm/1035 (Initial / Employee #)

Date: 6/8/05

## MIX RATIOS

Coating TYPE: ARATHANE Mfr: HUNTSMAN

Lot Number: AKAGB8013A Expiration Date: 6/30/05

MIX RATIOS: 5750-A 5750B  
18PBW TO 100PBW ARATHANE

AIR CURE: 6/8/05 3:35 PM

OVEN CURE: \_\_\_\_\_


## REWORK TRAVELER

SO NO: F17300	PART NO: SLAC LAT-DS-01646	REV: 56
---------------	----------------------------	---------

ASSEMBLY NAME: TEM CCA	QTY: 1
------------------------	--------

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APPROVAL G. POZZI	G. HEFFKIN	K. BERGTHOLDT	P. LUJAN
PREPARED BY	DATE	DATE	DATE
ENG MGR SUP	DATE	QA MGR ENTL	DATE
SLAC SOURCE	DATE		

STEP	OPERATION	Operator Sign Off.	Date	Time spent
1	Record serial numbers: TEM LAT-DS-01646 SN GT- <u>112</u> GLAT- _____			
2	<b>OPERATOR: INSPECT FOR CLEANLINESS AND DEBRIS</b> USE A SOLUTION OF 75% ALCOHOL AND 25% DE-IONIZED WATER. PLACE BOARDS INTO SOLUTION AND USE A SOFT BRISTLE BRUSH TO REMOVE ALL SOLDER BALLS. VIEW BOARDS UNDER A 10X SCOPE AND RECLEAN UNTIL ALL SOLDER BALLS HAVE BEEN REMOVED. <b>NO SOLDER BALLS ALLOWED.</b>	ML 1337	4/21/05	
3	AQUEOUS CLEAN USING RECIPE #3	ML 1337	4/22/05	
4	<b>INSPECTION: INSPECT FOR BOARD CLEANLINESS. NO SOLDER BALLS ALLOWED.</b>	ML 1337	4/22/05	
5	SOURCE INSPECTION		5/4/05	





WESTEK

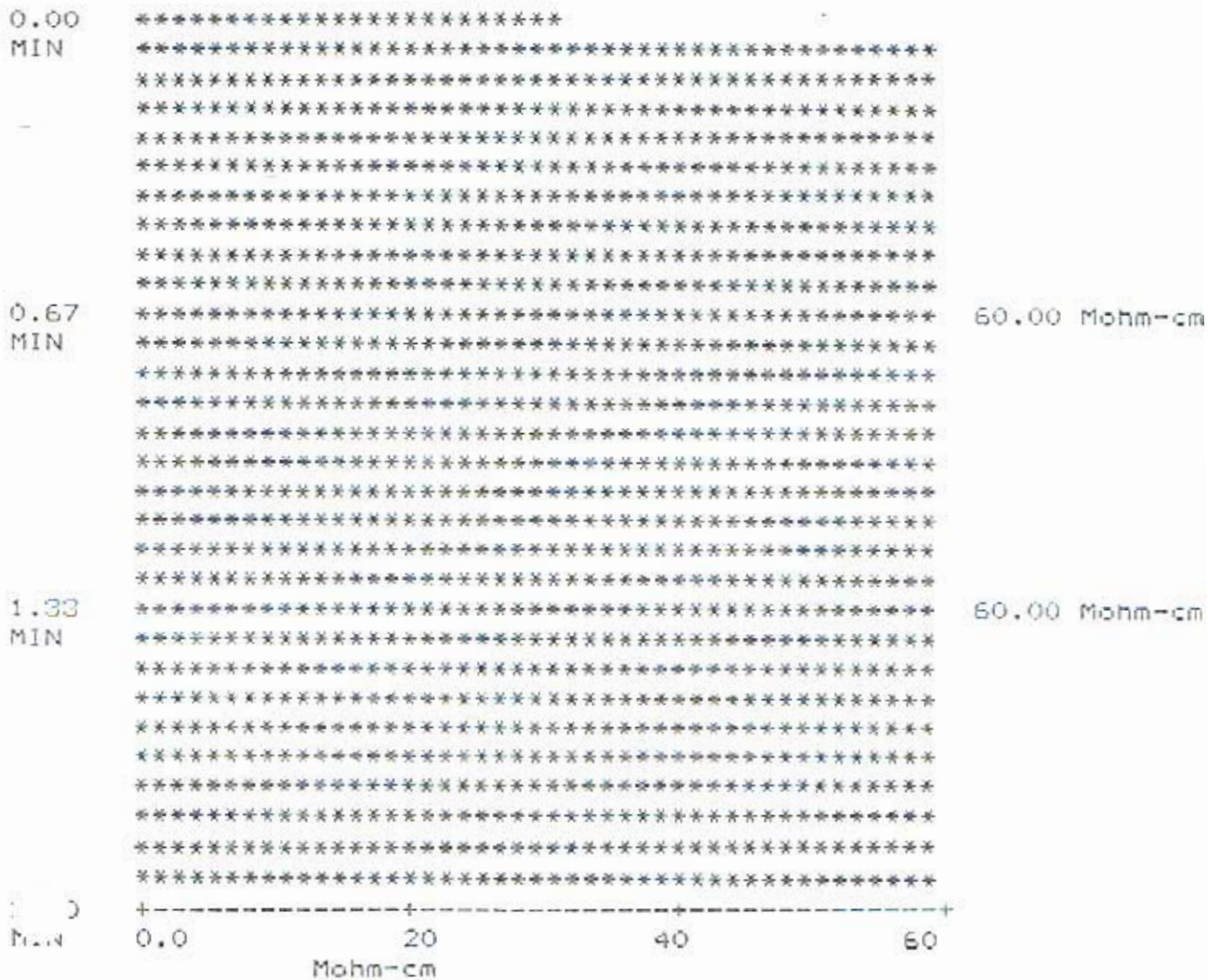
Operator : J.C.  
06/08/05  
09:51:47

Test Type : Auto  
Test name : 'Manual Test'  
Board # GT112 has P A S S E D

TEST TIME : 2.00 min  
TEST VOLUME : 8820 ml  
BOARD AREA : 220.5 sq in  
COMP. AREA : 0.00 sq in  
VOL/SQ. IN : 40 ml/sq. in  
P/F LIMIT : 10.07 ug/sq in  
: 7.70 Mohm-cm

Initial Resistivity : 51.00 Mohm-cm  
NaCl Equivalence (Final) : 0.58 ug/sq in

TIME vs RESISTIVITY



Final Resistivity : 60.00 Mohm-cm

# DEFECT RECORD REPORT

ID: 29535

PART NUMBER: LAT-DS-01646

WORK ORDER: 112012

SALES ORDER: F17200

QUANTITY: 1 RW QTY: 1

CUSTOMER: SLAC

INSPECTION TYPE: 1ST SOLDER INSPECTION

INSPECTION LEVEL: 1

INSPECTOR: HUBBARD

OFF SOLDER: 4163

OFF ASSEMBLY: 5203

DATE: 2/19/2005

WEEK CODE: 9

SERIAL NO	QUANTITY	OPERATOR	DEFECT CODE	WORKCELL	DEFECT DESCRIPTION	REF DES	PINNOTES
112	1	1347	S402		INSUFFICIENT SOLDER	U4'	4 SIDES
112	1	1347	S414		SOLDER BALLS	BD	THROUGHOUT

*Handwritten:* 1337  
2/24/05

*Handwritten:* 3/29/05



# GTC TEST DEFECT RECORD REPORT

TEST ID: 24626

PART NUMBER: LAT-DS-01646  
 WO: 112012 WC: 4-MIXED  
 SO: F17200  
 TEST QTY: 1  
 FAIL QTY: 1

TEST TYPE: SPEA  
 TEST LEVEL: 1ST  
 TEST TECH: STEFFEN BODE  
 CUSTOMER: SLAC  
 PROGRAM NAME: LAT-DS-01646

DATE: 5/5/2005

SERIAL #	QTY	DEFECT CODE	DEFECT DESCRIPTION	REF DES
GT112	1	T302	MISSING COMPONENT	C119
TEST INFO			RW INFO: <i>Placed C119</i>	REWORKED BY: <i>me 5/6/05</i> INSPECTED BY: <i>[Signature]</i> 5/6/05
GT112	1	T302	MISSING COMPONENT	C118
TEST INFO			RW INFO: <i>Placed C118</i>	REWORKED BY: <i>me 5/6/05</i> INSPECTED BY: <i>[Signature]</i> 5/6/05

REWORK NOTES (OPTIONAL):

RETEST NOTES (OPTIONAL):

RETESTED BY: *M. Ma* RETEST DATE: P F  
 | | 5/6/05 | X |



# DEFECT RECORD REPORT

ID: 29535  
 PART NUMBER: LAT DS-01646  
 WORK ORDER: 112012  
 SALES ORDER: F17200  
 INSPECTION TYPE: 1ST SOLDER INSPECTOR *post re-flow*  
 INSPECTION LEVEL: 1 *2/27/05 K.H.*  
 INSPECTOR: HUBBARD  
 QUANTITY: 1 RAV QTY: 1  
 CUSTOMER: SLAC  
 OFF SOLDER: 4163  
 OFF ASSEMBLY: 5203  
 DATE: 2/19/2005  
 WEEK CODE: 9

SERIAL NO.	QUANTITY	OPERATOR	DEFECT CODE	WORKCELL	DEFECT DESCRIPTION	REF DES	PIN NOTES
112	1	1347	A343		INCOMPLETE PAPERWORK	SEQ. 8 ✓	✓
112	1	1347	A385		SOAP RESIDUE	BD. ✓	THROUGH OUT
112	1	1347	S402		INSUFFICIENT SOLDER	U54 ✓	4 SIDES
112	1	1347	S402		INSUFFICIENT SOLDER	U68 ✓	4 SIDES
112	1	1347	S402		INSUFFICIENT SOLDER	U58 ✓	4 SIDES
112	1	1347	S402		INSUFFICIENT SOLDER	U56 ✓	4 SIDES
112	1	1347	S402		INSUFFICIENT SOLDER	U55 ✓	4 SIDES
112	1	1347	S402		INSUFFICIENT SOLDER	U60 ✓	4 SIDES
112	1	1347	S402		INSUFFICIENT SOLDER	U57 ✓	4 SIDES
112	1	1347	S402		INSUFFICIENT SOLDER	U41 ✓	PIN 5
112	1	1347	S402		INSUFFICIENT SOLDER	U59 ✓	4 SIDES
112	1	1347	S402		INSUFFICIENT SOLDER	U51 ✓	4 SIDES
112	1	1347	S402		INSUFFICIENT SOLDER	U53 ✓	4 SIDES
112	1	1347	S402		INSUFFICIENT SOLDER	U12 ✓	PIN 8
112	1	1347	S402		INSUFFICIENT SOLDER	U35 ✓	PIN 5
112	1	1858	S402		INSUFFICIENT SOLDER	U33 ✓	PIN 5
112	1	1347	S402		INSUFFICIENT SOLDER	U16 ✓	4 SIDES

*no 1337  
2/24/05*

*3/29/05*

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TV PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 1

ASSY/PN: LAT-DS-02588  
ASSY. CABLE, CONN. TEM

WOB 112026  
REQ DATE 02-04-05  
REL DATE 01-31-05  
SOS  
PO# 0001048799

CUST #  
QTY 15  
PROJECT# 117200  
CUST# 15356

SERIAL NUMBER LISTING:-----  
N/A

APPROVAL:  
PROD GH 2/4/05  
CA GH 2.4.05

WORKMANSHIP:-----  
ANSI-Z-39-18 CLASS 3; OTHER:  
(DEFAULT WORKMANSHIP UNLESS INDICATED OTHERWISE, ABOVE)

LOT NO.	LOT QTY	SERIAL NUMBERS	SPO NO.	REASON	APPRY EDATE

(wobdr rev 05.19.04 gih)-----

LIN DEPT MACH# OP# DESCRIPTION..... HOURS  
SET-UP RUN... LINE-MACH ST-LOC

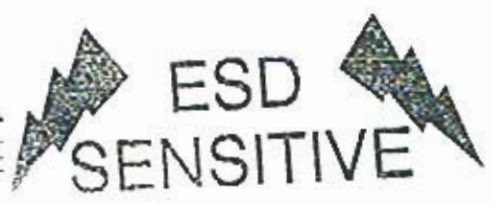


400 00 CONFIG RECORD/ATTING 0.0000 0.0000 0.0000  
CONFIG

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
DOCUMENT NUMBER REV PD/PL OUTSTANDING SO'S  
ASSY & PL: LAT-DS-02588 01 NONE  
TEST SPEC: N/A  
ASSY AID: N/A  
CUSTOMER NAME: SLAC

\*\*\*\*\* BUILD DOCUMENTS \*\*\*\*\*  
USE... TRAVELER AND DRAWING  
(REV'D)/PREP'D BY: GH (DATE)DATE: 02.02.05

DATE	QTY	REMARKS	STATUS
2-4-05			<u>GH</u>



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 2

ASSY/PN# LAT-DS-02593  
ASSY, CABLE, CONN, TEM

NO# 112024  
REQ DATE 02-04-06  
REL DATE 01-31-06  
SO#  
PO# 0000045799

CUST P#  
CITY 19  
PROJECT# 1817200  
CUST# 18356

LI# DEPT MACH# OP# DESCRIPTION..... HOURS  
SET-UP RUN... LINE-MACH ST-LOT



2 201 00 STOCKROOM/KITTING AREA 0.0000 0.0000 3.0000  
KIT PARTS/MATERIALS

\* WIRE, CRIMP PINS, AND CONNECTOR.

DATE	QTY	REMARKS.....	STATUS
2/1/06	19		



WORK CELL: 4-MIXED

CUSTOMER: SIAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 3

ASSY/P/N: LAT-DS-02588  
ASSY, CABLE, CONN, TEM

WO# 112026  
REQ DATE 02-04-05  
REL DATE 01-31-05  
JOB #  
PO# 0000048799

CUST P#  
CITY 19  
PROJECT# P17200  
CUST# 15356

Step 1-4  
# 1337  
4/26/05  
move to start AS3A  
Jetha

LI# DEPT MACH# OP# DESCRIPTION SET-UP ACN... HOURS LINE-MACH ST-LOT



3 220 00 CABLE/HARNESS ASSY AREA 0.0000 3.0000 0.0000

CUT WIRE, STRIP WIRE, CRIMP PIN CONTACTS, TIN LEADS.

- CRIMP TEST SETUP - GTC-2081.
- CUT 4 PIECES OF WIRE W 9" TO 9" LONG, FOR FULL TESTS. USE 3 PCS EACH FOR PRE-CRIMP AND POST-CRIMP TESTS.
- STRIPPING METHOD -- ALL ASSEMBLY AND TEST ACTIVITY...
- ... USE SCHEMATIC PNEUMATIC WIRE STRIPPER SET UP WITH 24 AWG STRIP BLADES, A STRIP LENGTH OF 3/16" AND LEAVES THE INSULATION SLUG IN PLACE.
- PRE-ASSY CRIMP TEST...
- STRIP AND CRIMP THREE CONTACTS USING TEST WIRE. TEST THE SAMPLE CRIMPS PER GTC-2081. RECORD RESULTS. IF FAIL, CONTACT ENGINEERING.
- CRIMP TEST: BY: stalos DATE: 2/19/05 STATUS Pass  
Remanthon 1970
- ASSEMBLY ACTIVITY...
- 1) FEED WIRE DIRECTLY OFF THE SPOOL TO THE STRIPPER.
- 2) STRIP THE INSULATION LEAVING THE SLUG. (1.125")
- 3) CUT THE WIRE OFF AT THE INDICATED LENGTH, AND QUANTITY.
- CUT 4 PIECES TO 1-1/8" (1.125") LONG. USE PROGRAM # 89
- CUT 4 PIECES TO 1" (1.000") LONG. USE PROGRAM # 90 } ON EUBANKS
- 4) STRIP SECOND END USING THERMAL TWEEZERS. 3/16"
- 5) TIN SECOND END BY SOLDER DIP. CLEAN WITH ALCOHOL.
- 6) FULL INSULATION SLUG AND CRIMP CONTACT (22D) ONTO LEAD. USE M22520/2-01 CRIMPER W/ M22520-2-09 TURRET/LOCATOR.
- POST-ASSY CRIMP TEST...
- STRIP AND CRIMP THREE CONTACTS USING TEST WIRE. TEST THE SAMPLE CRIMPS PER GTC-2081. RECORD RESULTS. IF FAIL, CONTACT ENGINEERING.
- CRIMP TEST: BY: stalos DATE: 2/19/05 STATUS Pass

Equipment CHANGE: EUBANKS #AB... 3-01-05  
3/16" strip length to 1/4" (#19)  
2-8-05  
Pass Crimp Tensile Strength Sheet attached

①②③④ - performed using S. 80  
3/16 (#19)  
GTC-A-463  
K42 - mm  
#AB... 2-8-05

DATE	QTY	REMARKS	STATUS
2/19/05	4	8 7/8" (39) @ 1 1/8" (39) @ 4 each	RM 1970
3.1.05	8	1 1/8" (350) 1" (200) 1 9/16" (175)	H.G. #1941
3.11.05	8	1 1/8 strips	H.G. #1941

3.11.05 @ 5/16 strips H.G. #1941  
3.11.05 crimps 1 9/16 H.G. #1941  
3-2-05 MV 1742 1" strip  
3-12-05 turning H.G. #1941 1 5/16  
3.14.05 crimp/tin 1" (46) H.G. #1941  
3.14.05 crimp/tin 1 1/8 (46) H.G. #1941  
3.14.05 crimp/tin 1 1/8 (235) H.G. #1941  
3.14.05 crimp/tin (26) 1" H.G. #1941

\* pre-Asst crimp test 7.28.05 Pass H.G. #1941  
pre-Asst crimp test 3.1.05 Pass H.G. #1941  
u 3.2.05 Pass H.G. #1941  
u 3.3.05 Pass H.G. #1941  
no crimping on 3.4.05  
pre-Asst crimp test 3.5.05 Pass H.G. #1941  
u 3.7.05 Pass H.G. #1941  
pre-Asst crimp test 3.14.05 Pass H.G. #1941  
u 1" #1941

See page 3A - continued  
Jetha

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/FN# LAT-DS-02588  
ASSY. CABLE, CONN, TEM

NO# 112026  
REQ DATE 02-01-05  
REL DATE 01-31-05  
SO#  
PO# 0000048799

CUST #  
QTY 19  
PROJECT# F17200  
CUST# 15355

PAGE 4

LINE DEPT MACH# OP# DESCRIPTION..... HOURS  
SET-UP RUN LINE-MACH ST-LOT



4 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OP# SLD-78 ASSY-312

- \* INSPECT WIRE COUNT, STRIPS, CRIMPS, TINNINGS, AND CLEANING.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DRAW#(S)

DATE	QTY	REMARKS	STATUS
2/17/05	4	7/8" 39 pieces	OK
	A	1 1/8" 39 pieces	OK
3/4/05		(Redone)	OK



5 220 00 CABLE/HARNESS ASSY AREA 0.0000 0.0000 0.0000  
INSERT CRIMP CONTACTS TO CONNECTOR

- \* INSERT TERMINATED WIRES TO CONNECTOR.
- ... INSERT LONGER WIRES (1-<sup>5/16</sup>) INTO HOLE NUMBERS 1 THRU 20.
- ... INSERT SHORT WIRES (1/8") INTO HOLE NUMBERS 60 THRU 78.
- \* ASSURE CONTACT IS SEATED AND LOCKED INTO CONNECTOR.

*3/1/05 15% inspection 4 strip*  
*3/1/05 1/8" strip*  
*3/1/05 1/8" strip*  
*strips, crimps & things*  
*3/17/05*  
*2-21-05*

DATE	QTY	REMARKS	STATUS
2/17/05	4		OK
3-15-05	2		OK
3-21-05	1		OK

*3-21-05 3 completed H6 #19*



6 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OP# SLD-0 ASSY-78

- \* INSPECT INSERTED WIRES.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DRAW#(S)

ROUTE FOR WO CLOSURE AND DELIVERY TO NEXT ASSY LAT-DS-01641.

DATE	QTY	REMARKS	STATUS
2/17/05	4	AMP 206504-1 conn	OK
		inserts, step 5.	OK
3-15-05	2	AMP 206504-1 conn, check wires	OK
3/21-05	1		OK
3/22/05	3	conn	OK



WORK ORDER : 112026  
 BLY # : LAT-DE-01588  
 JANUITY : 19  
 LOCATION: W02

( NEW )

WORK ORDER PICK LIST  
 BY LINE ITEM

PAGE: 1

EFFECTIVITY DATE: 02-04-05  
 RELEASE DATE : 01-31-05  
 DATE PRINTED : 02-07-05

DATE PULLED: \_\_\_\_\_

PULLED BY: \_\_\_\_\_

REQUIREMENTS					INVENTORY DETAIL							
LINE	DESCRIPTION	UM	REQUIRED QUANTITY	CURR STATUS	RESV IN QUANTITY	LOT #	INVLOC NUMBER	LOT QUANTITY	LOT DATE	BIN	BINLOC	QUANTITY
1	206504-1 AMPLIMITE ORIGINAL QUANTITY...	EA	19.00	RSVD	19.00	114794	SKCF2 FN-1	114794 PULLED:	22.00	09-23-04		
The following parts have been defined as alternates for 206504-1: LI# 1.1 311P407-52-B-1s 1 PER Partial quantity replacements are allowed.												
2	M22759/11-24-9 WIRE, 24AWG, WHITE ORIGINAL QUANTITY...	IN	1938.00	RSVD	1938.00	115299	SKCF2 FN-3	115299 PULLED:	15994.00	01-01-04		
The following parts have been defined as alternates for 204370-8: LI# 3.1 GOSP: 1 PER Partial quantity replacements are allowed.												
3	204370-8 PIN, CRIMP ORIGINAL QUANTITY...	EA	54.00	RSVD	1596.00	114796	SKCF2 FN-2	114796 PULLED:	1597.00	09-23-04	IN ASSY	
							FN-2	115041 PULLED:	972.00	09-23-04	P17200	

*A*

*1938*

*1596*



0750

## CRIMP TENSILE STRENGTH LAT-DS-02588

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	POST - PROD	
CRIMP OPERATOR NAME/EMP #:	RHODA MARMON 1970	TEST DATE	
CONTACT PN:	204370-8	2/09/05	
WIRE PN:	M22759/11-24-9	TESTED BY	
CRIMP TOOL PN (GTC Tool #):	M22520/2-01 (GTC-A-930)	RHODA MARMON 1970	
DIE/LOCATOR PN (GTC Tool #):	M22520/02-09 (GTC-A-831)	WORK ORDER NO.	
SELECTOR VALUE:	3	112026	
TEST EQUIP # (Last CAL date):	ALPHATRON MPF 2004 (6-17-04)		
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:	
OBSERVATIONS/VALUES			
SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	11.8	12.9	12.9
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input type="radio"/> PASS <input type="radio"/> FAIL
	Type of Separation Observed		
SLIP (pull out) (a)			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) (b)			
CONTACT BROKEN IN CRIMP AREA (some or all) (c)			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) (d)	✓	✓	✓
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			
SPECIAL INSTRUCTIONS (as reqd):			

1500

## CRIMP TENSILE STRENGTH LAT-DS-02588

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	POST - PROD
CRIMP OPERATOR NAME/EMP #:	1	TEST DATE
CONTACT PN:		2/09/05
WIRE PN:		TESTED BY
CRIMP TOOL PN (GTC Tool #):	(GTC- )	Roger Marmol 1970
DIE/LOCATOR PN (GTC Tool #):	(GTC- )	WORK ORDER NO.
SELECTOR VALUE:		112026
TEST EQUIP # (Last CAL date):	( )	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.2	13.4	13.5
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL
	Type of Separation Observed		
SLIP (pull out) {a}			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) {b}			
CONTACT BROKEN IN CRIMP AREA (some or all) {c}			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) {d}	✓	✓	✓
CONTACT BROKEN OUTSIDE OF CRIMP AREA {e}		✓	✓
OTHER (define) {f}			
SPECIAL INSTRUCTIONS (as reqd):			



0830

## CRIMP TENSILE STRENGTH

LAT-05-02588

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	POST - PROD
CRIMP OPERATOR NAME/EMP #:	RHODA MARLOW 1970	TEST DATE
CONTACT PN:	204370-8	2-15-05
WIRE PN:	M22759/11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520/2-01 (GTC-A 830)	RHODA MARLOW 1970
DIE/LOCATOR PN (GTC Tool #):	M22520/02-01 (GTC-A 831)	WORK ORDER NO.
SELECTOR VALUE:	3	112026
TEST EQUIP # (Last CAL date):	ALPHATRON MPE 200A (6-17-04)	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	12.8	13.5	13.3
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input type="radio"/> PASS <input type="radio"/> FAIL
	Type of Separation Observed		
SLIP (pull out) {a}	✓	✓	✓
CONDUCTOR BROKEN IN CRIMP AREA (some or all) {b}			
CONTACT BROKEN IN CRIMP AREA (some or all) {c}			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) {d}	⊗	⊗	
CONTACT BROKEN OUTSIDE OF CRIMP AREA {e}			
OTHER (define) {f}			
SPECIAL INSTRUCTIONS (as req):			



13223 1355

# CRIMP TENSILE STRENGTH

LAT-05-02588

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	POST - PROD
CRIMP OPERATOR NAME/EMP #:	1	TEST DATE
CONTACT PN:		2/15/05
WIRE PN:		TESTED BY
CRIMP TOOL PN (GTC Tool #):	(GTC- )	STODA MARMON
DIE/LOCATOR PN (GTC Tool #):	(GTC- )	WORK ORDER NO.
SELECTOR VALUE:		1102/12026
TEST EQUIP # (Last CAL date):	( )	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.3	12.6	13.3
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL
Type of Separation Observed			
SLIP (pull out) (a)	✓	<del>✓</del>	
CONDUCTOR BROKEN IN CRIMP AREA (some or all) (b)		✓	✓
CONTACT BROKEN IN CRIMP AREA (some or all) (c)			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) (d)			
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			

SPECIAL INSTRUCTIONS (as reqd):

1:10 PM.

### CRIMP TENSILE STRENGTH

Lat-05-02588

MIL-STD-1344: METHOD 2003.1

TEST TYPE (circle one):	<b>PRE - PROD</b>	POST - PROD
CRIMP OPERATOR NAME/EMP #:	Herbie Gray 1#141	TEST DATE
CONTACT PN:	704370-8	2.28.05
WIRE PN:	M22759 / 11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520 / 2-01 (GTC 1.520)	Herbie Gray
DIE/LOCATOR PN (GTC Tool #):	M22520 / 2-09 (GTC 1.631)	WORK ORDER NO.
SELECTOR VALUE:	3	112026
TEST EQUIP # (Last CAL date):	Alpation MPF200A ( <del>6.18.05</del> ) 1.18.05	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

### OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.5	13.0	12.0
PASS/FAIL (circle test result)	<b>PASS</b> FAIL	<b>PASS</b> FAIL	<b>PASS</b> FAIL
Type of Separation Observed			
SLIP (pull out) {a}			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) {b}		✓	
CONTACT BROKEN IN CRIMP AREA (some or all) {c}			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) {d}	✓		✓
CONTACT BROKEN OUTSIDE OF CRIMP AREA {e}			
OTHER (define) {f}			

SPECIAL INSTRUCTIONS (as reqd):



8:45 a.m.

## CRIMP TENSILE STRENGTH Lat-15-02588

MIL-STD-1344: METHOD 2003.1

TEST TYPE (circle one):	<b>PRE - PROD</b>	POST - PROD
CRIMP OPERATOR NAME/EMP #:	Herbie Gray 1#1941	TEST DATE
CONTACT PN:	204370-B	3.1.05
WIRE PN:	M72759 / 11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M72520 / 2-01 (GTC 1.830)	Herbie Gray
DIE/LOCATOR PN (GTC Tool #):	M72520 / 2-09 (GTC 1.831)	WORK ORDER NO.
SELECTOR VALUE:	3	117026
TEST EQUIP # (Last CAL date):	Alphatron MPF 200A ( <del>64501</del> ) 11805	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.8	13.5	13.8
PASS/FAIL (circle test result)	<b>PASS</b> FAIL	<b>PASS</b> FAIL	<b>PASS</b> FAIL
	Type of Separation Observed		
SLIP (pull out) (a)			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) (b)		✓	
CONTACT BROKEN IN CRIMP AREA (some or all) (c)			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) (d)	✓		✓
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			

SPECIAL INSTRUCTIONS (as reqd):



7:47 a.m.

## CRIMP TENSILE STRENGTH Lot-DS-02588

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	<input checked="" type="radio"/> PRE-PROD	<input type="radio"/> POST-PROD
CRIMP OPERATOR NAME/EMP #:	Herbie Gray 127941	TEST DATE
CONTACT PN:	204370-8	33.05
WIRE PN:	M22799 / 11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520 / 2-01 (GTC 8-82)	Herbie Gray
DIE/LOCATOR PN (GTC Tool #):	M22520 / 2-01 (GTC 8-83)	WORK ORDER NO.
SELECTOR VALUE:	3	112026
TEST EQUIP # (Last CAL date):	Aluminum MPF 200A <del>11-24-9</del> 16.17.04	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.5	13.6	13.4
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL	<input checked="" type="radio"/> PASS <input type="radio"/> FAIL
	Type of Separation Observed		
SLIP (pull out) {a}			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) {b}			
CONTACT BROKEN IN CRIMP AREA (some or all) {c}			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) {d}	✓	✓	
CONTACT BROKEN OUTSIDE OF CRIMP AREA {e}			
OTHER (define) {f}			
SPECIAL INSTRUCTIONS (as reqd):			

9.501.1c

**CRIMP TENSILE STRENGTH** Lot DS-02588

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	<b>PRE - PROD</b>	POST - PROD
CRIMP OPERATOR NAME/EMP #:	Herbie Gray #1941	TEST DATE
CONTACT PN:	204370-8	3.505
WIRE PN:	M22759 / 11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520 / 2-01 (GTC 1102)	Herbie Gray
DIE/LOCATOR PN (GTC Tool #):	M22920 / 2-09 (GTC 631)	WORK ORDER NO.
SELECTOR VALUE:	3	112026
TEST EQUIP # (Last CAL date):	Alutron MPF 20A (6.17.04)	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

**OBSERVATIONS/VALUES**

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.4	13.2	13.4
PASS/FAIL (circle test result)	<b>PASS</b> FAIL	<b>PASS</b> FAIL	<b>PASS</b> FAIL
	Type of Separation Observed		
SLIP (pull out) (a)			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) (b)			✓
CONTACT BROKEN IN CRIMP AREA (some or all) (c)			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) (d)	✓	✓	
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			

SPECIAL INSTRUCTIONS (as reqd):



8:50 A.M.

## CRIMP TENSILE STRENGTH Cat. DS-02588

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	<u>PRE - PROD</u>	POST - PROD
CRIMP OPERATOR NAME/EMP #:	Herbie Gray #1941	TEST DATE
CONTACT PN:	204370-8	3.7.05
WIRE PN:	M2259 / 11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520 / 2-d (GTC A.830)	Herbie Gray
DIE/LOCATOR PN (GTC Tool #):	M22520 / 2-09 (GTC A.831)	WORK ORDER NO.
SELECTOR VALUE:	3	112026
TEST EQUIP # (Last CAL date):	Alpha 4 MPF 200A (1.18.05)	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.0	12.8	13.0
PASS/FAIL (circle test result)	<u>PASS</u> FAIL	<u>PASS</u> FAIL	<u>PASS</u> FAIL
	Type of Separation Observed		
SLIP (pull out) {a}			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) {b}		✓	
CONTACT BROKEN IN CRIMP AREA (some or all) {c}			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) {d}	✓		✓
CONTACT BROKEN OUTSIDE OF CRIMP AREA {e}			
OTHER (define) {f}			
SPECIAL INSTRUCTIONS (as reqd):			





# CRIMP TENSILE STRENGTH (at 15-02583)

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	<input checked="" type="radio"/> PRE PROD	<input type="radio"/> POST - PROD						
CRIMP OPERATOR NAME/EMP #:	Herbie Gray 1#1941	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td style="text-align: center;">TEST DATE</td></tr> <tr><td style="text-align: center;">3.14.05</td></tr> <tr><td style="text-align: center;">TESTED BY</td></tr> <tr><td style="text-align: center;">Herbie Gray</td></tr> <tr><td style="text-align: center;">WORK ORDER NO.</td></tr> <tr><td style="text-align: center;">112026</td></tr> </table>	TEST DATE	3.14.05	TESTED BY	Herbie Gray	WORK ORDER NO.	112026
TEST DATE								
3.14.05								
TESTED BY								
Herbie Gray								
WORK ORDER NO.								
112026								
CONTACT PN:	204370-8							
WIRE PN:	M22759 / 11-24-9							
CRIMP TOOL PN (GTC Tool #):	M2202 / 2-01 (GTC# 102)							
DIE/LOCATOR PN (GTC Tool #):	M2202 / 2-01 (GTC# 836)							
SELECTOR VALUE:	3							
TEST EQUIP # (Last CAL date):	Alldata MPT-2004 (6.17.04)							
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:						

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.4	12.9	13.2
PASS/FAIL (circle test result)	<input checked="" type="radio"/> PASS    FAIL	<input checked="" type="radio"/> PASS    FAIL	<input checked="" type="radio"/> PASS    FAIL
	Type of Separation Observed		
SLIP (pull out) (a)			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) (b)			
CONTACT BROKEN IN CRIMP AREA (some or all) (c)			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) (d)	✓	✓	✓
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			
SPECIAL INSTRUCTIONS (as reqd):			



# CRIMP TENSILE STRENGTH

LAT-DS-02580

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	<b>POST</b> PROD
CRIMP OPERATOR NAME/EMP #:	Herbie Gray 1 # 1441	TEST DATE
CONTACT PN:	204370-8	3.21.05
WIRE PN:	M22759 / 11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520 / 2-01 (GTC 4100)	Herbie Gray
DIE/LOCATOR PN (GTC Tool #):	M22520 / 2-09 (GTC 836)	WORK ORDER NO.
SELECTOR VALUE:	3	112026
TEST EQUIP # (Last CAL date):	Alperton MPT-200A (6.17.01)	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

## OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10	10	10
MEASURED TENSILE STRENGTH:	13.6	13.4	13.8
PASS/FAIL (circle test result)	<b>PASS</b>	FAIL	<b>PASS</b>
	FAIL	<b>PASS</b>	FAIL
	<b>PASS</b>	FAIL	<b>PASS</b>
	FAIL	<b>PASS</b>	FAIL
	Type of Separation Observed		
SLIP (pull out) {a}			
CONDUCTOR BROKEN IN CRIMP AREA (some or all) {b}		✓	
CONTACT BROKEN IN CRIMP AREA (some or all) {c}			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) {d}	✓		✓
CONTACT BROKEN OUTSIDE OF CRIMP AREA {e}			
OTHER (define) {f}			

SPECIAL INSTRUCTIONS (as reqd):



Assy LAT-DS-02588

## CRIMP TENSILE STRENGTH

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	<u>PRE - PROD</u>	POST - PROD
CRIMP OPERATOR NAME/EMP #:	Dora / 11337	TEST DATE
CONTACT PN:	204370-8 (C08P1)	4/28/05
WIRE PN:	M22759/11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520/2-01 (GTC-AL610)	Dora
DIE/LOCATOR PN (GTC Tool #):	M22520-2-09 (GTC- )	WORK ORDER NO.
SELECTOR VALUE:	3	112026
TEST EQUIP # (Last CAL date):	6/17/04 <sup>Due</sup> 6/17/05 GTC 958	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

### OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10.0	10.0	10.0
MEASURED TENSILE STRENGTH:	13.7	13.5	13.4
PASS/FAIL (circle test result)	<u>PASS</u> FAIL	<u>PASS</u> FAIL	<u>PASS</u> FAIL
Check Failure Mode Observed			
SLIP (pull out) (a)	13.7 ✓		✓
CONDUCTOR BROKEN IN CRIMP AREA (some or all) (b)			
CONTACT BROKEN IN CRIMP AREA (some or all) (c)			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) (d)		✓	
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			
SPECIAL INSTRUCTIONS (as reqd):			

Assy. LAT-D5-02588

### CRIMP TENSILE STRENGTH

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	<b>POST - PROD</b>
CRIMP OPERATOR NAME/EMP #:	Nara 11337	TEST DATE
CONTACT PN:	204370-8 (608PI)	4/28/05
WIRE PN:	M22759/11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520/2-01 (GTC-A610)	Nara
DIE/LOCATOR PN (GTC Tool #):	M22520-2-09 (GTC- )	WORK ORDER NO.
SELECTOR VALUE:	3	112026
TEST EQUIP # (Last CAL date):	6/17/04 <sup>Due</sup> 6/17/05 (GTC PS11)	
PULL RATE:	1" +/- .25" per min.	OTHER PULL RATE:

### OBSERVATIONS/VALUES

SAMPLE NUMBER:	No. 1	No. 2	No. 3
MINIMUM TENSILE STRENGTH:	10.0	10.0	10.0
MEASURED TENSILE STRENGTH:	13.0	13.4	13.2
PASS/FAIL (circle test result)	<b>PASS</b>	FAIL	<b>PASS</b>
		<b>PASS</b>	FAIL
			<b>PASS</b>
			FAIL
	Check Failure Mode Observed		
SLIP (pull out) (a)		✓	
CONDUCTOR BROKEN IN CRIMP AREA (some or all) (b)			✓
CONTACT BROKEN IN CRIMP AREA (some or all) (c)			
CONDUCTOR BROKEN OUTSIDE CRIMP AREA (not in gripping area) (d)	✓		
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			
SPECIAL INSTRUCTIONS (as reqd):			