

**END-ITEM DATA PACKAGE – LAT-DS-01643; Serial Number: GT112 GLAT1845**

*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# 113237 : S/N (above SN)
- TPS Unit; LAT-DS-01482 WO# 113220 : S/N GT120 GLAT1828
- TPS CCA; LAT-DS-02388 WO# 112073 : S/N GT120 GLAT1790
- 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# 113111 : S/N GT110 GLAT1799
- TEM CCA; LAT-DS-01646 WO# 112010 : S/N GT110 GLAT1761
- 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.) (✓)

( LAT-DS-02388 / 2305, 2323, 2294 )

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 - 57 )
- 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 )

END-ITEM DATA PACKAGE – LAT-DS-01643; Serial Number: \_\_\_\_\_

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: \_\_\_\_\_

TR# vs. TPS CCA LAT-DS-02388: \_\_\_\_\_

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

( LAT-DS-02388/29666, 32999 LAT-DS-01646/29534, 30429 )

(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

¾ view of TEM LAT-DS-01481  ¾ view of TPS Unit LAT-DS-01482


¾ view of TEM/TPS Unit LAT-DS-01643

Completed by: Teriia Martinez

Date: 6-30-05

GTC QA Acceptance:  \_\_\_\_\_

Date: 6-30-05

SLAC QAR Acceptance:  \_\_\_\_\_

Date: 7.18.05

GENERAL TECHNOLOGY CORP.  
1450 MISSION AVENUE NE  
ALBUQUERQUE NM 87107  
TE 81666

SHIPPER  
SHIPPER NUMBER F17301.14  
SALES ORDER NUMBER F17301  
SHIP DATE 06/29/05  
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: FREPAID AND ADD

-----  
CUSTOMERS PO: 0000053827 RESALE.NO:

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

Special Inspection is required.

LI#	ORDER/	QTY	UM	PART/DESCRIPTION	UNITS/PKG	SHIP	QTY	LOT NO
1.1	12	EA		LAT-DS-01643 ASSY, UNIT-TEM/TPS S/N: GT118 GLAT1845. QTY DUE...: 4	52	1.00	1	131748

SHIP.V24: UPCR  
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 issued 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 UOON 200.031

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

*Judith Martinez* 6/29/05  
Quality Assurance Signature's Date

WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 1

ASSY/FN# LAT-DS-01643  
ASSY. UNIT-TEM/TPS

WOB 113337  
REV 05-05-05  
REL. DATE 04-21-05  
REV 17-01-05  
WOB 000053627

CUST #  
PROJECT #  
CUST #

QTY  
17301  
16386

\*SERIAL NUMBER \*\*\*\*\*

GT118 GLAT1845

\*\*\*\*\*APPROVAL:\*\*\*

PROD: LAT 5-3-05  
OR 10/14/5.3.05

\*WORKMANSHIP:\*\*\*\*\*  
IPC/EIA-J-STD-001C CLASS 1; 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.

\*G18 02.02 05\*\*\*\*\*

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



1 200 00 CONFIG RECORD/KITTING 0.0000 0.0000 0.0000  
CONFIG

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
DOCUMENT NUMBER REV ED/PL OUTSTANDING ED'S  
ASSY DWG: LAT-DS-01643 53 NONE  
BOM PL: (SAME - ON DWG)  
CUST SOW: LAT-PS-03615/05078 00 NONE  
VISE/TC: (NOT APPLICABLE; WAS SK-202, SOW DELETED GTC 10.)  
ASSY AID: LAT-DS-01643 (RELEASED PER EC 2470)  
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 \_\_\_\_\_ John



2 201 00 STOCKROOM/KITTING AREA 0.0000 0.0000 0.0000  
KITTING

\* PROCESS MATERIAL PER CAA STEP 2.

DATE... QTY... REMARKS..... STATUS  
5/17/05 1 \_\_\_\_\_ LATA  
\_\_\_\_\_ \_\_\_\_\_ SCCA

ESD SENSITIVE



1: PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/PN# LAT-DS-01643  
ASSY. UNIT-TEM/TPS

WC# 113237  
REQ DATE 05-26-05  
REL DATE 04-21-05  
SUN 517301  
PO# 0000082027

CUST #  
PROJECT# 1  
CUST# 15166

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



3 210 00 CCA/BLACK BOX ASSY AREA  
INSTALL SCREWS JOINING  
THE TEM & TPS BOX ASSYS.

PROCESS ASSY PER CAA STEP 3.

DATE... QTY... REMARKS... STATUS  
06/29/05 1 \_\_\_\_\_ Byp(1200)



4 210 00 CCA/BLACK BOX ASSY AREA  
TORQUE FASTENERS.

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

DATE... QTY... REMARKS... STATUS  
06/29/05 1 \_\_\_\_\_ Byp(1200)

6.20.051 WITNESS TORQUE



5 210 00 CCA/BLACK BOX ASSY AREA  
STAKE BOLT HEADS.

PROCESS ASSY PER CAA STEP 5.  
RECORD MATERIAL DATA BELOW:  
ADHESY 0251: GTC PC# 31403 EXPIRATION DATE 01/31/07  
CURE DATE/TIME: START-06/29/05 STOP-

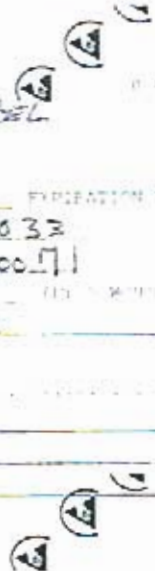
DATE... QTY... REMARKS... STATUS  
06/29/05 1 \_\_\_\_\_ Byp(1200)

7 210 00 CCA/BLACK BOX ASSY AREA  
ASSY MARKING

PROCESS ASSY PER CAA STEP 7.  
RECORD MATERIAL DATA OF GUN:  
INK SPRAYER: GTC PC# 31201 EXPIRATION DATE 04/27/07  
LOT # (PT A): 200409080032  
LOT # (PT B): 200407020071  
MIX PREP (PT A WHIP) 10 gr (1) WHIP 0.6 gr  
MARKING DATE/TIME: 06/29/05  
CURE OCCUR AT STAYING STEP 13.

DATE... QTY... REMARKS... STATUS  
06/29/05 1 \_\_\_\_\_ Byp(1200)

3M  
3M



Handwritten notes and signatures

WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 3

ASSY/PN# LAT-DS-01643  
ASSY UNIT-ITEM/75

NO# 113137  
DATE 09-06-05  
DATE 09-06-05  
P17301-05  
0000093627

CUST P#  
QTY 1  
PROJECT# P17301  
CUST# 19156

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



4 280 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OFF: SLDR-0 ASSY-122

PROCESS ASSY PER CAA STEP 6.

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

DATE	QTY	REMARKS	STATUS
6/30/05	1		
_____	_____	_____	_____
_____	_____	_____	_____



7 280 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
EXAMINE BOX JOINING  
AND BID PACKAGE

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 GTC-129).

DATE	QTY	REMARKS	STATUS
6/30/05	1	GLAT 1895	
_____	_____	_____	_____
_____	_____	_____	_____



8 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OFF: SLDR-0 ASSY-37

PROCESS ASSY PER CAA STEP 8.

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

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

DATE	QTY	REMARKS	STATUS
6/30/05	1		
_____	_____	_____	_____
_____	_____	_____	_____

ORDER # 111237  
 SLY # LAC-12-01487  
 WIP LOCATION: W02  
 DATE PULLED \_\_\_\_\_

( NEW )  
 WORK ORDER PICK LIST  
 BY LINE ITEM

PAGE: 1  
 EFFECTIVITY DATE: 01-13-18  
 RELEASE DATE: 04-21-03  
 DATE PRINTED: 05-17-08

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

LINE	PART NUMBER AND DESCRIPTION	UNIT	QUANTITY	STAT	REQUIREMENTS		REQD IN LOT #	INVLCC NUMBER	INVENTORY DETAIL				
					QUANTITY	STATUS			LOC	QUANTITY	LOT	DATE	BIN
1	LAC-12-01487 SCREW, WASH CAP, 4344-102 ORIGINAL QUANTITY	EA	40.00	ASVD	40.00		110307	SKCF1 FN-D3	100307	40	09-11-07	IN ASSY	
2	1194 ADHESIVE, HYDOL 400 ALT ORIGINAL QUANTITY	OE	1.00	90	1.00			SKCF2 FN-D4		0.00			

WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 1

ASSY/PN# LAT-DS-01482  
ASSY, GLAST, DRG, TFS

WO# 113220  
REV DATE 05-06-05  
REL DATE 01-20-05  
WOB# F17300  
PO# 0000049900

CUST P#  
QTY 1  
PROJECT# F17300  
CUST# 19359

\*SERIAL NUMBER \*\*\*\*\*  
GT120 GLAT1828

APPROVAL:\*\*\*  
PROD: LH/5-3-05  
call 1-3-05

\*WORKMANSHIP\*\*\*\*\*  
IPC/EIA-3-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.  
-plh 09.28.04\*\*\*\*\*

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



1 200 00 CONFIG RECORD/KITTING 0.0000 0.0000 0.0001  
CONFIG

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
DOCUMENT NUMBER REV TO/PL OUTSTANDING EO'S  
ASSY DWG: LAT-DS-01482 55 NONE  
RCM PL: (SAME - ON DWG)  
MST SCW: LAT-PS-C3C78 03 NONE  
EOD TEST: N/A THIS LEVEL)  
ASSY AID: LAT-DS-01482 - (RELEASED PER EC 2477)  
CUSTOMER NAME: SLAC (STANFORD LINEAR ACCELERATOR CENTER)  
\*\*\*\*\* BUILT DOCUMENTS \*\*\*\*\*  
USE... WORK ORDER, CONTROLLED ASSEMBLY AID, & DRAWINGS.  
\*\*\*\*\* SEE FOOTER OF WORK ORDER FOR REV HISTORY \*\*\*\*\*

DATE ... QTY... REMARKS..... STATUS  
5/7/05 \_\_\_\_\_ set



2 100 00 STOCKROOM/KITTING AREA 0.0000 0.0000 0.0000  
KITTING

\* PROCESS MATERIAL PER QAR STEP 2:

DATE QTY... REMARKS... STATUS  
5/11/05 1 \_\_\_\_\_ UNDER STOCK





PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/FN# CAT-35-01492  
ASSY, GLAST, DAD, 179

WO# 113220  
RDO DATE 05-06-05  
REL DATE 04-20-05  
SOR #17100  
PCN 000048800

CUST #  
QTY 1  
PROJECT# P17100  
CUST# 10056

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



3 010 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
APPLY ADHESIVE

PROCESS ASSY PER CAA STEP 3.

RECORD ADHESIVE DATA BELOW:

GTC PO# 32131 EXP. DATE 10/01/05  
LOT #1# PT A# 32775 (PT B#) 32775  
MIX RECORD (PART A WGT) 15 gr (PART B WGT) 1 gr

DATE	QTY	REMARKS	STATUS
06/29/05	1		Buy (1288)



4 010 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: GT120

DATE	QTY	REMARKS	STATUS
06/29/05	1		Buy (1288)



5 21 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-951 1/2 CAL DUE DATE 08/05  
GTC-E-944 CAL DUE DATE 08/05

DATE	QTY	REMARKS	STATUS
06/29/05	1		Buy (1288)
06/29/05	1	WITNESS TORQUE	



WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 3

ASSY/FN# LAT-09-01462  
ASSY. GLAST. DAQ. TFS

W# 119220  
REQ DATE 09-06-06  
REL DATE 04-20-06  
SQ# P17100  
PC# 0000048800

CUST P#  
QTY 1  
PROJECT# F17100  
CUST# 16356

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



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

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

ALHSV 0161: GTC FOR 31403 EXPIRATION DATE 01/31/07  
CURE DATE/TIME: START- 06/29/05 12:30 PM STOP.

DATE	QTY	REMARKS	STATUS
06/29/05	1		BLP(1288)



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

- PROCESS ASSY PER CAA STEP 13.

DATE	QTY	REMARKS	STATUS
06/29/05	1		BLP(1288)



14 290 00 QUALITY ASSURANCE AREA  
CPE: SLDR-0 ASSY-257 0.0000 0.0000 0.0000

- PROCESS ASSY PER CAA STEP 14

RECORD DEFECT REPORT NO. IF APPLICABLE.

DATE	QTY	REMARKS	STATUS
6/29/05	1		



15 290 00 SOURCE INSPECTION  
EXAMINE ASSY PAB-CLOSE 0.0000 0.0000 0.0000

- PROCESS ASSY PER CAA STEP 15

RECORD DEFECT REPORT NO. IF APPLICABLE.

DATE	QTY	REMARKS	STATUS
6/29/05	1	QUAL 1829	



WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 7

ASSY/PN# LAT-DS-01452  
ASSY. GLAST. DAD. 175

WO# 113330  
REQ DATE 05-06-05  
REL DATE 04-20-05  
SQ# 717300  
PC# 0000046800

CUST ID#  
QTY 1  
PROJECT# 717300  
CUST# 15256

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



19 010 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE BOLT HEADS

- PROCESS ASSY PER CAA STEP 19.
- RECORD MATERIAL DATA BELOW.

ADRSV 0151. GTC PO# 31403 EXPIRATION DATE 01/31/07  
CURE DATE/TIME: START-06/29/05 12:30 PM STOP-

DATE	QTY	REMARKS	STATUS
06/29/05	1		By (1088)



20 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OP# RLD-0 ASSY-10

- PROCESS ASSY PER CAA STEP 20
- RECORD DEFECT REPORT NO. IF APPLICABLE: \_\_\_\_\_

DATE	QTY	REMARKS	STATUS
6/29/05	1		



21 260 00 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
6-29-05	1	GCAT 1828	

\*\*\*\*\* TRAVELLER REVISION HISTORY RECORD \*\*\*\*\*  
 CREATED BY: \_\_\_\_\_ FOR ASSY REV: \_\_\_\_\_ DATE: \_\_\_\_\_  
 REFRIN \_\_\_\_\_ SS \_\_\_\_\_ 042203  
 ASSY CHG CHG  
 REV BY DATE CHANGE DETAIL  
 \*\*\*\*\*  
 01 JLN 042203 RELEASED AT REV 01, AND CAA AT REV 01

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



112220  
 SLY # - LAT 05-0182  
 WIP LOCATION: 802

( NEW )

WORK ORDER PICK LIST  
 BY LINE ITEM

EFFECTIVITY DATE: 05-03-07  
 REVISION DATE: 04-03-07  
 CHANGE PRINTED: 1 00:47:00

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

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

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STATUS	RESV IN QUANTITY	LOT #	INVLOC	LOC NUMBER	INVENTORY DETAIL			
									LOT QUANTITY	LOT DATE	SIN QUANTITY	
1	LAT-05-00885 BASE BOX 1PS ORIGINAL QUANTITY	EA	1.00	RSVD	1.00	121225	SKCF2 FN-1	121225	1	09-30-07	SLAC	1
2	LAT-05-00956 LID BOX 1PS ORIGINAL QUANTITY	EA	1.00	RSVD	1.00	121224	SKCF2 FN-2	121224	1	09-30-07	SLAC	1
3	LAT-05-00188 COA SLAST 1PS ORIGINAL QUANTITY	EA	1.00	BO	1.00		SKCF2 FN-3		0			0
4	NAE1382N4-8 SCREEN ORIGINAL QUANTITY	EA	30.00	RSVD	30.00	115013	SKCF2 FN-4	115013	30	07-27-04	DOT 118	1
									100	04-13-05	IN ASSY	
5	NAE220C4 WASHER, FLAT, SS, 115'ID, 2 ORIGINAL QUANTITY	EA	12.00	BO	12.00		SKCF2 FN-5		0			0
6	NAE1352N4-4 SCREEN ORIGINAL QUANTITY	EA	20.00	RSVD	20.00	115019	SKCF2 FN-6	115019	20	09-27-04	FL7300	1
									84	12-16-04	IN ASSY	
7	0151 ADHESIVE: NY50L 400 M2 ORIGINAL QUANTITY	OZ	1.00	BO	1.00		SKCF2 FN-7		0			0
8	CV-0046 RTV NY50L TECH ORIGINAL QUANTITY	OZ	1.00	BO	1.00		SKCF2 FN-8		0			0
9	ELTOM-074 1/8" CABLE LOCKING BANDUIT ORIGINAL QUANTITY	EA	5.00	BO	5.00		SKCF2 FN-9		0			0
10	NAE1352N4-4 SCREEN ORIGINAL QUANTITY	EA	4.00	BO	4.00		SKCF2 FN-10		0			0
11	004-1104 ADHESIVE ORIGINAL QUANTITY	OZ	0.01	BO	0.01		SKCF2 FN-11		0			0
12	LAT-05-00885 LABEL, FN ORIGINAL QUANTITY	EA	1.00	BO	1.00		SKCF2 FN-12		0			0



ORDER 118200

( NEW )

WORK ORDER PICK LIST

PAGE 2

ASSEMBLY # LAT-09-01482  
AQ QUANTITY 1  
AIP LOCATION W02

BY LINE ITEM

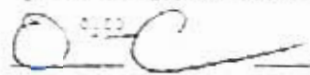
ISSUE DATE 08-11-08  
ISSUE TIME 08:11:08  
ISSUE USER 08-11-08

DATE FILLED:

FILLED BY:

LINE	PART NUMBER AND DESCRIPTION	REQD QUANTITY	CURR STATUS	REQUIREMENTS		ASBY IN	LOT	INVL0C NUMBER	INVENTORY DETAIL						
				QUANTITY	LOT #				LOT QUANTITY	LOT DATE	INVL0C	BIN	QUANTITY		
03	5723-55-4440 BACKPOST, K-F 440X 18X 1/2 ORIGINAL QUANTITY	EA 2.00	SO	2.00	00	0.00		SKETS PH011							

FILLED:



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 1

ASSY/DWG: LAT-02-024  
PCA: GLAG 103

WC# 112079  
PROJ DATE 02-10-05  
REV DATE 12-01-04  
WOB 1000045800

CUST #  
CITY  
PROJECT 1  
117300  
CUST# 18388

SERIAL NUMBER  
GT120 GLAT1790

APPROVAL  
PROD. RA 2/10/05  
CAJA 2-10-05

WORKMANSHIP:-----  
IPC/EIA-3-STD-001C 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.  
-310 02.07.05-----

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



1 200 00 CONFIG RECORD/KITTING 0 0000 0 0000 0 0000  
CONFIG

CONFIGURATION DOCUMENTS  
DOCUMENT NUMBER REV FD/PL OUTSTANDING EO'S  
ASSY DWG: LAT-DR 02388 2/28 NONE  
SCM PL: LAT-TO 02391 EC NONE  
CUST SCW: LAT-PS 03078 03 NONE  
SSS TEST: N/A NONE  
ASSY AID: LAT-DS-02388 - (RELEASED PER EC 2092)  
CUSTOMER NAME: SLAC (STANFORD LINEAR ACCELERATOR CENTER)  
BUILD DOCUMENTS  
Use... WORK ORDER, CONTROLLED ASSEMBLY AID, & DRAWINGS.  
(REV'D/PREP'D BY: GH (DATE)DATE: 02.07.05

SAB 4-28-05

Table with columns: DATE, QTY, REMARKS, STATUS. Includes handwritten date 2-10-05 and signature.



1 201 00 STOCKROOM/KITTING AREA 0 0000 0 0000 0 0000  
KIT PARTS

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

Table with columns: DATE, QTY, REMARKS, STATUS. Includes handwritten date 2-10-05 and signature.



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK UNDER TRAVELLER - NEW

PAGE 2

ASSY/PN# LAT-DS-02355  
CAA, GLAST, TPS

WO# 111073  
SRO DATE 03-10-05  
SEL DATE 10-01-04  
SC#  
PO# 0000143900

CUST #  
PROJECT# 1  
PROJ QTY 117300  
CUST# 15385

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



2 213 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
MARK GTC SN

\* PROCESS PER CAA STEP 3.

DATE... QTY... REMARKS... STATUS  
2-11-05 1  PF 1857



3 213 01 SMT ASSY LINE 0.0000 0.0000 0.0000  
PRE-SMT BAKEOUT

\* PROCESS PER CAA STEP 4.

RECORD BAKE DATE-TIME START/STOP BELOW:

BAKE DATE: 2-11-05 START 10:12 STOP 12:12

DATE... QTY... REMARKS... STATUS  
2-11-05 1  PF



4 213 00 SMT ASSY LINE 0.0000 0.0000 0.0000  
STENCIL BOTTOM SIDE

\* PROCESS PER CAA STEP 5.

\* RECORD SOLDER PASTE DATA BELOW:

GTC FC# 31728 EXPIRATION DATE 7-14-05

DATE... QTY... REMARKS... STATUS  
2-17-05 1  112 186



5 213 00 SMT ASSY LINE 0.0000 0.0000 0.0000  
PICK-N-PLACE PARTS

\* PROCESS PER CAA STEP 6

DATE... QTY... REMARKS... STATUS  
2-11-05 1  65

- 001 - .0077
- 008 - .0078
- 011 - .0076
- 0 - .0077
- 012 - .0070
- 057 - .0070
- 0122 - .0077
- 0134 - .0073

Solder Paste Data BOTH SIDES  
 Mean: .0068  
 Avg: .0076  
 Range: .0066  
 Measurement  
 To Line 150  
 MR 186  
 2/17/05

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/ENS LAT-08-02488  
CAA, START, TPR

WOM 112073  
ASO DATE 02-10-05  
SEL DATE 12-01-04  
POM 0000048800

COST PR  
QTY 1  
PROJECT# 117300  
CUST# 111111

PAGE 3

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



1 011 00 SMT ASSY LINE SOLDER REFLOW 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 7.

DATE...	QTY...	REMARKS.....	STATUS
2/17/05	1		PF



8 011 00 SMT ASSY LINE AQUEOUS CLEAN 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 8.

DATE...	QTY...	REMARKS.....	STATUS
2/17/05	1		PF



90 00 QUALITY ASSURANCE AREA  
OP#: 5LDR-1255 ASSV-1645 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 9.

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

DRR#(S)

DATE	QTY	REMARKS.....	STATUS
2/18/05	1		PF

\* CAA Short Inspection 48045  
2/17/05



10 112 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:

SIC FOR: 112073 EXPIRATION DATE 2/18/05

DATE	QTY	REMARKS.....	STATUS
2/17/05			PF

114 - 0071  
1255 - 0072  
1124 - 0072  
4601 - 0076  
112 - 0071



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER \* NEW

PAGE 4

ASSY/FIN# LAT-DS-02229  
CQA GLAST. IFS

WO# 112073  
XSD DATE 02-10-05  
REL DATE 12-01-04  
SCH#  
PC# 0000048800

CUST P#  
QTY  
PROCESS#  
COST#  
1  
127300  
10356

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



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

\* PROCESS PER CAA STEP 11.

DATE	QTY	REMARKS	STATUS
2-22-05	1	2011	27



12 213 00 SMT ASSY LINE SOLDER REFLOW 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 12.

DATE	QTY	REMARKS	STATUS
2-22-05	1		28



13 213 00 SMT ASSY LINE AQUEOUS CLEAN 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 13.

DATE	QTY	REMARKS	STATUS
2-22-05	1		28



14 290 00 QUALITY ASSURANCE AREA  
CPE: SLDR-1421 ASSY-796 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 14.

\*\* RECORD EFFECT RECORD REPORT NUMBER(S) BRN

REP#(S): 29666

DATE	QTY	REMARKS	STATUS
2-25-05	1	GT10 Post Reflow	28

\* Missing 1200 BR at 2-22-05  
 \* Missing 1200 BR at 2-22-05  
 \* Missing 1200 BR at 2-22-05  
 \* Missing 1200 BR at 2-22-05  
 \* Missing 1200 BR at 2-22-05

03/22/05 filled shortage of DS00, DS01, DS04, DS07, DS0E, D601, D602, D607 & D608.  
 3/31/05

4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

SY/PNS LAT DS-02338  
A. GLASS. SPR

WQ# 112073  
REQ DATE 12-10-06  
REL DATE 12-01-04  
SOP  
PO# 000048800

JUST PR  
QTY  
PROJECT# P17300  
CUST# 15100

PAGE 5

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



15 210 00 CCA/BLACK BOX ASSY AREA  
TIN THRU-HOLE PARTS 0.0000 0.0000 0.0000

03/15/05 Stripped wires (35) MV  
3/15/05 Stripped wires (35) MV  
03/15/05 Tinned wires (35) MV  
3/15/05 wrap of tinned wires (35)

- \* PROCESS PER CAA STEP 15.
- \* SPECIAL IN-PROCESS QA EXAMINATION OF IC LEAD PREP AND SHORT WIRE PASS.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DEF#(S)

DATE	QTY	REMARKS	STATUS
3/10/05	1	Tinned	262262
3/14/05		Tinned leads	251695



16 210 00 CCA/BLACK BOX ASSY AREA  
MECH ASSY - HTANKS/VRS 0.0000 0.0000 0.0000

- \* PROCESS PER CAA STEP 16.
- \* RECORD ADHESIVE DATA BELOW:  
GTC PC# 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
04/06/05	1	Installed heat sinks	644
04/12/05	1	Installed VRS (GTC-A-976)	644



17 210 00 CCA/BLACK BOX ASSY AREA  
TERMINATE VRS 0.0000 0.0000 0.0000

- \* PROCESS PER CAA STEP 17
- | DATE     | QTY | REMARKS                | STATUS |
|----------|-----|------------------------|--------|
| 03/22/05 | 5   | stripped wires         | MV     |
| 03/22/05 | 5   | Tinned wires           | MV     |
| 04-13-05 | 1   | Installed wires on VRS | 644    |

← Special in-process QA Examination of Wires.  
Mtz. 4-7-05  
tinned wires for VRS  
3/22/05



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 6

ASSY/IN# 147-DS-02332  
CCA GLAST. TFS

W/O# 112073  
REL. DATE 02-10-05  
REL. DATE 12-01-04  
PO# 000046800

CUST. #  
QTY  
PROC. # P17300  
CUST# 12355

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



18 210 00 CCA/BLACK BOX ASSY AREA  
INSTALL/SOLDER W1, W2 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 18.

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

*move to install + solder to  
STEP 26  
ME 4-7-05*



19 210 00 CCA/BLACK BOX ASSY AREA  
INSTALL/SOLDER IC WIRES 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 19.

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

04/13/05 1 installed wires *(Signature)*



190 00 QUALITY ASSURANCE AREA  
OPE. SLDR. TO ASSY-41 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 20.

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

DRR#(S)

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

7/13/05 1 *(Signature)*



22 210 00 CCA/BLACK BOX ASSY AREA  
MECH ASSY-BOTTOM ICS 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 21.

\* RECORD ADHESIVE DATA BELOW:

JIC #0# 31450 EXPIRATION DATE 05/17/05

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

TOOL # GTC-A-985 CAL DUE DATE 06/22/05

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

04/13/05 1 *(Signature)*



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 7

ASSY/PN# LAT-DS-03288  
CCA, GLAST, TFS

MO# 112073  
REQ DATE 02-10-05  
REL DATE 12-01-04  
SOP  
PO# 0003049930

CUST #  
QTY  
PROJECT # 117300  
COST# 16359

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



22 210 00 CCA/BLACK BOX ASSY AREA  
INSTALL/SOLDER WIRES-105 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 22.

DATE	QTY	REMARKS	STATUS
04/18/05	1	uninstalled IC's <del>soldered wires</del>	ByP
04/18/05	1	soldered wires	ByP



23 220 00 QUALITY ASSURANCE AREA  
CPE - SLDX-35 ASSY-24 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 23.

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

DEF#(S)

DATE	QTY	REMARKS	STATUS
4/18/05	1		ByP



24 210 00 CCA/BLACK BOX ASSY AREA  
INSTALL/SOLDER Q504, Q604 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 24.

\*\* RECORD ADHESIVE DATA BELOW.

GTC PO# 31450 EXPIRATION DATE 05/17/05

DATE	QTY	REMARKS	STATUS
04/21/05	1	installed & soldered Q504 & Q604	ByP RTC 1298 04/21/05



25 210 00 CCA/BLACK BOX ASSY AREA  
INSTALL/SOLDER CAPS 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 25.

DATE	QTY	REMARKS	STATUS
3/16/05	1	Prep Caps	SC 1507
04/22/05	1	installed & soldered caps	ByP



PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/PKG LAT-DS-02388  
CCA, GLAST, VPS

WOB 112073  
MDD DATE 03-10-05  
MDF DATE 03-01-02  
MDF 000000000

CUST #  
QTY  
PROJECT  
CUST#

PAGE 5

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



24 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL/SOLDER P. R T

\* PROCESS PER CAA STEP 26.

RI + R2 ME 4-7-05

04/19/05 filled shortage  
of CR2. <sup>By</sup> 04/19/05

DATE QTY REMARKS STATUS  
04/22/05 1 (1288) By



27 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
QPE. SLDG-76 ASSY-33

\* PROCESS PER CAA STEP 27.

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

DRR#(S)

DATE QTY REMARKS STATUS  
4/22/05 1 (1288) By



28 265 00 SFEA LOT 0.0000 0.0000 0.0000  
SFEA TEST

\* PROCESS PER CAA STEP 28.

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

TDRR#(S)

DATE QTY REMARKS STATUS  
4.22.05 1 SN - GT120 (less D505 + D605) dnc PASSED



29 212 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL/SOLDER IP CABLE

SLDR 1/7 ROW 1 CHECK 04-25-05 (M D)

SLDR 1/9 ROW 1 CHECK 04-25-05 (M D)

\* PROCESS PER CAA STEP 27.

DATE QTY REMARKS STATUS  
04/25/05 1 soldered Row #1. (1288) By  
04/25/05 1 soldered Row #2. (1288) By  
04/25/05 1 soldered Row #3. (1288) By

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/DNS LAT-DS-02388  
CCR, CLAST, TRS

W# 112173  
REQ DATE 02-10-09  
REL DATE 12-01-04  
SOS  
PCS 0000048800

CUST #  
QTY  
PROJECT# P17300  
CUST# 15355

PAGE 3

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



30 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL/SOLDER O/P CABLE  
SLDR O/P-ROW 1-CHECK 04-25-05 M.D.  
SLDR O/P-ROW 2-CHECK 04-26-05 M.D.  
SLDR O/P-ROW 3-CHECK 7-26-05  
SLDR O/P-ROW 4-CHECK 7/26/05

\* PROCESS PER CAA STEP 30.

DATE	QTY	REMARKS	STATUS
04/25/05	1	soldered Row #1.	Byp
04/26/05	1	soldered Row #2.	Byp
04/26/05	1	soldered Row #3.	Byp
04/26/05	1	soldered Row #4.	Byp



31 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OPE: SLDR-98 ASSY-107

\* PROCESS PER CAA STEP 31.

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

DEFECT(S)

DATE	QTY	REMARKS	STATUS
7/26/05	1		



32 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
HANDS CLEAN

\* PROCESS PER CAA STEP 32.

DATE	QTY	REMARKS	STATUS
05/03/05	1	washed	Byp

05/04/05 filled shortage of DSOS & DBOS. Byp 05/06/05

WORK CELL: 4-MIXED

CUSTOMER: ELAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/PK# 121-05-02358  
UCA, GLAST. 715

WOP 112073  
REQ DATE 02-10-05  
REL DATE 12-01-04  
SC#  
PO# 0000048800

CUST P#  
QTY 1  
PROJECT# P17300  
CUST# 15356

PAGE 10

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



33 250 00 COATING/POTTING AREA  
DOT WITH RTV - CABLE  
DCG-1104 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 33

RTV DCG-1104, SCC PO# 31695 EXPIRATION DATE 08/21/05

SEE ADHESIVE 0491 APPLICATION FOR CURE DATA.

DATE	QTY	REMARKS	STATUS
05/16/05	1		ByP



34 210 00 CCA/BLACK BOX ASSY AREA  
STAKE WITH RTV - VRS  
DCG-1104 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 34

ME 3-14-05

ME 3-14-05

RECORD DEFECT REPORT NUMBER(S) BELOW

RTV DCG-1104 PO# 31695 EXP. DATE 08/21/05

DATE	QTY	REMARKS	STATUS
05/16/05	1		ByP

ME 3-14-05



35 210 00 CCA/BLACK BOX ASSY AREA  
POTTING/STAKING 105 0.0000 0.0000 0.0000

\* PROCESS CAA PER CAA STEP 35

RTV DCG-1104  
3-14-05

ME 3-14-05  
Date 08/21/05

ME 3-14-05

OPEN-CURE-DATE PO# 31695 START STOP

DATE	QTY	REMARKS	STATUS
05/16/05	1		ByP

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 11

ASSY/IN4 LAT-DS-02388  
CCA, CLAST, OPS

WOB 112173  
MFG DATE 02-10-05  
REL DATE 12-01-04  
SOP  
PO# 0000048800

CUST #  
PROJECT# P17300  
DUST# 10396

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



36 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE HARDWARE - NUTS,  
WASHERS, STUDS, SCREWS

\* PROCESS PER CAA STEP 36

ADHESIVE 0151, GTC PO# 31403 EXPIRATION DATE 01/31/07  
CURE DATE 05/16/05 START 1:05 PM STOP 3:05 PM

DATE... QTY... REMARKS..... STATUS  
05/16/05 1 (GTC 1298) Buy



37 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL/STAKE SUPPORTS

\* PROCESS PER CAA STEP 37

ADHESIVE 0151, GTC PO# 31403 EXPIRATION DATE 01/31/07  
CURE DATE 05/16/05 START 1:05 PM STOP 3:05 PM

DATE... QTY... REMARKS..... STATUS  
05/16/05 1 (GTC 1298) Buy



38 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE COMPONENTS - Q550,  
Q550, P2-P5

\* PROCESS PER CAA STEP 38

ADHESIVE 0151, GTC PO# 31403 EXPIRATION DATE 01/31/07  
CURE DATE 05/16/05 START 1:05 PM STOP 3:05 PM

DATE... QTY... REMARKS..... STATUS  
05/16/05 1 (GTC 1298) Buy



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 13

ASSY/PW/ LAT-DS-12388  
CCA, CLAS7, TBS

WO# 112073  
REQ DATE 02-10-05  
REL DATE 12-01-04  
COS  
PO# 0000048500

CUST #  
PROJECT# P17300  
CUST# 15356

\*\*\*\*\*  
L1# DEPT MACH# OP# DESCRIPTION..... H O U R S  
SET-UP RUN... LINE-MACH ST-LOC  
\*\*\*\*\*



39 317 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE INDUCTORS

\* PROCESS PER CAA STEP 39.

ADHESIVE 0151, GTC PO# 31403 EXPIRATION DATE 01/31/07

CURE DATE 05/16/05 START 1:05 PM STOP 3:05 PM

DATE... QTY.. REMARKS..... STATUS  
05/16/05 1 ..... (GTC 429) Byp



40 310 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE CAPACITORS AND R22, R1 & R2

\* PROCESS PER CAA STEP 40.

ADHESIVE 0151, GTC PO# 31403 EXPIRATION DATE 01/31/07

CURE DATE 05/16/05 START 1:05 PM STOP 3:05 PM

DATE... QTY.. REMARKS..... STATUS  
05/16/05 1 ..... (GTC 429) Byp

LAB 4-28-05



41 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OP#- SLDR-0 ASSY-87

\* PROCESS PER CAA STEP 41.

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

ERR#(S)

DATE... QTY.. REMARKS..... STATUS  
5/17/05 1 .....

WORK CELL: 4-MIXED

CUSTOMER: SLAC

1 PRODUCTION

WORK UNDER TRAVELLER - NEW

PAGE 10

ASSY/PN: LAT-DS-02266  
UCA: GLAT, TFS

WC# 112073  
REF DATE 02-21-06  
REL DATE 12-21-04  
SQ#  
PO# 0000048800

CUST #  
PROJECT# P17300  
CUST# 18358

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



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

\* PROCESS PER CAA STEP 42  
(SOM MANDATORY INSPECTION POINT - MIP)

DATE... QTY.. REMARKS  
6.13.05 1 GLAT 1790



43 289 00 PACKAGING/SHIPPING INSP 0.0000 0.0000 0.0000  
PACKAGE & SHIP OCA FOR  
TEST W CUSTOMER

\* PROCESS PER CAA STEP 43

DATE... QTY.. REMARKS  
06/14/05 1

STATUS  
BYP(1288)



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

DRR# S1

DATE... QTY.. REMARKS  
6/23/05 1



GT 120  
Tela Drop Tripped  
25 G (Both)  
50 G (One)



45 281 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
GLAT OAR PRE-COAT INSP  
MANDATORY INSPECTION  
POINT (SOM POINT)

\* PROCESS PER CAA STEP 45

DATE... QTY.. REMARKS  
6.27.05 1 GLAT 1790



WOPY CELL 4-MIXED

CUSTOMER: GLAC

1 PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 14

ASSY/ENG LAT-DC-02388  
CAA, GLAC, 193

WOB 113073  
MATERIAL DATE 01-10-05  
DATE 10-01-04  
JOB# 0000248500

CUST #  
QTY 1  
PROJECT 1813500  
CUST# 1813500

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



46 217 00 CCA BLACK BOX ASSY AREA  
HAND CLEAN AND TEST  
THE CLEANLINESS FOR CCA  
ATTACH RESULTS REPORT TO  
THE TRAVELLER/NO

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

DATE	QTY	REMARKS	STATUS
6/27/05	1		AK1576
6/27/05	1		DM1035



47 220 00 QUALITY ASSURANCE AREA  
OPE. SLIP-0 ASSY-7

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

DNR(S)

DATE	QTY	REMARKS	STATUS
6/27/05	1		( )



48 23 00 COATING/POTTING AREA  
BAKE-OUT AND MASK

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

BAKE DATE: 6-27-05 START: 4:00pm STOP: 5:18pm

DATE	QTY	REMARKS	STATUS
6-27-05	1	Bake-mask	HW

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 15

ASSY/IN# CAT-28-02388  
CLA: SLAC, 115

WOB# 112073  
PBO DATE 02-10-05  
REL DATE 12-01-04  
SOL  
POS 0000048800

CUST #  
CITY 1  
PROJECT# 717300  
CUST# 15355

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



49 250 00 COATING/POTTING AREA 0.0000 0.0000 0.0000  
CONFORMAL COATING

\* PROCESS CAA PER CAA STEP 49

CONFORMAL COATING PO# 31201 EXPIRATION DATE 6-30-05  
AIR CURE DATE 6-27-05 START 6:00pm STOP 6/28/05 6:50am

DATE... QTY... REMARKS... STATUS  
6-27-05 1 Cont 140



50 250 00 COATING/POTTING AREA 0.0000 0.0000 0.0000  
OVEN CURE/POUCHUP

\* PROCESS CAA PER CAA STEP 50

OVEN CURE DATE 6/28/05 START 6:30AM STOP 7:30am  
OVEN CURE DATE 6/28/05 START 8:15am STOP 9:15am

DATE... QTY... REMARKS... STATUS  
6/28/05 1 70 Cont 876

*6/28/05 Baked in out  
SAG 11:00am - 1:00*

*6-28-05 touch up Bake  
7:00 TO 5:00 p.*



51 250 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
EPE SLDR-C ASSY-7

\* PROCESS CAA PER CAA STEP 51

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

- ... COPIES OF CERTIFICATIONS.
- ... OPERATOR SIGNATURES
- ... INSPECTION REPORTS
- ... NON-CONFORMANCE REPORTS
- ... END-ITEM DATA PACKAGE FORM
- ... DIGITAL PHOTOGRAPHS, RECORDED ONTO CD...

DATE... QTY... REMARKS... STATUS  
6/28/05 1 \_\_\_\_\_ 876





WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER \* NEW

PAGE 16

ASSY/P/N# LAT-DS-02388  
CCA: GLAST, 098

WOM 102075  
REQ DATE 12-10-05  
REL DATE 12-31-04  
SO#  
PC# 0000048600

CUST P#  
QTY 1  
PROJECT# P17300  
CUST# 19354

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



52 290 00 SOURCE INSPECTION 0.1010 0.1010 0.0000  
CSI

\* PROCESS CAR PER CAR STEP 52.

NOTE: NEXT ASSEMBLY IS LAT-DS-01482.

*ID 32999*

DATE... QTY... REMARKS.....  
4-28-05 1 CURE TIMES  
DOC ERROR ?  
SEQ 050



*6-29-05*

SERIAL NUMBER ..... APPROVAL:...

PROD: \_\_\_/\_\_\_

CA: \_\_\_/\_\_\_

WORKMANSHIP.....  
IPC/EIA-J-STD-001C CLASS 3; WITH "DS" 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.  
-jlr 02.18.05.....



ASSEMBLY # : LAT-06-02388  
QUANTITY : 1  
LOCATION: W02

BY LINE ITEM

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

DATE PULLED:

PULLED BY:

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STATUS	RESV IN LOT #	INVLOC	LOT NUMBER	INVENTORY DETAIL			
								LOT QUANTITY	LOT DATE	BINLOC	BIN QUANTITY
8	NAS671C6 NUT, #6, SM, DAT Cont from prior page.	EA	19.00			FN-6	117403	57.00	11-04-04	D2H	
							PULLED:				
						FN-6	122961	910.00	02-02-05		
							PULLED:				
						FN-6	122986	500.00	02-03-05		
							PULLED:				
						FN-6	122987	500.00	02-02-05		
							PULLED:				
						SKCP2	44571	18.00	08-19-00	CF3D	
							PULLED:				
							116770	423.00	10-26-04		
							PULLED:				
9	NAS1352ND6-6 SCREW ORIGINAL QUANTITY	EA	7.00			SK2 FN-D7		0.00			
							PULLED:				
				RSVD	7.00	115011	SKCP2	115011	121.00	09-27-04	
							PULLED:				
10	NAS1352ND4-6 SCREW ORIGINAL QUANTITY	EA	4.00			SK2 FN-D8		0.00			
							PULLED:				
				RSVD	4.00	114892	SKCP2	114892	524.00	09-25-04	115
							PULLED:				
							115012	712.00	09-27-04	IN ASSY	
							PULLED:				
11	NAS1149CN632R WASHER ORIGINAL QUANTITY	EA	19.00			SK2 FN-D9		0.00			
							PULLED:				
				RSVD	19.00	115010	SKCP2	115010	327.00	09-27-04	
							PULLED:				
12	NAS671C4 NUT, HEX, SS, PASS, 4-40TRD ORIGINAL QUANTITY	EA	4.00	RSVD	4.00	122091	SK2 FN-D10	122091	199.00	01-20-05	HW7
							PULLED:				
						FN-D10	122142	64.00	01-20-05		
							PULLED:				
						FN-D10	122180	250.00	01-21-05		
							PULLED:				
						FN-D10	123196	2000.00	02-04-05		
							PULLED:				
						FN-D10	123384	320.00	02-07-05		
							PULLED:				

*Handwritten note:* 112073

WBLY # : LAT DS-02188  
 JANTITY : 1  
 LOCATION: W02

BY LINE ITEM

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

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

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

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STATUS	REQUIREMENTS STAT QUANTITY	RESV IN LOT #	INVLOC	LOT NUMBER	INVENTORY DETAIL			
									LOT QUANTITY	LOT LIFE	BINLOC	BIN QUANTITY
12	NAS671C4 NUT HEX SS PASS 4-40THRD Cont from prior page	EA	4.00				FN-D10	123397	610.00	02-07-05		
							FN-D10	123512	60.00	02-07-05		
							FN-D10	123521	155.00	02-07-05		
							FN-D10	123532	160.00	02-07-05		
							FN-D10	123691	700.00	02-07-05		
							SKCF2	115009	21.00	09-27-04	LOT 115	
13	CV-2946 RTV MISTL TECH ORIGINAL QUANTITY...	OZ	1.00	BO	1.00		SK2 FN-D11		0.00			
							SKCF2		0.00			
14	0151 ADHESIVE: EPOXY 40Z KIT ORIGINAL QUANTITY...	OZ	1.00	BO	1.00		SK2 FN-D12		0.00			
							SKCF2		0.00			
15	PLT1X-076 TIE CABLE, LOCKING, SANDUIT ORIGINAL QUANTITY...	EA	5.00	BO	5.00		SK2 FN-D15		0.00			
							SKCF2		0.00			
16	5750 CONFORMAL COATING URELANE ORIGINAL QUANTITY...	OZ	1.00	BO	1.00		SK2 FN-D17		0.00			
							SKCF2		0.00			
17	DC6-1104 ADHESIVE ORIGINAL QUANTITY...	OZ	1.00	BO	1.00		SK2 FN-D18		0.00			
							SKCF2		0.00			
18	M22759/11 34-B WIRE 24AWG, WHITE ORIGINAL QUANTITY...	IN	1.00	RSVD	1.00	46190	SK2 FN-D19	46190 (PCA TERMINATING VAS)	1250.00	09-14-01	SK2 R4	

112071



WORK ORDER : 112073

( NEW )

WORK ORDER PICK LIST

PAGE: 4

WBLY # : LAT-DS-12388  
QUANTITY : 1  
LOCATION: W02

BY LINE ITEM

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

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

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

LINE	PART NUMBER AND DESCRIPTION	UOM	REQUIRED QUANTITY	CURR STATUS	REQUIREMENTS	RESV IN LOT #	INVLOC	LOT NUMBER	INVENTORY DETAIL				
									LOT QUANTITY	LOT DATE	SINLOC	SIN QUANTITY	
	WIRE, 24AWG, WHITE Cont from prior page						SKCF2	115299	17716.00	10-01-04	LOT1152		
19	LAT-DS-04101 HEATSINK ORIGINAL QUANTITY...	EA	2.00				SK2 FN-020		0.00				
			2.00				SKCF2	120304	34.00	09-11-07			
				RSVD	2.00	120304							
20	ARF461 IC FILTER ORIGINAL QUANTITY...	EA	1.00				SK2 FN-34 VRS		0.00				
			1.00				SKCF2	114959	17.00	09-17-04			
				RSVD	1.00	114959							
21	MAX724DCN IC ORIGINAL QUANTITY...	EA	7.00				SK2 FN-06 U6 U7 U8 U10 U15 U17 U18		0.00				
			7.00				SKCF2	114961	249.00	09-27-04			
				RSVD	7.00	114961							
22	5962R98691501VXC IC ORIGINAL QUANTITY...	EA	5.00				SK2 FN-15 U20 U559 U560 U559 U660		0.00				
			5.00				SKCF2	120301	25.00	12-16-04	SKY-10		
				RSVD	5.00	120301							
23	SSR1040GTXY DIODE ORIGINAL QUANTITY...	EA	7.00				SK2 FN-19 D1 D2 D3 D4 D8 D19 D20		0.00				
			7.00				SKCF2	114946	200.00	09-17-04			
				RSVD	7.00	114946							
24	JANTXVIN4153UR-1 DIODE ORIGINAL QUANTITY	EA	8.00				SK2 FN-20 D502 D503 D503 D599 D602 D603 D609 D699		0.00				
			8.00				SKCF2	114949	224.00	09-17-04			
				RSVD	8.00	114949							
25	JANTXVIN8808US DIODE INVERSE ORIGINAL QUANTITY...	EA	8.00				SK2 FN-21 D501 D604 D507 D508 D601 D604 D607 D608		0.00				
			8.00				SKCF2	114950	125.00	09-17-04			
				RSVD	8.00	114950							
26	JANTXVIN6467US DIODE ORIGINAL QUANTITY...	EA	6.00				SK2 FN-23 CR1 CR1 CR1 CR6 CR6 CR6		0.00				
			6.00										



WORK ORDER 112073

( NEW )

WORK ORDER PICK LIST

PAGE: 5

TRLY # : LAT-DS-02388  
QUANTITY : 1  
LOCATION : W02

BY LINE ITEM

EFFECTIVITY DATE: 02-10-05  
RELEASE DATE : 02-11-04  
DATE PRINTED : 02-11-06

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

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

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STATUS	REQUIREMENTS	RESV IN LOT #	INVLOC	LOT NUMBER	INVENTORY DETAIL			
									LOT QUANTITY	LOT DATE	BINLOC	QUANTITY
	DIODE Cont from prior page	EA		RSVD	6 00	114952	SKCF2	114952	149.00	09-27-04		
27	JANTXV1N4106UR-1 DIODE ORIGINAL QUANTITY...	EA	4.00				SK2 FN-24	CR5 D30 D505 D505	0.00			
				RSVD	4.00	114953	SKCF2	114953	4.00	09-27-04		
28	JANTXV1N4494US DIODE ORIGINAL QUANTITY...	EA	1.00				SK2 FN-24	D600	0.00			
				RSVD	1.00	114955	SKCF2	114955	1.00	09-27-04		
29	JANTXV1N4482US DIODE ORIGINAL QUANTITY...	EA	1.00				SK2 FN-22	CR2	0.00			
				RSVD	1.00		SKCF2	114951	1.00	09-27-04		
30	JANTXV2N3439 TRANSISTOR ORIGINAL QUANTITY...	EA	4.00				SK2 FN-81	Q514 Q590 Q64 Q650	0.00			
				RSVD	4.00	115006	SKCF2	115006	4.00	09-27-04		
31	5962R9582602VXC IC ORIGINAL QUANTITY...	EA	6.00				SK2 FN-38	U1 U2 U21 U22 U561 U661	0.00			
				RSVD	6.00	120302	SKCF2	120302	6.00	12-16-04	DRY-10	
32	CDR32BK103BKUS CAP 0.01UF 100V 10% ORIGINAL QUANTITY...	EA	22.00				SK2 FN-4	C1 C5 C9 C91 C93 C95 C97 C94 C62 C88 C73 C76 C110 C114 C115 C165 C506 C896 C898 C676 C896 C698	0.00			
				RSVD	22.00	114937	SKCF2	114937	22.00	09-27-04		
33	CDR08HC106KCS CAPACITOR ORIGINAL QUANTITY...	EA	4.00				SK1 FN-6	C850 C897 C850 C897	0.00			
				RSVD	4.00	114939	SKCF2	114939	4.00	09-27-04		
34	M88106/20-0567H CAPACITOR ORIGINAL QUANTITY...	EA	20.00				SK2 FN-8	C1 C2 C3 C4 C11 C12 C14 C35 C10 C32 C88 C84 C137 C138 C139 C140 C141 C142 C143 C144 C145 C146 C147 C148 C149 C150 C151 C152 C153 C154 C803 C803	0.00			



MBLY # : LAP-05-00358  
QUANTITY : 1  
W.P. LOCATION: W02

BY LINE ITEM

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

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

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

LINE	DESCRIPTION	UNITS	REQUIREMENTS	REQD QUANTITY	CURR STATUS	STAT QUANTITY	RESV IN LOT #	INVLOC NUMBER	LOT	INVENTORY DETAIL	QUANTITY	LOT DATE	BIN	QUANTITY
17	CAPACITOR Cont from prior page.	EA	RSVD	30.00			114941	SKCF2	114941	0.00 PN-13 C801 C802 C810 C811 C814 C840 C801 C808 C810 C811 C814 C840 PULLED:	30.00	09-27-04		
35	1110B563KES1YHTM CAPACITOR	EA	RSVD	12.00			114802	SKCF2	114802	0.00 PN-13 C801 C802 C810 C811 C814 C840 C801 C808 C810 C811 C814 C840 PULLED:	12.00	09-23-04		
36	RXC65 FUSE	EA	RSVD	2.00			114957	SKCF2	114957	0.00 PN-32 F1 F3 PULLED:	2.00	09-27-04		
37	5562L8771002VXA IC	EA	RSVD	2.00			114962	SKCF2	114962	0.00 PN-17 U804 U804 PULLED:	2.00	09-27-04		
38	12786-31 INDUCTOR	EA	RSVD	12.00			114964	SKCF2	114964	0.00 PN-39 L1 L2 L3 L4 L5 L6 L7 L10 L11 L12 L13 L14 PULLED:	12.00	09-27-04		
39	12763-31 INDUCTOR	EA	RSVD	2.00			114965	SKCF2	114965	0.00 PN-40 L801 L801 PULLED:	2.00	09-27-04		
40	18HNJ997014 TRANSISTOR	EA	RSVD	3.00			114966	SKCF2	114966	0.00 PN-41 Q10 Q11 Q12 PULLED:	3.00	09-27-04		
41	W17050PK000 THICK FILM JUMPER	EA	RSVD	15.00			114817	SKCF2	114817	0.00 PN-42 R23 R24 R17 R216 R245 R216 R245 R235 R230 R265 R271 R260 R2100 R2101 R2102 PULLED:	15.00	09-23-04		
											756.00	09-27-04		









JDY # : 141-05-02388  
ANTENNA : 1  
WIP LOCATION: X02

BY LINE ITEM

EFFECTIVITY DATE : 02-10-05  
PRINTED DATE : 09-27-04  
DATE PRINTED : 02-11-05

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

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STAT	REQUIREMENTS		RSVD IN LOC #	LOC	INVENTORY DETAIL					
					STAT	QUANTITY			LOT	LOT QUANTITY	LOT DATE	BINLOC	BIN QUANTITY	
56	CDR315X1238KUS CAPACITOR ORIGINAL QUANTITY...	EA	4.00					SK2 FN-7 C523 C551 C603 C651	0.00					
			4.00					PULLED:						
				RSVD	4.00	114940		SKCF2 114940		4	249.00	09-27-04		
								PULLED:						
57	CDR315X173AKUS CAPACITOR ORIGINAL QUANTITY...	EA	7.00					SK2 FN-9 C6 C7 C32 C36 C63 C74 C77	0.00					
			7.00					PULLED:						
				RSVD	7.00	114759		SKCF2 114759		7	1251.00	09-23-04		
								PULLED:						
								114942			333.00	09-27-04		
								PULLED:						
58	CDR315B170BKUS CAPACITOR ORIGINAL QUANTITY...	EA	4.00					SK2 FN-10 C102 C512 C551 C661	0.00					
			4.00					PULLED:						
				RSVD	4.00	115090		SKCF2 115090		4	561.00	09-28-04		
								PULLED:						
59	CXR027C475KDR CAPACITOR ORIGINAL QUANTITY...	EA	89.00					SK2 FN-11 C11 C111 C113 C115 C117 C119 C121 C123 C125 C127 C129 C131 C133 C135 C137 C139 C141 C143 C145 C147 C149 C151 C153 C155 C157 C159 C161 C163 C165 C167 C169 C171 C173 C175 C177 C179 C181 C183 C185 C187 C189 C191 C193 C195 C197 C199 C200 C201 C202 C203 C204 C205 C206 C207 C208 C209 C210 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 C301 C302 C303 C304 C305 C306 C307 C308 C309 C310 C311 C312 C313 C314 C315 C316 C317 C318 C319 C320 C321 C322 C323 C324 C325 C326 C327 C328 C329 C330 C331 C332 C333 C334 C335 C336 C337 C338 C339 C340 C341 C342 C343 C344 C345 C346 C347 C348 C349 C350 C351 C352 C353 C354 C355 C356 C357 C358 C359 C360 C361 C362 C363 C364 C365 C366 C367 C368 C369 C370 C371 C372 C373 C374 C375 C376 C377 C378 C379 C380 C381 C382 C383 C384 C385 C386 C387 C388 C389 C390 C391 C392 C393 C394 C395 C396 C397 C398 C399 C400 C401 C402 C403 C404 C405 C406 C407 C408 C409 C410 C411 C412 C413 C414 C415 C416 C417 C418 C419 C420 C421 C422 C423 C424 C425 C426 C427 C428 C429 C430 C431 C432 C433 C434 C435 C436 C437 C438 C439 C440 C441 C442 C443 C444 C445 C446 C447 C448 C449 C450 C451 C452 C453 C454 C455 C456 C457 C458 C459 C460 C461 C462 C463 C464 C465 C466 C467 C468 C469 C470 C471 C472 C473 C474 C475 C476 C477 C478 C479 C480 C481 C482 C483 C484 C485 C486 C487 C488 C489 C490 C491 C492 C493 C494 C495 C496 C497 C498 C499 C500 C501 C502 C503 C504 C505 C506 C507 C508 C509 C510 C511 C512 C513 C514 C515 C516 C517 C518 C519 C520 C521 C522 C523 C524 C525 C526 C527 C528 C529 C530 C531 C532 C533 C534 C535 C536 C537 C538 C539 C540 C541 C542 C543 C544 C545 C546 C547 C548 C549 C550 C551 C552 C553 C554 C555 C556 C557 C558 C559 C560 C561 C562 C563 C564 C565 C566 C567 C568 C569 C570 C571 C572 C573 C574 C575 C576 C577 C578 C579 C580 C581 C582 C583 C584 C585 C586 C587 C588 C589 C590 C591 C592 C593 C594 C595 C596 C597 C598 C599 C600 C601 C602 C603 C604 C605 C606 C607 C608 C609 C610 C611 C612 C613 C614 C615 C616 C617 C618 C619 C620 C621 C622 C623 C624 C625 C626 C627 C628 C629 C630 C631 C632 C633 C634 C635 C636 C637 C638 C639 C640 C641 C642 C643 C644 C645 C646 C647 C648 C649 C650 C651 C652 C653 C654 C655 C656 C657 C658 C659 C660 C661 C662 C663 C664 C665 C666 C667 C668 C669 C670 C671 C672 C673 C674 C675 C676 C677 C678 C679 C680 C681 C682 C683 C684 C685 C686 C687 C688 C689 C690 C691 C692 C693 C694 C695 C696 C697 C698 C699 C700 C701 C702 C703 C704 C705 C706 C707 C708 C709 C710 C711 C712 C713 C714 C715 C716 C717 C718 C719 C720 C721 C722 C723 C724 C725 C726 C727 C728 C729 C730 C731 C732 C733 C734 C735 C736 C737 C738 C739 C740 C741 C742 C743 C744 C745 C746 C747 C748 C749 C750 C751 C752 C753 C754 C755 C756 C757 C758 C759 C760 C761 C762 C763 C764 C765 C766 C767 C768 C769 C770 C771 C772 C773 C774 C775 C776 C777 C778 C779 C780 C781 C782 C783 C784 C785 C786 C787 C788 C789 C790 C791 C792 C793 C794 C795 C796 C797 C798 C799 C800 C801 C802 C803 C804 C805 C806 C807 C808 C809 C810 C811 C812 C813 C814 C815 C816 C817 C818 C819 C820 C821 C822 C823 C824 C825 C826 C827 C828 C829 C830 C831 C832 C833 C834 C835 C836 C837 C838 C839 C840 C841 C842 C843 C844 C845 C846 C847 C848 C849 C850 C851 C852 C853 C854 C855 C856 C857 C858 C859 C860 C861 C862 C863 C864 C865 C866 C867 C868 C869 C870 C871 C872 C873 C874 C875 C876 C877 C878 C879 C880 C881 C882 C883 C884 C885 C886 C887 C888 C889 C890 C891 C892 C893 C894 C895 C896 C897 C898 C899 C900 C901 C902 C903 C904 C905 C906 C907 C908 C909 C910 C911 C912 C913 C914 C915 C916 C917 C918 C919 C920 C921 C922 C923 C924 C925 C926 C927 C928 C929 C930 C931 C932 C933 C934 C935 C936 C937 C938 C939 C940 C941 C942 C943 C944 C945 C946 C947 C948 C949 C950 C951 C952 C953 C954 C955 C956 C957 C958 C959 C960 C961 C962 C963 C964 C965 C966 C967 C968 C969 C970 C971 C972 C973 C974 C975 C976 C977 C978 C979 C980 C981 C982 C983 C984 C985 C986 C987 C988 C989 C990 C991 C992 C993 C994 C995 C996 C997 C998 C999 C1000	0.00					
			89.00					PULLED:						
				RSVD	89.00	114943		SKCF2 114943		889		09-27-04		
								PULLED:						
60	CDR315B101BKUS CAPACITOR ORIGINAL QUANTITY...	EA	4.00					SK2 FN-12 C323 C507 C607 C612	0.00					
			4.00					PULLED:						
				RSVD	4.00	114544		SKCF2 114544		4	530.00	09-27-04		
								PULLED:						
61	JANTXV1N48908 DIODE ORIGINAL QUANTITY...	EA	1.00					SK2 FN-25 D533	0.00					
			1.00					PULLED:						
				RS	1.00			SKCF2			0.00			
								PULLED:						
62	RXEL1C FUSE, POLYSWITCH ORIGINAL QUANTITY...	EA	2.00					SK2 FN-13 F4 F5	0.00					
			2.00					PULLED:						
				RSVD	2.00	114958		SKCF2 114958		2	45.00	09-27-04		
								PULLED:						
63	RXK020R100FR RESISTOR ORIGINAL QUANTITY...	EA	1.00					SK2 FN-43 R23	0.00					
			1.00					PULLED:						







AWBLY # : LAT-DE-02388  
WO QUANTITY : 1  
WIP LOCATION: W02

BY LINE ITEM

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

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

LINE	PART NUMBER AND DESCRIPTION	EA	REQUIREMENTS		RESV IN	INVLOC	LOT NUMBER	INVENTORY DETAIL						
			QUANTITY	STAT				QUANTITY	LOT #	LOT QUANTITY	LOT DATE	LOT LIFE	BIN/LOC	BIN QUANTITY
	RESISTOR, 20Kohms Cont from prior page.					SKCF2	114992	208.00	09-27-04					
71	M55342K06B22D1R RESISTOR ORIGINAL QUANTITY...	EA	1.00			SK2 FN-65 R511		0.00						
				RSVD	1.00	114993	SKCF2	114993	137.00	09-27-04				
72	M55342K06B22E1R RESISTOR ORIGINAL QUANTITY...	EA	5.00			SK2 FN-66 R34 R45 R512 R566 R612		33.00	12-15-00	SSG				
				RSVD	5.00	114994	SKCF2	114994	272.00	09-27-04				
								50591	10.00	12-15-00	SSG			
73	M55342K06B22E2R RESISTOR ORIGINAL QUANTITY...	EA	1.00			SK2 FN-67 R668		0.00						
				RSVD	1.00	114995	SKCF2	114995	114.00	09-27-04				
	M55342K06B49E0R RESISTOR, 49.9Kohms ORIGINAL QUANTITY...	EA	6.00	RSVD	6.00	83542	SK2 FN-68 R17 R42 R593 R599 R698 R699	323.00	03-21-03	S1E				
							SKCF2	114996	259.00	09-27-04				
75	M55342K06B61E9R RESISTOR ORIGINAL QUANTITY...	EA	1.00	RSVD	1.00	84266	SK2 FN-69 R667	17.00	04-15-03	S7H				
							SKCF2	114997	144.00	09-27-04				
76	M55342K06B1000R RESISTOR, CHIP, 100W, 100 OH ORIGINAL QUANTITY...	EA	4.00	RSVD	4.00	104427	SK2 FN-70 R501 R530 R601 R610	340.00	04-27-04	S7H				
							SKCF2	114823	3428.00	09-23-04				
								114998	0.00	09-27-04				
77	M55342K06B1000R RESISTOR, CHIP, 100W, 100 OH ORIGINAL QUANTITY...	EA	13.00			SK2 FN-71 R6 R7 R503 R501 R502 R503 R504 R206 R207 R513 R597 R613 R697		3.00		SSG				

Handwritten mark resembling a large 'L' or '1' with a vertical line extending upwards.



Y ORDER : 112073

( NEW )

WORK ORDER PICK LIST

PAGE: 12

A SLY # : LAT-DS-03388  
WIP LOCATION: W02

BY LINE ITEM

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

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

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

LINE	PART NUMBER AND DESCRIPTION	EA	REQUIRED QUANTITY	CURR STATUS	RESV IN LOT #	INVL0C NUMBER	LOT	INVENTORY DETAIL		
								LOT	LOT DATE	BIN
	RESISTOR,CHIP, 100W,100K Cont from prior page.			RSVD	13.00 114823	SKCF2	114823	1316.00	09-23-04	893
								160.00	09-27-04	
								60.00	01-08-04	
76	M55342K06R3012R RESISTOR ORIGINAL QUANTITY...	EA	1.00	RSVD	1.00 50769	SK2 FN-73 R50	50769	29.00	12-20-00	893
			1.00					84.00	09-24-04	CF10
								47.00	09-27-04	
78	D55342K07H402ER RES, 400K, 174W, 1A ORIGINAL QUANTITY...	EA	1.00	RSVD	1.00 84272	SK2 FN-73 R532	84272	20.00	04-15-01	820
			1.00					10.00	09-26-04	
								93.00	09-27-04	
80	D55342K07B511ER RESISTOR ORIGINAL QUANTITY...	EA	10.00			SK2 FN-74 R511 R553 R554 R555 R511 R512 R633		0.00		
			10.00	RSVD	10.00 115002			106.00	09-27-04	
81	M55342K06R548DR RESISTOR ORIGINAL QUANTITY...	EA	2.00			SK2 FN-75 R123 R142		0.00		
			2.00	RSVD	2.00 115003			480.00	09-27-04	
82	S1C1819-0987R6 THERMISTOR, 30K ORIGINAL QUANTITY...	EA	2.00			SK2 FN-79 R1 R2		0.00		
			2.00	RSVD	2.00 115004			40.00	09-27-04	
83	JAN7XV2N2222AUB TRANSISTOR NPN ORIGINAL QUANTITY...	EA	21.00			SK2 FN-82 Q1 Q2 Q4 Q6 Q33 Q11 Q12 Q13 Q14 Q15 Q16 Q17 Q18 Q19 Q20 Q21 Q22 Q23 Q24 Q25 Q26 Q27 Q28 Q29 Q30 Q31 Q32 Q34 Q35 Q36 Q37 Q38 Q39 Q40 Q41 Q42 Q43 Q44 Q45 Q46 Q47 Q48 Q49 Q50 Q51 Q52 Q53 Q54 Q55 Q56 Q57 Q58 Q59 Q60 Q61 Q62 Q63 Q64 Q65 Q66 Q67 Q68 Q69 Q70 Q71 Q72 Q73 Q74 Q75 Q76 Q77 Q78 Q79 Q80 Q81 Q82 Q83 Q84 Q85 Q86 Q87 Q88 Q89 Q90 Q91 Q92 Q93 Q94 Q95 Q96 Q97 Q98 Q99 Q100		0.00		
			21.00	RSVD	21.00 120303			425.00	01-15-04	

W. SER : 112073

( NEW )

WORK ORDER PICK LIST

PAGE: 13

ASSEMBLY # : LAT-DS-02388  
NO QUANTITY : 3  
WIP LOCATION: W02

BY LINE ITEM

EFFECTIVITY DATE: 03-10-05  
RELEASE DATE: 03-31-04  
DATE PRINTED: 03-11-05

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

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

LT#	PART NUMBER AND DESCRIPTION	UM	REQUIREMENTS		RESV IN LOT #	INVLOC NUMBER	INVENTORY DETAIL							
			REQUIRED QUANTITY	CURE STATUS			LOT QUANTITY	LOT DATE	BIN	LOT LIFE	BINLOC	QUANTITY		
84	JANTXV2N2907AUB TRANSISTOR ORIGINAL QUANTITY...	EA	2.00			SK2 FN-52 Q699 Q699 PULLED:	0.00							
				RSVD	2.00	115007	SKCP2 115007 PULLED:	2.00	09-27-04					
85	M55342K00B4E99K RESISTOR ORIGINAL QUANTITY...	EA	2.00			SK2 FN-54 R519 R519 PULLED:	0.00							
				RSVD	2.00	114982	SKCP2 114982 PULLED:	2.00	09-27-04					
86	M55342K00B5E11K RESISTOR ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00	60671	SK2 FN-55 R528 R508 PULLED: R528 R508 PULLED: SKCP2 114829 PULLED: 114983 PULLED:	44.00	09-07-01	S9F				
								9.00	03-15-05					
								204.00	09-23-04					
								232.00	09-27-04					
	M55342K09B1C0R RESISTOR ORIGINAL QUANTITY...	EA	1.00				SK2 FN-58 R631 PULLED:	0.00						
				RSVD	1.00	114986	SKCP2 114986 PULLED:	1.00	09-27-04					

# GENERAL TECHNOLOGY CORPORATION NONCONFORMANCE MATERIAL/RMA REPORT

<b>NCMR NUMBER</b>	<input type="text" value="2305"/>	<b>CUSTOMER RETURN</b>	<input type="checkbox"/>
<b>DATE</b>	<input type="text" value="4/14/2005"/>	<b>RMA NUMBER</b>	<input type="text"/>
<b>CUSTOMER</b>	<input type="text" value="SLAC"/>	<b>QUANTITY RETURNED</b>	<input type="text"/>
<b>CUSTOMER CONTACT</b>	<input type="text" value="Pat Lujan"/>	<b>VENDOR DEFECT</b>	<input type="checkbox"/>
<b>VENDOR</b>	<input type="text"/>	<b>QUANTITY REJECTED</b>	<input type="text"/>
<b>PART NUMBER</b>	<input type="text" value="LAT-DS-02388"/>	<b>PRODUCTION DEFECT</b>	<input checked="" type="checkbox"/>
<b>LOT QUANTITY</b>	<input type="text" value="19"/>	<b>QUANTITY REJECTED</b>	<input type="text" value="19"/>
<b>SALES ORDER</b>	<input type="text" value="F17300"/>	<b>REWORK REQUIRED</b>	<input checked="" type="checkbox"/>
<b>PURCHASE ORDER</b>	<input type="text" value="48800"/>	<b>QUANTITY REWORKED</b>	<input type="text" value="19"/>
<b>LOT NUMBER</b>	<input type="text"/>	<b>PURCHASING DEFECT</b>	<input type="checkbox"/>
<b>WORK ORDER</b>	<input type="text" value="112064"/>	<b>PURCHASING QUANTITY REJECTED</b>	<input type="text"/>
<b>INITIATOR</b>	<input type="text" value="Pat Lujan"/>		
<b>ASSIGNED TO</b>	<input type="text" value="SLAC"/>		
<b>DATE REQUIRED</b>	<input type="text" value="4/25/2005"/>		
<b>ASSIGNED TO SIGNATURE</b>	<input type="text" value="SLAC"/>		
<b>DISCREPANCY</b>	IS: On components Q10, Q11, and Q12 solder is grainy and cold exhibiting evidence of gold embrittlement. SB: Should exhibit a properly wetted solder joint. This condition exists on GT104 thru GT122. GLAT 1774 thru GLAT 1792.		
<b>NOTES</b>	Per MRB Telecon held 4-15-2005 MRB concluded to remove and replace mosfets (P/N IRHNJ597034SOS, DLC 0418) from TPS CCAs. Qty = 3 mosfets (ref. designators Q10, Q11, Q12) to be removed from each board. Mosfets were not pre-tinned prior to surface mount. Grainy, discolored solder joints indicated excessive gold contamination that could result in embrittling the joint.		
<b>CAUSE</b>	Parts were provided in bulk to GTC. GTC outsourced tape and reel operation. Parts were not pre-tinned prior to Surface Mount Assembly.		
<b>CORRECTIVE ACTION</b>	Schedule a MRB meeting with SLAC and GTC to determine method of removal, pre-tin, and reworking of these components.  Remove and replace with properly removed Gold per J-STD-001CS Para. 5.4.1.  SLAC on site QA representative will be attending a course to obtain formal certification to IPC/EIA J-STD-001C and J-STD-001CS.		
<b>FINAL DISPOSITION</b>	<input type="text" value="REWORK"/>		
<b>Q/A APPROVAL</b>	<input type="text" value="E-mails on file"/>		

# GENERAL TECHNOLOGY CORPORATION NONCONFORMANCE MATERIAL/RMA REPORT

Q/A APPROVAL DATE

4/15/2005

COST OF QUALITY



# GENERAL TECHNOLOGY CORPORATION NONCONFORMANCE MATERIAL/RMA REPORT

<p><b>NCMR NUMBER</b> <input type="text" value="2323"/></p> <p><b>DATE</b> <input type="text" value="4/25/2005"/></p> <p><b>CUSTOMER</b> <input type="text" value="SLAC"/></p> <p><b>CUSTOMER CONTACT</b> <input type="text" value="Pat Lujan"/></p> <p><b>VENDOR</b> <input type="text"/></p> <p><b>PART NUMBER</b> <input type="text" value="LAT-DS-02388"/></p> <p><b>LOT QUANTITY</b> <input type="text" value="19"/></p> <p><b>SALES ORDER</b> <input type="text" value="F17300"/></p> <p><b>PURCHASE ORDER</b> <input type="text" value="48800"/></p> <p><b>LOT NUMBER</b> <input type="text" value="All TPS"/></p> <p><b>WORK ORDER</b> <input type="text"/></p> <p><b>INITIATOR</b> <input type="text" value="Pat Lujan"/></p> <p><b>ASSIGNED TO</b> <input type="text" value="Tarkington"/></p> <p><b>DATE REQUIRED</b> <input type="text" value="4/28/2005"/></p> <p><b>ASSIGNED TO SIGNATURE</b> <input type="text"/></p> <p><b>DISCREPANCY</b> <input type="text" value="S: Cable Tie are trimmed below strap head.&lt;br/&gt;Should Be: Per NASA-STD-8739.4 Para. 9.6.2. Cable ties should be trimmed flush at the strap head."/></p> <p><b>NOTES</b> <input type="text" value="During Qual # 2 the material used to stake the cable tie heads did not adhere properly. The requirement was deleted from the drawing."/></p> <p><b>CAUSE</b> <input type="text" value="Tool used to install cable ties was not adjusted properly."/></p> <p><b>CORRECTIVE ACTION</b> <input type="text" value="Install cable ties with properly adjusted tool or manually Per NASA-STD_8739.4 Para. 9.6.2. Stake with Hysol D181. Add Staking requirements to drawing.&lt;br/&gt;Rework all assemblies per rework traveler."/></p> <p><b>FINAL DISPOSITION</b> <input type="text" value="REWORK"/></p> <p><b>Q/A APPROVAL</b> <input type="text" value="E-mails on file"/></p> <p><b>Q/A APPROVAL DATE</b> <input type="text" value="4/15/2005"/></p> <p><b>COST OF QUALITY</b> <input type="text"/></p>	<p><b>CUSTOMER RETURN</b> <input type="checkbox"/></p> <p><b>RMA NUMBER</b> <input type="text"/></p> <p><b>QUANTITY RETURNED</b> <input type="text"/></p> <p><b>VENDOR DEFECT</b> <input type="checkbox"/></p> <p><b>QUANTITY REJECTED</b> <input type="text"/></p> <p><b>PRODUCTION DEFECT</b> <input type="checkbox"/></p> <p><b>QUANTITY REJECTED</b> <input type="text"/></p> <p><b>REWORK REQUIRED</b> <input checked="" type="checkbox"/></p> <p><b>QUANTITY REWORKED</b> <input type="text" value="19"/></p> <p><b>PURCHASING DEFECT</b> <input type="checkbox"/></p> <p><b>PURCHASING QUANTITY REJECTED</b> <input type="checkbox"/></p>
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# GENERAL TECHNOLOGY CORPORATION

## NONCONFORMANCE MATERIAL/RMA REPORT

<b>NCMR NUMBER</b>	<input type="text" value="2294"/>	<b>CUSTOMER RETURN</b>	<input type="checkbox"/>
<b>DATE</b>	<input type="text" value="4/11/2005"/>	<b>RMA NUMBER</b>	<input type="text"/>
<b>CUSTOMER</b>	<input type="text" value="SLAC"/>	<b>QUANTITY RETURNED</b>	<input type="text"/>
<b>CUSTOMER CONTACT</b>	<input type="text" value="Pat Lujan"/>	<b>VENDOR DEFECT</b>	<input type="checkbox"/>
<b>VENDOR</b>	<input type="text"/>	<b>QUANTITY REJECTED</b>	<input type="text"/>
<b>PART NUMBER</b>	<input type="text" value="LAT-DS-02388"/>	<b>PRODUCTION DEFECT</b>	<input checked="" type="checkbox"/>
<b>LOT QUANTITY</b>	<input type="text" value="8"/>	<b>QUANTITY REJECTED</b>	<input type="text" value="8"/>
<b>SALES ORDER</b>	<input type="text" value="F17300"/>	<b>REWORK REQUIRED</b>	<input type="checkbox"/>
<b>PURCHASE ORDER</b>	<input type="text" value="48800"/>	<b>QUANTITY REWORKED</b>	<input type="text" value="0"/>
<b>LOT NUMBER</b>	<input type="text"/>	<b>PURCHASING DEFECT</b>	<input type="checkbox"/>
<b>WORK ORDER</b>	<input type="text" value="112064"/>	<b>PURCHASING QUANTITY REJECTED</b>	<input type="text"/>
<b>INITIATOR</b>	<input type="text" value="Pat Lujan"/>		
<b>ASSIGNED TO</b>	<input type="text" value="SLAC"/>		
<b>DATE REQUIRED</b>	<input type="text"/>		
<b>ASSIGNED TO SIGNATURE</b>	<input type="text" value="Pat Lujan"/>		

**DISCREPANCY**

I/S: Insufficient staking on tantalum capacitors.  
 S/B: Staking material should be in contact with both endfaces of the component.  
 GLAT SN's 1774, 1775, 1776, 1778, 1779, 1780, 1781, 1782

**NOTES**

Per MRB Telecon held 4-15-2005:  
 Staking of sleeved Ta capacitors on TPS CCA LAT-DS-02388 is acceptable as is. Capacitors are staked along entire length but no staking comes in direct contact with the capacitor body. A thin bead of staking compound would have to be applied to the ends of the capacitor to reach inside the open ends of the sleeving. Photos of typical staking of the capacitors were reviewed and MRB agreed that the existing staking along with conformal overcoat would provide sufficient mechanical staking of the Ta capacitors to the CCA. Rework is not required for any staked Ta capacitors on TPS CCAs.

**CAUSE**

Misinterpretation of Staking Specification J-STD-001CS Para. 10.3.d

**CORRECTIVE ACTION**

All personnel involved in this operation to receive additional training. This includes the SLAC on site QA representative.  
 SLAC on site QA representative will be attending a course to obtain formal certification to IPC/EIA J-STD-001C and J-STD-001CS.

**FINAL DISPOSITION**

USE AS IS

**Q/A APPROVAL**

E-mails on file

**Q/A APPROVAL DATE**

4/15/2005

*GENERAL TECHNOLOGY CORPORATION  
NONCONFORMANCE MATERIAL/RMA REPORT*

*COST OF QUALITY*



General Technology Corporation

# CONFORMAL COATING DATA SHEET

CCA PIN: LAT-DS--02388 6LAT1790 6T120

W.O. #: 112073

CC Tech: HN (Initial / Employee #)

Date: 6-27-05

## MIX RATIOS

Coating TYPE: ARATHANE Mfr: HUNTSMAN

Lot Number: AK4688013A Expiration Date: 6/30/05  
~~6-27-05-DM~~

MIX RATIOS: 18.5750-A 100 5750-B

AIR CURE: START 6/27/05 6:00pm FINISH 6/28/05 6:30 AM

OVEN CURE: START 6/28/05 6:30AM FINISH 6/28/05

REPEATED OVEN CURE 6/28/05 IN: 11:00 AM - OUT: 1:00 PM



WESTEK

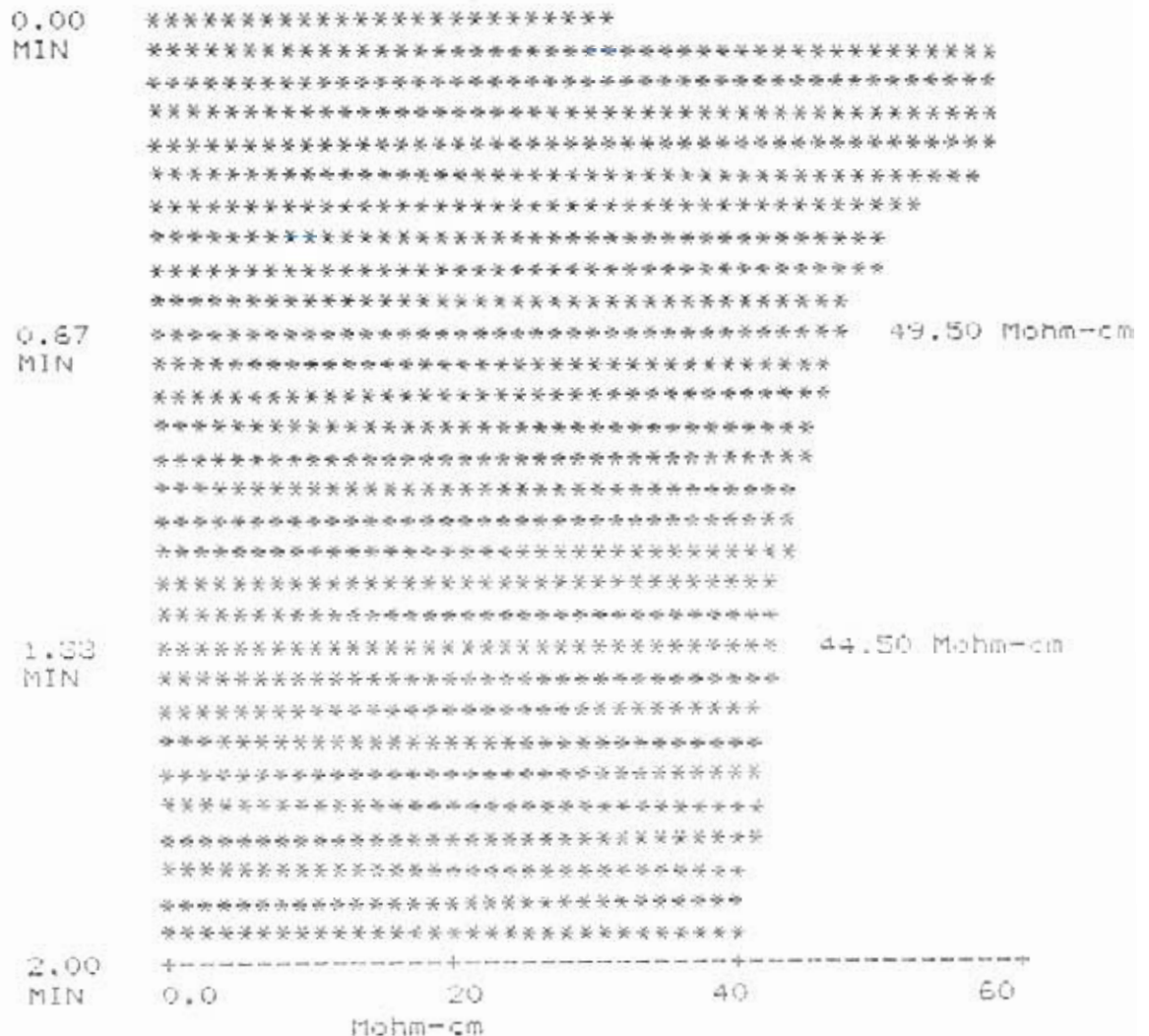
Operator :DON  
06/25/05  
12:51:39

Test Type : Auto  
-st name : 'Manual Test'  
Board # GT120 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 : 51.17 Mohm-cm  
NaCl Equivalence (Final) : 0.99 ug/sq in

TIME vs RESISTIVITY



Final Resistivity : 42.00 Mohm-cm  
NaCl Removed : 0.25 ug/sq in






## REWORK TRAVELER

CIRCUIT NO: F17300
PART NO: SLAC LAT-DS-02388
REV: 57

ASSEMBLY NAME: TPS CCA
QTY: 1

(Original signed edition reserved for copying.)

APPROVAL G. POZZI	4-18-05	G. HEFKIN	4-18-05	K. BERGTHOLDT	4/18/05	P. LUJAN	4-19-05
PREPARED BY	DATE	ENG MGR SUP.	DATE	QA MGR Eth.	DATE	SLAC SOURCE	DATE





STEP	OPERATION	Operator Sign Off.	Date	Time spent
1	Record serial numbers: __ TPS LAT-DS-02388 SN GT- <u>120</u> GLAT- <u>1790</u>	 BLP	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>	 BLP	05/02/05	
3	AQUEOUS CLEAN USING RECIPE #3	 BLP	05/03/05	
4	<b>INSPECTION: INSPECT FOR BOARD CLEANLINESS. NO SOLDER BALLS ALLOWED.</b>	 BLP	5/19/05	
5	SOURCE INSPECTION		4/13/05	

## REWORK TRAVELER

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	SLAC SOURCE	DATE

STEP	OPERATION	Operator Sign Off.	Date	Time spent
1	Record serial numbers: __ TPS LAT-DS-02388 SN GT- <u>120</u> GLAT- <u>1790</u>	 BHP	04/23/05	
2	OPERATOR: STAKE R22 PER CAA-LAT-DS-02388, STEP 40. CURE PER INSTRUCTION IN STEP 40	 BHP	05/16/05	
3	INSPECTION: INSPECT FOR BOARD CLEANLINESS. NO SOLDER BALLS ALLOWED.		5/19/05	
4	SOURCE INSPECTION		6/13/05	





# REWORK TRAVELER

SO NO: F17300      PART NO: SLAC LAT-DS-02388 TPS      REV: 57

ASSEMBLY NAME: SLAC CCA'S      QTY: ALL

<b>APPROVAL</b>							
G. POZZI	4-22-05	G. HEFKIN	4-22-05	BERGTHOLT	4/21/05	P. LUJAN	4-21-05
PREPARED BY	DATE	ENG MGR	QA MGR	PROD MGR	DATE	SOURCE	DATE


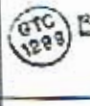
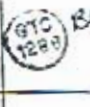

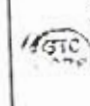


STEP	OPERATION	Operator Sign Off.	Date	Time spent
1	Record serial numbers: TPS LAT-DS-02388 SN's GT- <u>120</u> , GLAT- <u>1790</u>	(670 1222) BYP	04/20/05	
2	<p><b>OPERATOR:</b></p> <p>REMOVE Q10, Q11, AND Q12. USE THE HAKO FM202 PARALLET REMOVAL SOLDERING IRON WITH 5/16" BLADE TIPS</p> <p style="text-align: right;"><i>Removed Q10, Q11, Q12</i></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>	<p>(670 592) BYP</p> <p>(670 592) BYP</p> <p>(670 592) BYP</p>	<p>04-27-05</p> <p>4-27-05</p> <p>4-27-05</p>	
3	<p><b>OPERATOR:</b></p> <p>VERIFY PADS HAVE NO DAMAGE. <span style="border: 1px solid black; padding: 2px;">LAT TO QA</span> 4/27/05</p>	BYP	04/27/05	
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>	(670 1222) BYP	05/02/05	
4	<p><b>OPERATOR:</b></p> <p>HAND CLEAN BOARDS USING ALCOHOL.</p>	BYP	05/02/05	
5	<p><b>INSPECTION:</b></p> <p>INSPECT PARTS FOR WORKMANSHIP AND BOARD CLEANLINESS</p>	BYP	5/7/05	
6	<p><b>SOURCE INSPECTION</b></p>	<span style="border: 1px solid black; padding: 2px;">LAT TO QA</span>	5/7/05	



# REWORK TRAVELER

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

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

STEP	OPERATION	Operator Sign Off.	Date	Time spent
	RE. NCMR 2323. <i>sun</i>			
1	Record serial numbers Affected: __ GT-104 Glat-1774 Thru GT-122 Glat-1792 __ Serial Number <u>GT 120</u> <u>GLAT 1790</u>	 <i>Buy</i>	04/25/05	
2	REMOVE ALL CABLE TIE WRAPS ON HARNESSSES.	 <i>Buy</i>	05/19/05	
3	REPLACE ALL CABLE TIE WRAPS USING THE PANDUIT CABLE TIE WRAP TOOL ON SETTING "STANDARD", AT LEVEL "7".	 <i>Buy</i>	05/19/05	
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>REFER TO CAA LAT-DS-02388 FOR MIX INSTRUCTIONS</i>	 <i>Buy</i>	05/19/05	
5	Hysol 0151 data: DATE MIXED <u>05/19/05</u> Expiration Date <u>01/31/07</u> PO# <u>31403</u>	 <i>Buy</i>	05/19/05	
6	Inspection		5/19/05	
7	Source Inspection		6/1/05	



# DEFECT RECORD REPORT

ID: 32999

PART NUMBER: LAT-DS-0238B

WORK ORDER: 112073

SALES ORDER: F17300

QUANTITY: 1 RW QTY: 0

CUSTOMER: SLAC

INSPECTION TYPE: CUSTOMER SOURCE

INSPECTION LEVEL: 1

INSPECTOR: EMARTINEZ

OFF SOLDER: 0

OFF ASSEMBLY: 0

DATE: 6/28/2005

WEEK CODE: 28

SERIAL NO.	QUANTITY	OPERATOR	DEFECT CODE	WORKCELL	DEFECT DESCRIPTION	REF DES	PIN NOTES
GT120	1	1691	A375	1-BIG RUNNER	<i>Customer</i> BONDING NOT PER PRINT		



*Customer* BONDING NOT PER PRINT

 6/28/05  
 Stephanie Dally 6/28/05

# DEFECT RECORD REPORT

ID: 29665  
 PART NUMBER: LATDS-02388  
 WORK ORDER: 112073  
 SALES ORDER: F17300  
 INSPECTION TYPE: POST REFLOW  
 INSPECTION LEVEL: 1  
 INSPECTOR: SANDOVAL  
 OFF SOLDER: 1421  
 OFF ASSEMBLY: 786  
 DATE: 2/25/2005  
 WEEK CODE: 10  
 QUANTITY: 1 RW QTY: 1  
 CUSTOMER: SLAC

SERIAL NO.	QUANTITY	OPERATOR	DEFECT CODE	WORKCELL	DEFECT DESCRIPTION	REF DES	PIN NOTES
GT120	3	1858	A342		> 25% OVERHANG	L13	✓
GT120	2	1858	A342		> 25% OVERHANG	L4	✓
GT120	2	1858	A342		> 25% OVERHANG	L7	✓
GT120	1	1858	S402		INSUFFICIENT SOLDER	Q599	✓
GT120	100	1858	S414		SOLDER BALLS	ALL OVER	SOLDER BALLS EMBEDDED IN FLUX

03/31/05 Rework done by  03/31/05.  
 2/31/05 

WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

*Reprint*

TYPE: ENGINEERING

WORK ORDER TRAVELLER - MATERIAL PULLED

PAGE 1

PN# LAT-DS-01481  
GLAST. DAD. TEM

WOP 112111  
REQ DATE 04-29-05  
REL DATE 04-04-05  
SC# F17200  
PO# 0000048799

CUST #  
QTY: 1  
PROJECT# F17200  
CUST# 15354

SERIAL NUMBER  
GT110 GLAT1799

APPROVAL:  
PROD: RH/4-27-05  
QA: Rafael Mckin 4-27-05

WORKMANSHIP  
IPC/RIA-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 05.26.04

LINE DEPT MACH# OP# DESCRIPTION SET-UP RUN... HOURS LINE-MACH SC-LAT



1 200 00 CONFIG RECORD/KITTING 0.0000 0.0000 0.0000  
CONFIG

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
AGSY DWG: LAT-DS-01481 REV 13/PL OUTSTANDING RD'S  
SYM PL: (SAVE - ON DWG) 04 NONE  
RELOC TITON: LAT-DS-03248 03 NONE  
RELOC TITON: (N/A THIS LEVEL)  
AGSY AID: LAT-DS-01481 (RELEASED PER EC 2426)  
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 \_\_\_\_\_ Rafael Mckin



2 200 00 STOCKROOM/KITTING AREA 0.0000 0.0000 0.0000  
KITTING

PROCESS MATERIAL PER CAA STEP 2

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

4/28/05 1 \_\_\_\_\_ Customer Den 1



PN# LAT-DS-01481  
ASSY: SLAST. DAO. TRM

WO# 113111  
REQ DATE 04-29-05  
REL DATE 04-04-05  
SC# F17200  
PC# 0000048799

CUST #  
QTY  
PROJECT# 717200  
CURTA 15350

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



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

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

GTC PC# 32131 EXP. DATE 10/01/05  
 LOI #19 (PT A) 32775 (PT B) 32775  
 MIX RECORD (PART A WGT) 15gr (PART B WGT) 1gr

DATE	QTY	REMARKS	STATUS
06/27/05	1		Sup(1288)



4 210 00 CCA/BLACK BOX ASSY AREA  
LOG CCA SN TO WORK ORDER  
CHASE SCREW THREADS  
INSTALL CCA TO BOX 0.0000 0.0000 0.0100

- PROCESS ASSY PER CAA STEP 4.
- INSTALLED CCA SERIAL NUMBER: GT110

DATE	QTY	REMARKS	STATUS
06/27/05	1		Sup(1288)



5 210 00 CCA/BLACK BOX ASSY AREA  
TORQUE FASTENERS. 0.0000 0.0000 0.0100

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

TORQUE TOOL: GTC-E-9511/2  
 GTC-E-944 CAL DUE DATE 08/05

DATE	QTY	REMARKS	STATUS
06/27/05	1		Sup(1288)
6-27-05	1	OK FITNESS TORQUE	LAT TO 05

ENGINEERING

WORK ORDER TRAVELLER + MATERIAL FULLED

ASSY/FIN# LAY-DS-01491  
ASSY, GLAST, BAQ, TEM

WO# 113111  
REQ DATE 04-29-05  
REL DATE 04-04-05  
SQ# 217200  
PC# 0000048199

CUST DB  
PROJECT# 1  
PROJECT# 217200  
COST# 15356

LINE DEPT MACH# OP# DESCRIPTION ..... K D U R S  
SET-UP RUN... LINE-MACH ST-LOT



6 315 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
STAKE BOLT HEADS.

• PROCESS ASSY PER CAA STEP 6.

• RECORD MATERIAL DATA BELOW:

ADHSV 0191: GTC PC# 31403 EXPIRATION DATE 01/31/07  
CURE DATE/TIME: START-06/28/05 8:45 AM STOP-10:45 AM

DATE	QTY	REMARKS	STATUS
<u>06/28/05</u>	<u>1</u>		<u>Buy (1288)</u>



7 310 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
ASSY MARKING

• PROCESS ASSY PER CAA STEP 7.

• RECORD MATERIAL DATA BELOW:

INK 50-100R: GTC PC# 31201 EXPIRATION DATE 04/27/07  
LOT # (PT A): 200409080033

LOT # (PT B): 200407020071

MIX RECORD (PT A WGT) 0.6g (PT B WGT) 0.6g

MARKING DATE/TIME: 06/28/05 8:45 - 10:45 AM

CURE OCCURS AT STAKING STEP 13.

DATE	QTY	REMARKS	STATUS
<u>06/28/05</u>	<u>1</u>		<u>Buy (1288)</u>



8 291 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CPE: SLDR-0 ASSY-117

• PROCESS ASSY PER CAA STEP 8.

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

DATE	QTY	REMARKS	STATUS
<u>06/28/05</u>	<u>1</u>		<u>Buy (1288)</u>

WORK CELL: 1-BIG RINGER

CUSTOMER: SLAC

ENGINEERING

WORK ORDER TRAVELLER - MATERIAL PULLED

ASSY: W# LAT-26-11461  
ASSY: GLAST, DAG, TEN

WO# 113111  
REQ DATE 14-29-05  
REL DATE 14-24-05  
SQ# 17900  
PC# 0000068799

JUST IN  
PROCESS  
CONCERN  
L017200  
L013500

PAGE 4

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



9 260 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
EXAMINE BOX ASSY

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

DATE	QTY	REMARKS	STATUS
6/28/05	1	GLAT 1799	LAT TO CA



10 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSTALL LID

- PROCESS ASSY PER CAA STEP 10.

DATE	QTY	REMARKS	STATUS
06/28/05	1		BYP(1200)



11 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
TORQUE FASTENERS.

- PROCESS ASSY PER CAA STEP 11.
  - ALERT SLAC QAR TO WITNESS TORQUE PROCESS.--
  - RECORD ASSIGNED TOOLS USED, AND CAL DUE DATE, BELOW.
- TORQUE TOOL = GTC-A-977 GTC-E-951 1/2  
GTC-E-944 CAL DUE DATE 08/05

DATE	QTY	REMARKS	STATUS
06/28/05	1		BYP
6/28/05	1	WITNESS: TROPE	LAT TO CA



12 291 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
QFA: SLOC-C ASSY-74

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

DATE	QTY	REMARKS	STATUS
6/28/05	1		304 5

WORK CELL: 1-BIG RUNNER

CUSTOMER: SLAC

ENGINEERING

WORK ORDER TRAVELLER

MATERIAL PULSED

PAGE 5

ASSY: LAT-DS-01481  
ASSY: GLAST, DAQ, TEM

W# 112111  
REQ DATE 01-29-05  
REL DATE 01-04-05  
SO# F17200  
PC# 0000048759

CUST #  
PROJECT# F:7200  
CUST# 15356

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



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

\* PROCESS ASSY PER CAA STEP 13.

\* RECORD MATERIAL DATA BELOW.

ADMSV 0151: GTC PO# 31403 EXPIRATION DATE 01/31/07  
CURE DATE/TIME: START 06/28/05 2:00PM STOP 4:00PM

DATE	QTY	REMARKS	STATUS
06/28/05	1		Buy (1288)



14 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CP2: SLDR-0 ASSY-37

\* PROCESS ASSY PER CAA STEP 14.

RECORD DEFECT REPORT NO. IF APPLICABLE:

DATE	QTY	REMARKS	STATUS
6/29/05	1		



15 290 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
6-29-05	1	GLAT 1799	



TRAVELER REVISION HISTORY RECORD

CREATED BY: REFFIN FOR ASSY REV: 94 DATE: 03.31.05

ASSY REV	CHG BY	CHG DATE	CHANGE DETAIL
91	RLM	03/31/05	RELEASED AT REV 94, AND CAA AT REV 91

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









WORK CELL: 4-MIXED

CUSTOMER: SIAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

APPY/PN4 LAT-DS-01444  
CCA, GLAST, TFM

MO# 112010  
DATE 02-03-05  
DATE 02-21-04  
JOB# 0000048799

COST ID  
PROJECT# 1  
CUST# P17200  
15156

PAGE 2

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



3 215 00 CCA/BLACK BOX ASSY AREA 1.3300 1.3300 1.3300  
BOARD MARKING

\* PROCESS PER CAA STEP 3.

DATE	QTY	REMARKS	STATUS
2-1-05	1		OK 1630



4 213 00 SMT ASSY LINE 0.0000 0.0000 0.0000  
PRE-SMT OVEN BAKE

\* PROCESS PER CAA STEP 4.

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

DATE	QTY	REMARKS	STATUS
2-7-05	1	OK	OK 1648
2-7-05		OUT	OK



5 213 01 SMT ASSY LINE 5.6300 5.6300 5.6300  
SOLDER PASTE STENCIL  
ONLY TOP SIDE GSTS PARTS

\* PROCESS PER CAA STEP 5.

\* RECORD SOLDER PASTE DATA BELOW:

GTC PO# 31728 EXPIRATION DATE 7/14/05

DATE	QTY	REMARKS	STATUS
2-9-05	1		OK

4-56 - .0060  
 4-55 - .0060  
 R291 - .0060  
 C361 - .0060  
 C374 - .0060  
 4-53 - .0060  
 4-52 - .0060  
 4-58 - .0060



WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 3

ASSY/PN# LAT DS-01614  
CNA. GLAST. SEM

WOB# 112010  
RSD DATE 02-03-05  
REL. DATE 12-21-04  
SQ#  
PO# 0010049722

COST #  
QTY 1  
PROJECT# P17200  
COST# 14344

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



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

\* PROCESS PER CAA STEP 6:

\* RECORD SERIAL NUMBERS OF LISTED ASIC DEVICES

FN-19 U1 1721 U4 1728 U5 1661 U6 1694  
FN-23 U54 1699 U55 1689 U56 1676 U57 1611  
U58 1738 U59 1744 U60 1677 U61 1680

DATE	QTY	REMARKS	STATUS
<u>2-9-05</u>	<u>1</u>	<u>77-11</u>	<u>PF</u>



7 213 00 SMT ASSY LINE 0.5000 0.5000 0.5000  
SOLDER REFLOW

\* PROCESS PER CAA STEP 7:

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

DATE	QTY	REMARKS	STATUS
<u>2-9-05</u>	<u>1</u>		<u>PF</u>



8 213 00 SMT ASSY LINE 0.1000 0.1000 0.1000  
AQUEOUS CLEAN

\* PROCESS PER CAA STEP 8:

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

DATE	QTY	REMARKS	STATUS
<u>2-9-05</u>	<u>1</u>		<u>PF</u>

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

WIP/ENR LAT-DS-01646  
PCA: GLAST, TEM

NO# 112010  
REQ DATE 02-03-05  
DEL DATE 12-21-04  
PC# 0000048799

CUST P#  
QTY 1  
PROJECT# 217200  
CUST# 13386

PAGE 4

LINE DEPT MACH# QTY DESCRIPTION..... H O U S  
SET-UP RGN... LINE-MACH SP:LAT



9 290 00 QUALITY ASSURANCE AREA 0 4400 0 4400 0 4400  
OP# SISR-4163 ASSY-5003

- PROCESS PER CAA STEP 9
- RECORD DEFECT RECORD NUMBER/S BELOW.

DEF#S: **29534**

DATE	QTY	REMARKS	STATUS
2/19/05	1	110	GIC 6



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

- 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-1942 CAL DUE DATE 4/05 ASG-Box GTC-E944

DATE	QTY	REMARKS	STATUS
3/30/05	1		1337



12 310 00 WAVESOLDER 0.0000 0.0000 0.0000  
WAVE SOLDER

- PROCESS PER CAA STEP 12.
- | DATE    | QTY | REMARKS | STATUS |
|---------|-----|---------|--------|
| 3.30.05 | 1   |         | K      |
|         |     |         |        |
|         |     |         |        |

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY: FNA LAT-DS-01644  
CCA, GLAST, JEM

WCS 112010  
REQ DATE 02-23-05  
RPT DATE 12-21-04  
CO#  
PO# 0000048799

CHPT P#  
QTY 1  
PROJECT# P17200  
CUST# 15224

PAGE 5

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



13 215 00 WAVESOLDER ACCESS CLEAN 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 13:

DATE	QTY	REMARKS	STATUS
3/30/05	1	110	me 1337



14 240 00 QUALITY ASSURANCE AREA (PE: SLDR-600 ASSY-85) 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 14:

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

WRK#(S): 30429

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



15 210 00 CCA/BLACK BOX ASSY AREA TOUCHUP 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 15:

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



16 210 00 CCA/BLACK BOX ASSY AREA ADJUST/DI CLEAN 0.0000 0.0000 0.0000

\* PROCESS PER CAA STEP 16:

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

WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 6

PN# LAT-05-01040  
CUST. CLASST. TIM

WC# 112010  
REQ DATE 02-03-05  
REL. DATE 12-31-04  
SCH  
PC# 0000148799

CUST ID#  
QTY  
PROJECT# P27200  
CUST# 15254

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



17 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OP#: SLDR-200 ASSY-0

\* PROCESS PER CAA STEP 17.

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

DR#(S)

DATE	QTY	REMARKS	STATUS
3/31/05	1	S/N 110	100



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

\* PROCESS PER CAA STEP 18.

ADHESIVE NO# 32131 EXP. DATE: 12/1/05  
FPGA SERIAL #'S: U49 40492 U52 50142

DATE	QTY	REMARKS	STATUS
5/4/05	1		337



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

\* PROCESS PER CAA STEP 18

DATE	QTY	REMARKS	STATUS
5/19/05	1		me 1337



20 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
POST WAVE ASSY-D3, D4, D5

\* PROCESS PER CAA STEP 20

DATE	QTY	REMARKS	STATUS
5/19/05	1		me 1337



WORK CELL 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

W/ENS LAD-DS-01646  
CAA: CAAST, TEM

NO# 112010  
REQD DATE 01-03-05  
CMTY DATE 10-01-04  
PO# 0000046700

CUST Pa  
CITY 1  
COUNTRY 10111000  
COST# 10111000

PAGE 8

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



SN 110

LT#	DEPT	MACH#	OP#	DESCRIPTION	H	O	U	R
24	210	00		CCA/BLACK BOX ASSY AREA	13.8300	14.8300	13.8300	
				INSTALL CONNECTOR-SP1 PER				
				SLDR-CONN J1-ROW 1>CHECK				
				SLDR-CONN J1-ROW 2>CHECK				
				SLDR-CONN J1-ROW 3>CHECK				
				SLDR-CONN J1-ROW 4>CHECK				

- \* PROCESS PER CAA STEP 19.
- \* RECORD ASSIGNED TOOLS USED, AND CAL DUE DATE, BELOW.

TOOL # GTC 2-944 CAL DUE DATE 8/05

DATE	QTY	REMARKS	STATUS
<u>5/12/05</u>	<u>1</u>		<u>me 1337</u>



LT#	DEPT	MACH#	OP#	DESCRIPTION	H	O	U	R
24	290	00		QUALITY ASSURANCE AREA	5.6800	5.6800	5.6800	
				OP# SLDR-396 ASSY-405				

- \* PROCESS PER CAA STEP 24.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW

DRR#(S): \_\_\_\_\_

DATE	QTY	REMARKS	STATUS
<u>5/13/05</u>	<u>1</u>		

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY: ON: LAT-DS-01646  
COA: SLAC, TEM

WO# 112010  
RTO DATE 02-03-05  
RST DATE 12-21-04  
SO#  
PUR 0000048799

CUST P#  
PROJECT# P17000  
COST# 10396

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S/H 110

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



07 250 00 COATING/POTTING AREA 0.6000 0.6000 0.6000  
POTTING/STAKING

\* PROCESS PER CAA STEP 27.

\* RECORD MATERIAL DATA BELOW:

RTV DCG-1104, CTC PO# 31695 EXPIRATION DATE 8-21-05  
ADHESY 0161, CTC PO# 31403 EXPIRATION DATE 1-31-07

\*16# ADHESIVE MIX RECORD (RECORD PER BATCH)

BATCH #1 BATCH #2 BATCH #3 BATCH #4

RESIN WGT# 3.1g

HARDENER WGT# 1.0g

CURE DATE: 5-16-05 START: 11:30 STOP: 1:30

DATE... QTY... REMARKS... STATUS  
5-13-05 1 cured @ 120°F P.D.1946



190 00 QUALITY ASSURANCE AREA 0.1000 0.1000 0.1000  
CFR: SLDG-0 ASSY-104

\* PROCESS PER CAA STEP 24.

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

DAR#(S):

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

5/16/05 1 [Stamp]



22 260 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
NIE... SLAC CAR INSPECTION  
BEFORE SHIPMENT TO SLAC

\* PROCESS PER CAA STEP 29.

\* PLEASE RETURN COA TO QA FOR SHIPMENT.

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

6-6-05 1 [Stamp]

WORK CELL: 4 MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 10

ASSY/STG: LAT-DS-01646  
CAA: 01257, TRM

W# 112010  
RDO DATE 03-08  
MIL DATE 12-21-04  
SOS  
PO# 0000048799

CUST #  
PROJECT 47420  
CUSTY 12224

Li# DEPT MACH# OP# DESCRIPTION..... H O U R S  
SET UP RUN... 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
06/07/05	1		By P (1288)



31 299 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 CRUSH OR ALLOW ANY  
REWORK TO BE PERFORMED WITHOUT AUTHORIZATION PROVIDED BY  
APPROVED REWORK INSTRUCTIONS (NOMR REQUIRED).

DATE	QTY	REMARKS	STATUS
6/23/05	1		6/23/05



32 299 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
SLAC CAR PRE-COAT INSP  
MANDATORY INSPECTION  
POINT

\* PROCESS PER CAA STEP 32.

DATE	QTY	REMARKS	STATUS
6/23/05	1	GLAT 176.1	GLAT TO CA

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

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ASBY/ENR LAP-DS-02040  
CCA, GLASS, TEM

WCR: 112010  
SNO: 02-03-05  
SNO DATE: 12-21-04  
PC#: 0000148799

CUST #  
PROJECTS: 1  
CMTA: 16156

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



33 210 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
6/23/05	1		AL 1576
6/23/05	1	TEST CLEAN	DN



34 204 00 QUALITY ASSURANCE AREA  
QTY: 0.0000 0.0000 0.0000

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

DEF#(S):

DATE	QTY	REMARKS	STATUS
6/24/05	1		



35 200 00 COATING/POTTING AREA  
MASK & CONFORMAL COATING 0.6000 0.6000 0.6000

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

RECORD BAKE DATE-TIME START/STOP BELOW:

BAKE DATE: 6/24/05 START: 8:02 STOP: 9:30

DATE	QTY	REMARKS	STATUS
6/24/05	1	MASK/BAKE	PAZ



WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

REV# 1A7-DS-01646  
CLA, GLAST, TEM

WCR# 112010  
MATERIAL DATE 02-03-03  
MATERIAL DATE 12-21-04  
WCR# 0000048799

CUST P#  
MTR  
PROJECT# F17800  
CUST# 16386

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LINE DESCRIPTION

SET-UP RUN. HOURS S...  
LINE-MACH ST-LOC



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

\* PROCESS PER CAA STEP 36.

CONFORMAL COAT MATERIAL PO#: 31201  
EXP. DATE: 6/30/05

2ND (2) HOUR AIR CURE (BEFORE OVEN BAKE):  
DATE: 6/24/05 START: 10:00 AM STOP: 12:01 PM

DATE	QTY	REMARKS	STATUS
<u>6/24/05</u>	<u>1</u>	<u>Coat</u>	<u>Dm/1035</u>



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

\* PROCESS PER CAA STEP 37.

FIRST BAKE DATE 6/24/05 START: 12:01 PM STOP: 1:00 pm

SECOND BAKE DATE 6/24/05 START: 6:00 pm STOP: 3:10 pm

DATE	QTY	REMARKS	STATUS
<u>6-24-05</u>	<u>1</u>	<u>Touch coat</u>	<u>OK</u>

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER : NEW

ASSY/ENF LAT-DS-014846  
CCA, GLAST, TEM

WC# 112010  
REV DATE 02-03-06  
REL DATE 12-21-04  
SOS  
PO# 0000048799

Wkst #  
QTY 1  
PROJECT# PL7200  
CUST# 19398

PAGE 13

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



39 000 00 QUALITY ASSURANCE AREA 0.5000 0.5000 0.5000  
CPE: SLDR-0 ASSY-95

\* PROCESS PER CAA STEP 39.

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

DRA#(S)

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

- MATERIAL CERTIFICATIONS...
- SCIP REPORTS (SCIP REPORTS)
- SCIP CONFORMANCE REPORTS
- FORM 512 (DOC REV RECORD)...
- NO LONG REPORT
- DIGITAL PHOTOGRAPHS, RECORDED ONTO CD...

DATE	QTY	REMARKS	STATUS
6/27/05	1		



39 260 00 SOURCE INSPECTION 0.0000 0.0000 0.0000  
CPE

\* PROCESS PER CAA STEP 39.

NOTE: NEXT ASSEMBLY IS LAT-DS-014841.

\*\* PLEASE RETURN INSPECTED CCA TO QA UPON COMPLETION \*\*

DATE	QTY	REMARKS	STATUS
6-27-05	1	GLAT 1761	

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIRED QUANTITY	CURR STATUS	REQUIREMENTS		RECV IN LOT #	INVLOC	LOT NUMBER	INVENTORY DETAIL		
					STAT QUANTITY	REQ QUANTITY				LOT QUANTITY	DOI DATE	SINLOC
1	LAT-D9-01649 FAB. TEM ORIGINAL QUANTITY...	EA	1.00	RSVD	1.00	120299	SKCF1 FN-D1	120299	18.00	09-21-07		✓
2	LAT-D9-01026 PLATE, CONN. TEM ORIGINAL QUANTITY...	EA	1.00	RSVD	1.00	114784	SKCF1 FN-D6	114784	18.00	08-19-07		✓
3	LAT-D9-01031 PIN, CONNECTOR, TEM ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00	114785	SKCF1 FN-D7	114785	36.00	08-19-07		2 ✓
4	NAS1352N02-8 SCREW ORIGINAL QUANTITY...	EA	26.00	RSVD	26.00	114786	SKCF1 FN-D3	114786	946.00	09-23-04		26 ✓
5	LAT-D9-03692 STANDOFF ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00	114787	SKCF2 FN-D5	114787	38.00	09-23-04		2 ✓
6	MSS1957-13 SCREW, PHND, 4-40 X .25 ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00	93945	SKCF2 FN-D10	93945	291.00	11-24-03	C2F	2 ✓
							FN-D10	114788	78.00	09-23-04		2 ✓
	NAS620-C2 FLATWASHER ORIGINAL QUANTITY...	EA	52.00	RSVD	52.00	114789	SKCF2 FN-D2	114789	1092.00	09-23-04		52 ✓
8	MS24671-2 SCREW ORIGINAL QUANTITY...	EA	4.00	RSVD	4.00	114790	SKCF2 FN-D8	114790	64.00	09-23-04		4 ✓
9	NAS671-C2 NUT ORIGINAL QUANTITY...	EA	26.00	RSVD	26.00	114791	SKCF2 FN-D4	114791	520.00	09-23-04		26 ✓
10	LAT-D9-02588 ASSY, CABLE, CONN. TEM ORIGINAL QUANTITY...	EA	1.00	BO	1.00		SKCF2 FN-D9	25 J1	0.00			✓
11	0151 ADHESIVE, HYBOL, 40Z WIT ORIGINAL QUANTITY...	OZ	1.00	BO	1.00		SKCF1 FN-D14		0.00			C-C
12	CV 2946 RIV, NUSOL TECH ORIGINAL QUANTITY...	OZ	1.00	BO	1.00		SKCF2 FN-D12		0.00			C-C
13	5782 CONFORMAL COATING URETHANE ORIGINAL QUANTITY...	OZ	1.00	BO	1.00		SKCF2 FN-D13		0.00			C-C











ORIGINAL QUANTITY... 4.00

PULLED:  
114826  
FN-21 U49 U50 U51 U52  
PULLED:

4.00 09-23-04 DRY-10

4 ✓



WCR ORDER : 112010

NEW

WORK ORDER PICK LIST

PAGE: 5

A LY # : LAC-DS-01646

BY LINE ITEM

EFFECTIVITY DATE: 02-03-05  
RELEASE DATE : 12-21-04  
DATE PRINTED : 02-04-05

WIP LOCATION: W02

DATE PULLED:

PULLED BY:

LT#	PART NUMBER AND DESCRIPTION	UM	QUANTITY	REQD STATUS	RESV IN	LOT #	INVLCC	LOT NUMBER	INVENTORY DETAIL			
									QUANTITY	LOT LIFE	BINLOC	BIN
45	M55342K06B49D9R RESISTOR,CHIP,100W,49.9 ORIGINAL QUANTITY...	EA	4.00	RSVD	4.00	114827	SKCF2	114827	234.00	09-23-04		
							FN-34	R648 R649 R650 R651 PULLED:				
								16398 FN-34 R648 R649 R650 R651 PULLED:	17.00	03-23-04	CF3D	4 ✓
46	M55342K06B1F30R RESISTOR ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00	114828	SKCF2	114828	88.00	09-23-04		
							FN-27	R321 R322 PULLED:				
								114828 FN-27 R321 R322 PULLED:	229.00	09-27-04		2 ✓
47	M55342K06B5E11R RESISTOR ORIGINAL QUANTITY...	EA	2.00	RSVD	2.00	114829	SKCF2	114829	240.00	09-23-04		
							FN-30	R642 R643 PULLED:				
								114829 FN-30 R642 R643 PULLED:	232.00	09-27-04		2 ✓
48	M55342K06B10E0R RESISTOR,CHIP,100W,10K Ω ORIGINAL QUANTITY...	EA	23.00	RSVD	23.00	114830	SKCF2	114830	615.00	09-23-04	CF2C	
							FN-31	R3 R145 R146 R147 R148 R149 R150 R151 R167 R168 R171 R172 R173 R174 R175 R640 R641 R642 R649 R750 R751 R752 R753				
								114830 FN-31 R3 R145 R146 R147 R148 R149 R150 R151 R167 R168 R171 R172 R173 R174 R175 R640 R641 R642 R649 R750 R751 R752 R753 PULLED:	627.00	09-27-04		23 ✓
								9334 FN-31 R3 R145 R146 R147 R148 R149 R150 R151 R167 R168 R171 R172 R173 R174 R175 R640 R641 R642 R649 R750 R751 R752 R753 PULLED:	58.00	09-24-04		




## REWORK TRAVELER

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

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

APPROVAL <i>(Original signed editions reserved for copying)</i>							
G. POZZI	<i>4-18-05</i>	G. HEFKIN	<i>4-18-05</i>	K. BERGTHOLDT	<i>4/18/05</i>	P. LUJAN	<i>4/18/05</i>
PREPARED BY	DATE	ENG MGR SUP	DATE	QA MGR EHL	DATE	SLAC SOURCE	DATE

STEP	OPERATION	Operator Sign Off.	Date	Time spent
1	Record serial numbers: TEM LAT-DS-01646 SN GT- <u>110</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>	<i>1337</i>	<i>4/2/05</i>	<i>1:00</i>
	AQUEOUS CLEAN USING RECIPE #3	<i>1337</i>	<i>4/7/05</i>	
4	<b>INSPECTION: INSPECT FOR BOARD CLEANLINESS. NO SOLDER BALLS ALLOWED.</b>	<i>1337</i>	<i>4/24/05</i>	<i>.5</i>
5	SOURCE INSPECTION		<i>4/6/05</i>	

# DEFECT RECORD REPORT

ID: 30429

PART NUMBER: LAT-05-01646

WORK ORDER: 112010

SALES ORDER: F17200

QUANTITY: 1 RWQTY: 1

CUSTOMER: SLAC

INSPECTION TYPE: HAND SOLDER

INSPECTION LEVEL: 1

INSPECTOR: EMARTINEZ

OFF SOLDER: 600

OFF ASSEMBLY: 14

DATE: 3/31/05

WEEK CODE: 15

SERIAL NO	QUANTITY	OPERATOR	DEFECT CODE	WORKCELL	DEFECT DESCRIPTION	REF DES	PIN NOTES
110	1	692	S413		BRIDGING	JT3	
110	1	692	S413		BRIDGING	JC1	

*3/31/05*

*1337  
1337  
3/31/05*

# DEFECT RECORD REPORT

ID: 29534

PART NUMBER: LAT-DS-01646

WORK ORDER: 112010

SALES ORDER: F17200

QUANTITY: 1 RW QTY: 1

CUSTOMER: SLAC

INSPECTION TYPE: 1ST SOLDER INSPECTIO

INSPECTION LEVEL: 1

INSPECTOR: HUBBARD

OFE SOLDER: 4163

OFE ASSEMBLY: 5203

DATE: 2/19/2005

WEEK CODE: 9

SERIAL NO QUANTITY OPERATOR DEFECT CODE WORKCELL

110 1 1858 S414

DEFECT DESCRIPTION

SOLDER BALLS

REF DES

BD.

PIN NOTES

THROUGH OUT

*Handwritten:* 1351 3/28/05  
3/20/05  
A circular stamp with illegible text is also present.

# DEFECT RECORD REPORT

ID: 27534

PART NUMBER: LAT-DS-01646

WORK ORDER: 112010

SALES ORDER: F17200

QUANTITY: 1 RW QTY: 1

CUSTOMER: SLAC

INSPECTION TYPE: 16T-SOLDER-INSPECTOR post reflojo  
K.H. 2/27/05

INSPECTION LEVEL: 1

INSPECTOR: HUBBARD

OFFE SOLDER: 4163

OFFE ASSEMBLY: 5203

DATE: 2/19/2005

WEEK CODE: 9

SERIAL NO	QUANTITY	OPERATOR	DEFECT CODE	WORKCELL	DEFECT DESCRIPTION	REF DES	PIN NOTES
110	1	1858	S402		INSUFFICIENT SOLDER	U6 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U58 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U56 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U55 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U4 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U60 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U59 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U5 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U57 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U54 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U61 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U3 ✓	4 SIDES
110	1	1858	S402		INSUFFICIENT SOLDER	U35 ✓	PIN 5
110	2	1858	S402		INSUFFICIENT SOLDER	U32 ✓	PINS 5,8
110	2	1858	S402		INSUFFICIENT SOLDER	U31 ✓	PINS 1,5
110	2	1858	S402		INSUFFICIENT SOLDER	U34 ✓	PINS 1,5
110	1	1858	S402		INSUFFICIENT SOLDER	U20 ✓	PIN 4

*13 13 13 13 13*  
*2/23/05*  
*3/30/05*



WESTEK

Operator :quyen  
06/23/05  
16:25:35

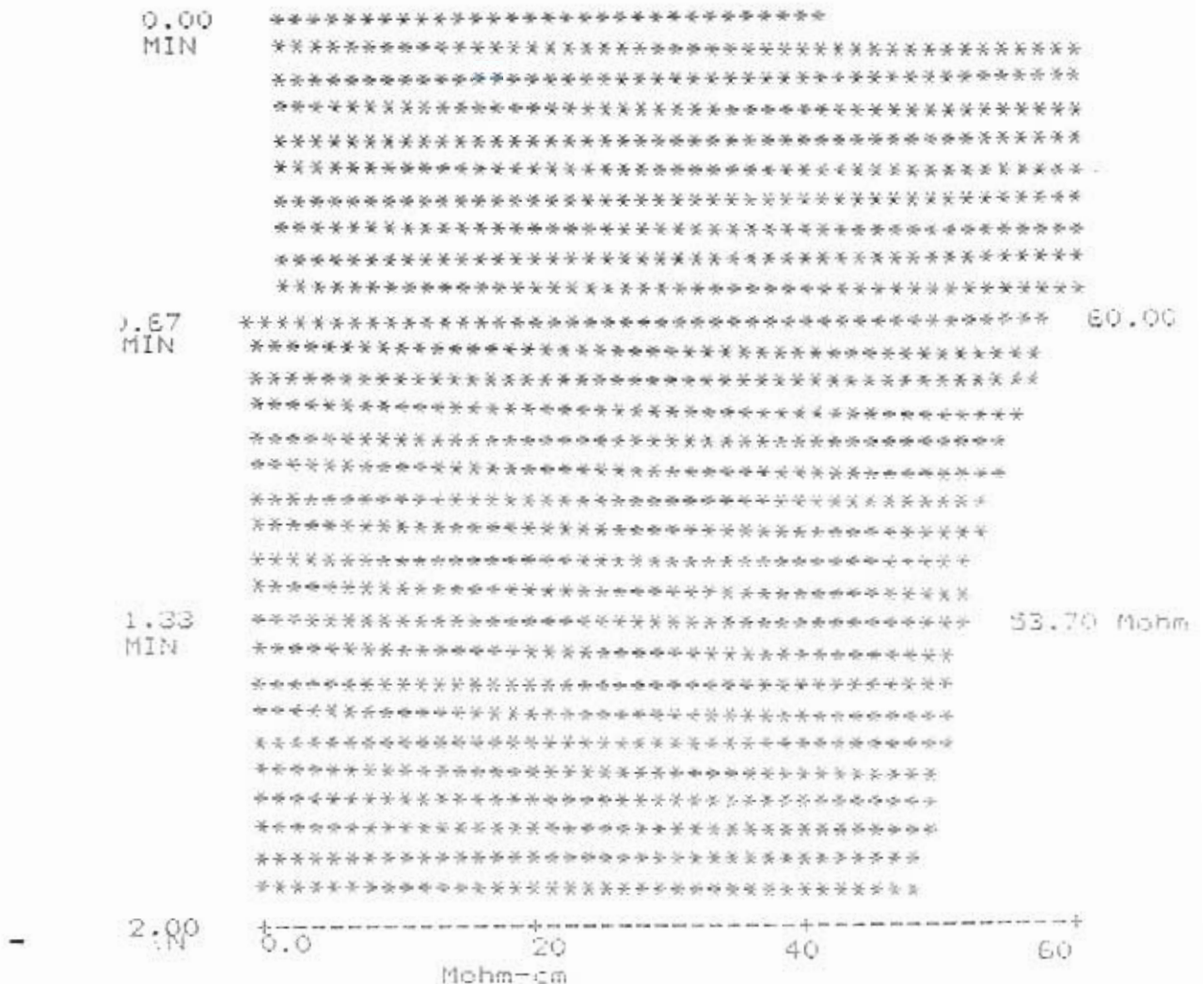
Test Type  $\rightarrow$

Board # gt110 has P A S S E D

TEST TIME : 2.00 min  
TEST VOLUME : 9680 ml  
BOARD AREA : 242.0 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 : 53.83 Mohm-cm  
NaCl Equivalence (Final) : 0.75 ug/sq in

TIME vs RESISTIVITY



Final Resistivity : 50.40 Mohm-cm  
NaCl Removed : 0.07 ug/sq in

CCA PIN: LAT-DS-01646 GLAT 1761 GT110

W.O. #: 112010

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

Date: 6/24/05

MIX RATIOS

Coating TYPE: ARATHANE Mfr: HUNTSMAN

Lot Number: AK4GB8013A Expiration Date: 6/30/05

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

AIR CURE: 6/24/05 START <sup>12:01 pm</sup> ~~10:00 AM~~ FINISH 1:00 pm

OVEN CURE: Touch up 2:00 pm - 3:10 pm

POP 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 1

ASSY/PN# LAT-DS-02331-01  
ASSY: CABLE, TFS O/P PWR

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

CUST P#  
QTY 10  
PROJECT# F17300  
CUST# 16355

SERIAL NUMBER LISTING:-----  
N/A  
APPROVAL  
PROD: 2/18/05  
CA: WDR, 2-9-05

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

LOT NO.	LOT QTY	SERIAL NUMBERS	SEC NO.	REASON	APPRV DATE
A <sup>1</sup>	15	N/A	3		mm 3/8/05
B	4	N/A	3	To max	mm 3/8/05
A <sup>2</sup>	2	N/A	6	To move	mm 3/16/05
A <sup>1B</sup>	2	N/A	7	To move	mm 3/2/05
A <sup>1D</sup>	6	N/A	7	To move	mm 3/16/05

(wobdr rev 05.19.04 glh)

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



1 200 13 CONFIG RECORD/KITTING 0.0000 0.0000 0.0000  
CONFIG

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
DOCUMENT NUMBER REV FD/PL OUTSTANDING EO'S  
ASSY & PL: LAT-DS-02331 52 NONE  
REFERENCE ASSY/PL LAT-DS-02338 FOR RTV APPLICATION RCT!  
ISSY SPEC: N/A  
ASSY ALD: 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			WDR



WORK CELL: 4-MIXED

CUSTOMER: SLAC

TL PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/PN# LAT-DS-02831-01  
ASSY. CABLR. TFS D/P PWR

WOB 112044  
REQ DATE 02-08-05  
REQ DATE 02-02-05  
SC#  
PC# 0000048800

CUST PN  
QTY 19  
PROJECT# 117300  
QUSIS 16356

PAGE 2

\*\*\*\*\*  
L# 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 RIV.

DATE QTY. REMARKS..... STATUS  
2/10/05 19  
*[Signature]*



W/ TEL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/PNS LAT DS-02831-01  
ASSY, CABLE, TWS O/P PWR

NO# 112044  
ISSUED DATE 02-08-05  
REVISED DATE 02-02-05  
VOR# 0000048800

PAGE 3  
CUST #  
QTY 19  
PROJECT# F17300  
CUST# 15256

LI# DEPT MACH# OP# DESCRIPTION..... HOURS  
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 - OTC-2081.

CUT 6 PIECES OF WIRE @ 6" TO 8" LONG, FOR FULL TESTS.  
USE 3 PCS EACH FOR PRE-CRIMP AND POST-CRIMP TESTS.

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

USE ~~SCHEIDT~~ PNEUMATIC WIRE STRIPPER SET UP WITH  
24 AWG STRIP BLADES, A STRIP LENGTH OF ~~1/16"~~ 7/16 (1.188)  
AND LEAVES THE INSULATION SLUG IN PLACE.

\* PRE-ASSY CRIMP TEST

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

CRIMP TEST: BY: RM1970 DATE: 2/16/05 STATUS Pass Crimp Tensile Strength Paper attach  
P1111

\* ASSEMBLY ACTIVITY...

- 1) FEED WIRE DIRECTLY OFF THE SPOOL TO THE STRIPPER.
- 2) STRIP THE INSULATION LEAVING THE SLUG, ~~W/ 1/16" (1.588)~~ 7/16 (1.188) 2-15-05
- 3) CUT THE WIRE OFF AT THE INDICATED LENGTH, AND QUANTITY.  
\* CUT 78 WIRES TO 8-1/2" (8.50") LONG.
- 4) STRIP SECOND END USING THERMAL TWEEZERS, 1/4"
- 5) TIN SECOND END BY SOLDER DIP. CLEAN WITH ALCOHOL.
- 6) FULL INSULATION SLUG AND CRIMP CONTACT (220) ONTO LEAD.  
USE M22520/2-01 CRIMPER W/ M22520-2-06 TURRET/LOCATOR.  
16:41

3.6.05 crimp test H-6 #1941 pre-assy  
3.7.05 crimp test H-6 #1941 pre-assy  
3.18.05 post assy crimp test H-6 #1941

\* POST-ASSY CRIMP TEST...

STRIP AND CRIMP THREE CONTACTS USING TEST WIRE. TEST THE  
SAMPLE CRIMPS PER OTC-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	
3/16/05	7	<del>4 wires</del>	300

3.22.05 strip, tin, crimp H-6 #1941 (133)

3.27.05 strips H-6 #1941 (815)

3.23.05 crimp, tin, clean H-6 #1941 (492)

3.28.05 tin & clean H-6 #1941 (315)

TOP LL & MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/PNY LAT-DS-02831-01  
ASSY, CABLE, TPS O/P PKR

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

CMST TN  
PROJECT# P17300  
QTY 19  
CURT# 15356

PAGE 4

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



4 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OFF: SLDR-78 ASSY-312

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

DRR#(S)

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	

H.B. #1441



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

- \* 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		

checked strips 375 wires 3/22/05  
1140  
checked crimps & tin 3/24/05  
checked wires for tinning 3/5 Em 1574

RM 1970  
H.B. #1441  
H.B. #1441



6 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
OFF: SLDR-0 ASSY-78

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

DRR#(S)

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	" " "	

407 LL 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 5

ASSY/PNA LAT-DG-01831-01  
ASSY. CABLE. IFS O/P PWR

WO# 112044  
REQ DATE 02-09-05  
REL DATE 02-02-05  
SQ#  
PO# 0000048800

CUST P#  
QTY 10  
PROJECT# F17300  
CUST# 15358

LI# 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, DCS-1104, TO WIRES EXITING CONNECTOR SHELL, FROM THE SHELL DOWN THE WIRES 1/2" (.5").
- \* TRANSFER RTV TO AN SFD 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 (62 C).
- \* RECORD CURE DATE, START/STOP TIME BELOW:

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

DATE	QTY	REMARKS	STATUS
<u>3/24/05</u>	<u>2</u>		<u>APR 12 02</u>
<u>3/28/05</u>	<u>6</u>	<u>same lot of RTV used as above</u>	<u>H.G.#1941</u>
<u>4/22/05</u>	<u>6</u>		<u>25M1212</u>



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

- \* INSPECT POTTING/CURING OF LEAD ASSEMBLY.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.  
DRR#(S) \_\_\_\_\_
- \* ROUTE FOR WO CLOSURE AND NEXT ASSY - LAT-DG-02369.

DATE	QTY	REMARKS	STATUS
<u>4/23/05</u>	<u>5</u>		
_____	_____	_____	
_____	_____	_____	





ASSEMBLY # : LAT-DS-02831-01  
NO QUANTITY : 19  
WIP LOCATION: W02

BY LINE ITEM

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

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

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIREMENTS		RECV IN LOT #	INVLOC NUMBER	LOT	INVENTORY DETAIL			
			QUANTITY	STAT QUANTITY				QUANTITY	LOT DATE	BIN	
1	206505-1 CONN (311P407-SS-B-15) ORIGINAL QUANTITY...	EA	100	RD	19.00	SKCF2 FN-1		0.00			
<p>The following parts have been defined as alternates for 206505-1:</p> <p>LINE 1.1 311P407-SS-B-15 1 PER</p> <p>Partial quantity replacements are allowed.</p> <p><i>Handwritten: SJB LAT-DS-02831 LOT # 114947</i></p>											
											<i>Handwritten: 18</i>

2	M22759/11-24-9 WIRE, 24AWG, WHITE ORIGINAL QUANTITY...	IN	860.00	RSVD	16340.00	115299	SKCF2 FN-1	115299	34055.00	12-01-04	LOT1152
<p><i>Handwritten: 16340</i></p>											

3	206071-1 CONTACT (206071-1) ORIGINAL QUANTITY...	EA	26.84	RD	510.00		SKCF2 FN-2		0.00		
<p>The following parts have been defined as alternates for 206071-1:</p> <p>LINE 3.1 G0851 1 PER</p> <p>Partial quantity replacements are allowed.</p>											

3.1	G0851 CONTACT (206071-1) ORIGINAL QUANTITY...	EA	51.16	RSVD	972.00	115021	SKCF2 FN-1	115021	972.00	09-27-04	
<p>This line is an alternate part for line 3. G0851 is used in a 1 to 1 ratio to 206071-1. Partial quantity replacements are allowed.</p> <p><i>Handwritten: 972</i></p>											

4	DC6-1104 ADHESIVE ORIGINAL QUANTITY...	OZ	1.00	RD	19.00		SKCF2 FN-1		0.00		
<p>REQUIREMENT SHOWS ON LAT-DS-02831-01. APPLY HERE.</p> <p><i>Handwritten: 0</i></p>											



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 #:	RHOON MARMON 1970		TEST DATE	
CONTACT PN:	206071-1		2.16.05	
WIRE PN:	M22759/11-24-9		TESTED BY	
CRIMP TOOL PN (GTC Tool #):	M22520/2-01 (GTC-A830)		RHOON MARMON	
DIE/LOCATOR PN (GTC Tool #):	M22520/2-06 (GTC-A834)		WORK ORDER NO.	
SELECTOR VALUE:	3		112044	
TEST EQUIP # (Last CAL date):	ALPHA 1200 MP 2007 (6.17.07)			
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
	Type of Separation Observed			
SLIP (pull out) (a)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
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- )	Rhona Marmon
DIE/LOCATOR PN (GTC Tool #):	(GTC- )	WORK ORDER NO.
SELECTOR VALUE:		118044
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)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
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-DS-02831-01

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	<b>PRE</b> - PROD		POST - PROD	
CRIMP OPERATOR NAME/EMP #:	Herbie Gray 1#1941			TEST DATE
CONTACT PN:	206071-1			3.16.05
WIRE PN:	M22759 / 1124-9			TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520 / 201 (GTC #1092)			Herbie Gray
DIE/LOCATOR PN (GTC Tool #):	M22520 / 2-06 (GTC #692)			WORK ORDER NO.
SELECTOR VALUE:	3			117044
TEST EQUIP # (Last CAL date):	Alphatron MP1-200A (6.11.04)			
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)	<b>PASS</b>		<b>PASS</b>		<b>PASS</b>	
	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-02831-01

MIL-STD-1344: METHOD 2003.1

TEST TYPE (circle one):	<b>PRE</b> PROD	POST - PROD						
CRIMP OPERATOR NAME/EMP #:	Deora M 1#1262	<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>117044</td></tr> </table>	TEST DATE	3.16.05	TESTED BY	Herbie Gray	WORK ORDER NO.	117044
TEST DATE	3.16.05							
TESTED BY	Herbie Gray							
WORK ORDER NO.	117044							
CONTACT PN:	20671-1							
WIRE PN:	M22759 / 11-24-9							
CRIMP TOOL PN (GTC Tool #):	M22520 / 2-01 (GTC 4-1011)							
DIE/LOCATOR PN (GTC Tool #):	M22520 / 2-06 (GTC A833)							
SELECTOR VALUE:	3							
TEST EQUIP # (Last CAL date):	Hydram MPT-2000 (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)	<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 req):

10:36 a.m.

for build of (e)

# CRIMP TENSILE STRENGTH CAT-15-0283/01

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	<b>POST</b> - PROD
CRIMP OPERATOR NAME/EMP #:	Herbie Gray 1# 1941	TEST DATE
CONTACT PN:	20671-1	3-18-05
WIRE PN:	M22759 / 11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520 / 7-01 (GTC #1002)	Herbie Gray
DIE/LOCATOR PN (GTC Tool #):	M22520 / 7-06 (GTC #1912)	WORK ORDER NO.
SELECTOR VALUE:	3	112044
TEST EQUIP # (Last CAL date):	Aluminum MPF2006 (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:	13.6	13.6	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):



11:00 a.m.

Build of 12

### CRIMP TENSILE STRENGTH CAT-DS-02381-01

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 #:	Harvie Gray 1# 1441	TEST DATE
CONTACT PN:	206071-1	3-22-05
WIRE PN:	M22520 / 11-249	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520 / 2-01 (GTC# 102)	Harvie Gray
DIE/LOCATOR PN (GTC Tool #):	M22520 / 2-06 (GTC# 953)	WORK ORDER NO.
SELECTOR VALUE:	3	112044
TEST EQUIP # (Last CAL date):	Alphatron MET-2004 (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
	<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

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	POST - PROD
CRIMP OPERATOR NAME/EMP #:	Harvie Gray #1941	TEST DATE 3-23-05 TESTED BY Harvie Gray WORK ORDER NO. 112044
CONTACT PN:	206071-1	
WIRE PN:	M22729 11-24-9	
CRIMP TOOL PN (GTC Tool #):	M22520 12-01 (GTC #1012)	
DIE/LOCATOR PN (GTC Tool #):	M22520 12-06 (GTC #833)	
SELECTOR VALUE:	3	
TEST EQUIP # (Last CAL date):	Alpertech 2004 (last cal)	
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:	13.1	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 LA-03-02831-01

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	PRE - PROD	<b>POST - PROD</b>
CRIMP OPERATOR NAME/EMP #:	Martha 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 4833)	Martha Villa
DIE/LOCATOR PN (GTC Tool #):	m 22520-206 (GTC 4833)	WORK ORDER NO.
SELECTOR VALUE:	3	112044
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:	13.6	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

A FNS LAT-DS-02830-01  
ASBY, CABLR, TFS 1/P 1WR

NO: 112043  
REQ DATE 02-03-05  
MPL. MATR 02 01 02  
SUB  
POB 0000048900

QTY 10  
17400018 P1/100  
CUST# 15356

PAGE 1

SERIAL NUMBER LISTING: .....

N/A

APPROVAL  
PROD: YH 2/3/05  
QA: YH 2/3/05

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	13	N/A	6		mm 3/10/05
B	4	N/A	6	To move	mm 3/10/05
A2	2	N/A	6	To move	mm 3/10/05

(vohdr rev 05.19.04 glh) .....

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



200 00 CONFIG RECORD/KITTING 0.0000 0.0000 0.0000

..... CONFIGURATION DOCUMENTS .....

DOCUMENT NUMBER REV FD/PL OUTSTANDING BO'S  
 ASSY & PL: LAT-DS-02830 53 NONE  
 (REFERENCE ASSY/PL LAT-DS-02838 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

2-3-05 \_\_\_\_\_ YH





WORK CELL: 4-MIXED

CUSTOMER: SLAC

TY: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 2

ASSY./PN# LAT-DS-02830-01  
ASSY. CABLE, TPS 1/P FWR

WO# 112043  
REQ DATE 02-09-05  
REL DATE 02-01-05  
SO#  
PO# 0000048800

CUST PN  
QTY 19  
PROJECT# P17300  
CUST# 15354

.....  
L# DEPT MACH# OP# DESCRIPTION..... HOURS  
SET-UP RIN... 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.

DATE 2/9/05 QTY 19

REMARKS .....

STATUS

*[Handwritten signature]*

Assy/FIN# IAT-DS-02830-01  
ASSY. CADLE, TFS I/P DWR

WOR 112043  
RPO DATE 02-09-05  
REL DATE 02-01-05  
SOP  
PO# 0000048800

QTY 10  
PROJECT# F17300  
CUST# 15356

LIST DEPT MACH# C/P# DESCRIPTION..... HOURS  
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 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~~ PNEUMATIC WIRE STRIPPER SET UP WITH  
24 AWG STRIP BLADES, A STRIP LENGTH OF 1/8" (.125"),  
AND LEAVES THE INSULATION SLUG IN PLACE.

*ELBANKS S.M.A.C. MCGEE #4800-  
2/1/05*

• 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" (.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 (22D) ONTO LEAD.  
USE M22520/2-01 CRIMPER W/ M22520-2-09 TURRET/LOCATOR.

*2/11 (10:00)*

*1/6: 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: 2/18/05 DATE: Rm1970 STATUS Pass

DATE	QTY	REMARKS	STATUS
2/18/05	4	4 set of 10 - 10	Rm1970
3/8/05	1	1 set of 10 - 10 (Reward)	CVI1920
3/19/05		2 set of 10	MV, DM, mm. - 108

*3-16 0.3-4 - set of 10*

*MV 1743*

*3/16/05 w/ set of 10 strip only*

WORK CELL: 4-MIXED

CUSTOMER: SLAC

T PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/PN: 1AT-DS-02830-01  
ASSY, CABLE, 1P'S 1/P PWR

WO# 112043  
REQ DATE 02-09-05  
REL DATE 02-03-07  
SO#  
PO# 0000048800

CUST PR  
QTY 10  
PROJECT# F17300  
CUST# 15356

PAGE 4

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



4 230 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CPE: SLDR-20 ASSY-R0

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

DRR#(S) 29547

DATE... QTY... REMARKS.....  
2/22/05 40/32

STATUS  
OK

3/2/05 10 Restripped ok

STATUS  
SLV



5 210 00 CCA/BLACK BOX ASSY AREA 0.0000 0.0000 0.0000  
INSERT WIRES AND CONTACTS TO CONNECTOR.

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

WIRE PAIR	CLR	PINS
PAIR #1	WHT	1
	RED	2
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.....  
3.8.05 1 complete

STATUS  
H.6.#1941

3.15.05 2 complete

STATUS  
H.6.#1941



WORK CELL, 4-MIXED

CUSTOMER: STAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSEMBLY: IAT-DS-02830-01  
ASSY. CABLE, TPS 1/P PWR

WCH# 112043  
REQ DATE 02-09-05  
REL DATE 02-03-05  
SQ#  
PO# 0000048800

CUST P#  
QTY 19  
PROJECT# F17300  
CUST# 15356

PAGE 5

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



4 200 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
REF: SISR.0 ASSY. 24

- \* 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

3/9/05 3

3/14/05 2



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

- \* APPLY RTV, DC6-1104, TO WIRES EXITING CONNECTOR SHELL, FROM THE SHELL DOWN THE WIRES 1/2" (.5").
- \* TRANSFER RTV TO AN EFD 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 OCA.
- \* 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 7-10-2005
- \* CURE APPLIED RTV IN OVEN FOR 2 HOURS AT 120 DEG F (60 C).
- \* RECORD CURE DATE, START/STOP TIME BELOW:

DATE: START: STOP:

DATE: 3-16-05 QTY: 2 REMARKS:..... STATUS: ME/PM 1202

CLEAR Defect Report #2954  
for 8 wires

ME/PM 2-25-05

3-14-05 22 11 feet Crimps  
used for red length



WORK CELL: 4 MIXED

CUSTOMER: SIAC

TY: PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSEMBLY: LAT-US-02630-01  
ASSY. CABLE. TFS I/P PWR

WOB: 112043  
REQ. DATE: 02-09-05  
REL. DATE: 02-03-05  
SO#: 0000048800  
PO#: 0000048800

PRINT P#  
QTY: 10  
PROJECT#: F17300  
CUST#: 15356

PAGE: 6

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



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

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

DRR#(S) \_\_\_\_\_

- \* ROUTE FOR WO CLOSURE AND NEXT ASSY - LAT-US-02388.

DATE	QTY	REMARKS	STATUS
3/17/05	2		OK
_____	_____	_____	_____
_____	_____	_____	_____



# DEFECT RECORD REPORT

ID: 29547

PART NUMBER: LAT-OS-02830-01

INSPECTION TYPE: CRIMPING

OFFE SOLDER: 20

WORK ORDER: 112043

INSPECTION LEVEL: 1

OFF ASSEMBLY: 90

SALES ORDER: F17300

INSPECTOR: WANDEVER

DATE: 2/22/2005


QUANTITY: 40 RW QTY: 3

WEEK CODE: 10

CUSTOMER: SLAC

SERIAL NO	QUANTITY	OPERATOR	DEFECT CODE	WORKCELL	DEFECT DESCRIPTION	REF DES	PIN NOTES
NA	2	1970	A316	4-MIXED	CUTS OR NICKS	WIRES	Twisted wires Red/white
NA	6	1970	A325	4-MIXED	IMPROPER CABLE LENGTH	WIRES	Twisted wires Red/white

*Cam 1970*

318105 



WORK CELL: 4-MIXED

CUSTOMER: SLAC

TYPE: PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 1

AS N# LAT-DS-02588  
ASSY, CABLE, COND. TEM

WO# 111026  
REQ DATE 02-04-05  
REL DATE 01-31-05  
SC#  
PC# 0000048799

CUST P#  
QTY 19  
PROJECT# F17200  
CUST# 15356

\*SERIAL NUMBER LISTING:-----  
N/A

APPROVAL: \_\_\_\_\_  
PROD: GH 2/4/05  
QA: MM 2.4.05

-----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

----- (wahr rev 05.19.04 glh) -----

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

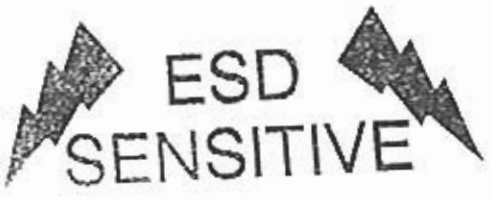


0 00 CONFIG RECORD/KITTING 0.0000 0.0000 0.0000  
CONFIG

\*\*\*\*\* CONFIGURATION DOCUMENTS \*\*\*\*\*  
ASSY & PL: LAT-DS-02588 DOCUMENT NUMBER REV FD/PL OUTSTANDING EO'S  
TEST SPEC: N/A 51 NONE  
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
<u>2-4-05</u>			<u>MM</u>



WORK CELL: 4-MIXED

CUSTOMER: SLAC

T PRODUCTION

WORK ORDER TRAVELLER - NEW

PAGE 2

ASSY/PN: LAT-DS-02588  
ASSY, CABLE, CONV, TEM

WO# 112026  
REQ DATE 02-04-05  
REL DATE 01-31-05  
SO#  
PO# 0000048788

CUST P#  
QTY 19  
PROJECT# F17200  
CUST# 15386

\*\*\*\*\*  
LI# DEPT MACH# OP# DESCRIPTION..... H O U R S  
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, AND CONNECTOR.

DATE	QTY	REMARKS	STATUS
01/05	19		

WORK CELL: 4-MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/FNS IAT-DS-02588  
ASSY, CABLE, COGN, TEM

WOB 112026  
REQ DATE 02-24-05  
REL DATE 01-31-05  
JOB# 0000048759

CUST #  
QTY 19  
PROJECT# F17200  
CUST# 15358

PAGE 3

Star 1-4  
1337  
4/26/05  
move to start p. 3A  
Jethal

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



1 220 00 CABLE/HARNESS ASSY AREA 0.0000 0.0000 0.0000

CUT WIRE, STRIP WIRE,  
CRIMP PIN CONTACTS,  
TIN LEADS.

CRIMP TEST SETUP - GTC-2081.

CUT 6 PIECES OF WIRE 8 1/2" 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 SCHEIDT 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 status DATE: 2/9/05 STATUS Pass  
R. Marston 1970

ASSEMBLY ACTIVITY...

1) FEED WIRE DIRECTLY OFF THE SPOOL TO THE STRIPPER.

2) STRIP THE INSULATION LEAVING THE SLUG, ~~7/8" (39)~~

3) CUT THE WIRE OFF AT THE INDICATED LENGTH, AND QUANTITY.

4) CUT 3 PIECES TO 1-1/8" (1.125") LONG. USE PROGRAM #89

5) CUT 3 PIECES TO 1" (25.4) LONG. USE PROGRAM #90

6) STRIP SECOND END USING THERMAL TWEEZERS.

7) TIN SECOND END BY SOLDER DIP. CLEAN WITH ALCOHOL.

8) FULL INSULATION SLUG AND CRIMP CONTACT (22D) ONTO LEAD.  
USE M22525/2-01 CRIMPER W/ M22525-2-05 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 R. Marston 1970 DATE: 2/9/05 STATUS Pass

DATE	QTY	REMARKS	STAT
2/10/05	4	8 7/8" (39) & 1 1/8" (39) @ 4 each	PM1970
3.10.05	8	1 1/8" (39) 1" (200) 1 5/16" (175)	H.G. #1941
3.11.05	8	1 1/8" strips	H.G. #1941

Equipment CHANGE: EUBANKS  
3/16" strip length to 1/4"  
(19)  
Pass Crimp Tensile Strength Sheet attached  
H.B. 3-21-05  
H.B. 2-8-05

1 2 3 4 - performed using S. 80  
3/16" (19)  
ON EUBANKS  
GTC-A-463  
K42 - mm.  
H.B. 2-8-05

3.11.05 8 5/16 strips H.G. #1941

3.11.05 crimps 1 5/16 H.G. #1941

3-10-05 MV 1942 1" strips  
3-12-05 turning H.G. #1941 1 5/16

3-14-05 crimp/in 1" (46) H.G. #1941  
3-14-05 crimp/in 1 1/8" (96) H.G. #1941  
3-14-05 crimp/in 1 1/8" (235) H.G. #1941  
3-14-05 crimp/in (26) 1" H.G. #1941

\* pre-Asst crimp test 2.28.05 pass H.G. #1941  
pre-Asst crimp test 3.1.05 pass H.G. #1941  
" 3.2.05 pass H.G. #1941  
" 3.3.05 pass H.G. #1941  
no crimping on 3.4.05  
pre-Asst crimp test 3.5.05 pass H.G. #1941  
" 3.7.05 pass H.G. #1941  
pre-Asst crimp test 3.14.05 pass H.G. #1941  
post-Asst crimp test 3.21.05 pass H.G. #1941

See page  
3A - continued  
Jethal



WORK CELL: 4 MIXED

CUSTOMER: SLAC

PRODUCTION

WORK ORDER TRAVELLER - NEW

ASSY/PN# LAT-DS-03588  
ASSY. CABLE. CONN. TEM

NO# 112026  
REQ DATE 02-04-05  
REL DATE 01-31-05  
SOP  
PO# 0000048795

COST PR  
QTY 19  
PROJECT# 1717200  
CUST# 10356

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  
CPE: SLDR-78 ASSY-312

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

DRR#(S)

DATE	QTY	REMARKS	STATUS
2/17/05	4	7/8" 39 pieces	(GTC 019)
	4	1/8" 39 pieces	(GTC 019)
3/4/05		(Redone)	(GTC 019)



5 220 00 CABLE/HARNESS ASSY AREA 0.0000 0.0000 0.0000  
CPE: SLDR-0 ASSY-78  
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.

DATE	QTY	REMARKS	STATUS
2/17/05	4		RM1970
3-15-05	2		L.G.#1941
3-21-05	1		L.G.#1941

*3/1/05 1/8" inspection 4 strip*  
*3/1/05 1/8" strips*  
*1" strip 3/1/05*  
*strips, crimps a thing TO 3/14/05*  
*3-23-05*  
*Just 1/8" wires into 21 Through 459*



6 290 00 QUALITY ASSURANCE AREA 0.0000 0.0000 0.0000  
CPE: SLDR-0 ASSY-78

- \* INSPECT INSERTED WIRES.
- \*\* RECORD DEFECT RECORD REPORT NUMBER(S) BELOW.

DRR#(S)

ROUTE FOR NO CLOSURE AND DELIVERY TO NEXT ASSY LAT-DS-01644.

DATE	QTY	REMARKS	STATUS
2/17/05	4	AMP206504-1 conn	(GTC 019)
		marks. step 5.	(GTC 019)
3-15-05	2	AMP206504-1 conn, check marks	(GTC 019)
3/21-05	1		(GTC 019)
3/22/05	3	conn.	(GTC 019)

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

LINE	PART NUMBER AND DESCRIPTION	UM	REQUIREMENTS			INVLOC	LOT NUMBER	INVENTORY DETAIL			
			REQUIRED QUANTITY	CURR STAT	RESV IN QUANTITY			LOT QUANTITY	LOT DATE	BIN	BINLOC QUANTITY
1	206504-1 AMPLIMITE ORIGINAL QUANTITY...	EA	1.00	RSVD	19.00	114794	SKCF2 FN-1	114794	22.00	09-23-04	
The following parts have been defined as alternates for 206504-1: Line 1.1 2112407-5P-B-15 1 PER Partial quantity replacements are allowed.											
2	M22759/11-24-9 WIRE, 24AWG, WHITE ORIGINAL QUANTITY...	IN	102.00	RSVD	1938.00	115299	SKCF2 FN-3	115299	35994.00	09-01-04	
The following parts have been defined as alternates for 204370-8: Line 3.1 G08P1 1 PER Partial quantity replacements are allowed.											
3	204370-8 PIN, CRIMP ORIGINAL QUANTITY...	EA	84.00	RSVD	1596.00	114796	SKCF2 FN-2	114796	1997.00	09-23-04	IN ASSY
							FN-2	115041	972.00	09-27-04	717200

19

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:	201370-8	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 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:	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 #:	/	
CONTACT PN:		
WIRE PN:		
CRIMP TOOL PN (GTC Tool #):	(GTC- )	TEST DATE 2/09/05 TESTED BY Rotor Marnon 1970 WORK ORDER NO. 112026
DIE/LOCATOR PN (GTC Tool #):	(GTC- )	
SELECTOR VALUE:		
TEST EQUIP # (Last CAL date):	( )	
PULL RATE:	1" +/- .25" per min.	

## 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}		✓ RN	✓ RN
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 #:	RHOA MARION / 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 930)	RHOA MARION 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 MAF 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)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
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)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
CONTACT BROKEN OUTSIDE OF CRIMP AREA (e)			
OTHER (define) (f)			
SPECIAL INSTRUCTIONS (as reqd):			



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- )	RHONA MARRION
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):

PRE - PROD

POST - PROD

CRIMP OPERATOR NAME/EMP #:

Herbie Gray 181941

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):

Aldatron MPF200A (6/10/04) 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)

PASS

FAIL

PASS

FAIL

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):











8:50 A.M.

## CRIMP TENSILE STRENGTH (at-DS-02588)

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	<u>PRE - PROD</u>	POST - PROD
CRIMP OPERATOR NAME/EMP #:	Herbie Gray 1#1941	TEST DATE
CONTACT PN:	204370-8	3.7.05
WIRE PN:	M22759 / 11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520 / 2-d (GTC# 830)	Herbie Gray
DIE/LOCATOR PN (GTC Tool #):	M22520 / 2-09 (GTC# 831)	WORK ORDER NO.
SELECTOR VALUE:	3	112026
TEST EQUIP # (Last CAL date):	Helatex MPF700A (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

Lot 15-02583

MIL-STD-1344; METHOD 2003.1

TEST TYPE (circle one):	<b>PRE</b> PROD	POST - PROD
CRIMP OPERATOR NAME/EMP #:	Herbie Gray 1#1941	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 #):	M22759 / 2-01 (GTC # 102)	
DIE/LOCATOR PN (GTC Tool #):	M22759 / 7-01 (GTC # 836)	
SELECTOR VALUE:	3	
TEST EQUIP # (Last CAL date):	11/2004 / 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	17.9	13.2
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):



# 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 # 1941	TEST DATE
CONTACT PN:	204370-8	3.21.05
WIRE PN:	M22759 / 11-24-9	TESTED BY
CRIMP TOOL PN (GTC Tool #):	M22520 / 2-0 / (GTC 4100)	Herbie Gray
DIE/LOCATOR PN (GTC Tool #):	M22520 / 2-09 (GTC 4.836)	WORK ORDER NO.
SELECTOR VALUE:	3	112026
TEST EQUIP # (Last CAL date):	Alphatron 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:	13.6	13.4	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):

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-A610)	Dora
DIE/LOCATOR PN (GTC Tool #):	M22520-2-09 (GTC- )	WORK ORDER NO.
SELECTOR VALUE:	3	112096
TEST EQUIP # (Last CAL date):	6/17/04 <sup>DIC</sup> 6/17/04 GTC 758	
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-D5-0258

CRIMP TENSILE STRENGTH					
MIL-STD-1344; METHOD 2003.1					
TEST TYPE (circle one):	PRE - PROD		POST - PROD		
CRIMP OPERATOR NAME/EMP #:	Nara 11337		TEST DATE		
CONTACT PN:	204370-8 (608P1)		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 FS11)				
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)	<input checked="" type="checkbox"/> PASS		<input checked="" type="checkbox"/> PASS		<input checked="" type="checkbox"/> PASS
	FAIL		FAIL		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):					



PART#	DESC	QTY	FROM LOT#	FROM LOT
1210S563K251YHTM	CAPACITOR	16.00	114802	200415016
5962-B759406XA	IC, LM1858BH-2.5, NEC	3.00	114805	785343F019
5962R99568101VXC	IC	1.00	114814	E25FDADA
5962R9985203QTC	IC	5.00	123441	D7C 0408
5962R99865103OYC	IC	4.00	120289	D7C 0407
3DR31BX472BKUS	CAPACITOR	249.00	114801	L0T 0422-10N
3DR33BX473AKUS	CAPACITOR	53.00	114799	L0T 0419R
3DR09FC476KDH	CAPACITOR	49.00	114800	L0T 0417
3DR11FH105KDH	CAPACITOR	36.00	120284	D7C 0426 LOT 0425AB52
3DR11FH475KDH	CAPACITOR	2.00	120285	D7C 0430
H0705CEX000	THICK FILM JUMPER	151.00	114817	L0T 7R107039
JANTXV1K41530R-1	DIODE	2.00	114806	L0T V-5869
LAF-DS-01026	PLATE, CONN, TSM	1.00	114784	NO L0T
LAF-DS-01031	PLN, CONNECTOR, TSM	2.00	114785	CONN PLATE
LAF-DS-01649	PWR, TEM	1.00	120299	NO L0T
LAF-DS-02588	ASSY, CABLE, CONN, TEM	1.00	130879	CONN PIN
LAF-DS-03582	STANDOFF	2.00	114787	D7C 4904, 4441
LAF-DS-03894	IC	1.00	127758	NO L0T
LAF-DS-03895	IC	1.00	123759	PARAMS STANDOFF 4-40
LAF-TD-01812	IC	8.00	114816	
LAF-TD-01814	IC	4.00	114813	
M55342K06B100DR	RESISTOR, CHLP, 100W, 100 OHM	60.00	114822	L0T 7R107035
M55342K06B100ER	RESISTOR, CHLP, 100W, 100K	50.00	114823	L0T 7R107045
M55342K06B10E0R	RESISTOR, CHLP, 100W, 10K O	23.00	114830	L0T 7R107038 (250)
M55342K06B1E00R	RESISTOR, CHLP, 100W, 1K OHM	55.00	114818	L0T 7R107040
M55342K06B1F00R	RESISTOR, CHLP, 100W, 1M OHM	2.00	114819	L0T 7R107041
M55342K06B200DR	RESISTOR	2.00	114824	L0T 107036
M55342K06B22D1R	RESISTOR	205.00	114821	L0T 112409
M55342K06B49D9R	RESISTOR, CHLP, 100W, 49.9	4.00	114827	L0T 7R110001
M55342K06B5E11R	RESISTOR	2.00	114825	L0T 7R110002
M55342K09B10F0R	RESISTOR	2.00	114820	L0T 107042

MS5342K09B1P00R	RESISTOR	2.00	114828	LOT 309569
MAX145AE0A	IC	24.00	114809	TOP 0310
MAX145AE0A	IC	12.00	120286	D/C 0310
MAX5121AEEB	IC	2.00	114810	LOT 0134
MCR-1051-1B1	CONNECTOR	9.00	114803	D.C 0404
MCR-1069-1B1	CONNECTOR	4.00	114804	D.C 0415
MS24671-2	SCREW	4.00	114790	76436
MS51957-13	SCREW, PHHD, 4-40 X .25	2.00	93945	
MS1352M02-8	SCREW	26.00	114786	70494-2
MS629-C2	FLATWASHER	52.00	114789	M062504R
MS671-C2	NUT	26.00	114791	50254
S31P18-09S7R6	THERMISTOR, 30K	2.00	114825	D.C 0341188
SMD050	FUSE, PLYCHEM/POI, SWITCH	4.00	114807	D.C 0348
SMD075	IC	4.00	114926	D.C 0332

NO. LOTS  
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PARTS ISSUED TO NO 112026

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PART#..... NOTES.....	DESC.....	QTY.....	FROM LOT#.....	FROM LOT
204370-8	FIN, CRIMP	1596.00	114796	LR087754
206504-1	AMPLIMITE	19.00	114794	00462
M22759/11-24-9	WIRE, 24AWG, WHITE	1938.00	115299	46190



PART#	DESC	QTY	FROM LOT#	FROM LOT
204370-8	PIN, CRIMP	380.00	114796	1888754
204370-8	PIN, CRIMP	500.00	126643	
EAT-DS-02930	ASSY, CABLE, TRS T/P PAR	19.00	114906	LOT 0414 , 0351
M22759/11-24-279	WIRE, 2AWG RED/WHITE	5700.00	115300	

NOTES.....

NO. LOTS

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PARTS ISSUED TO NO 112044

07-

PART# .....  
NOTES.....

DESC.....

QTY.....

FROM LOT#.....

FROM LOT

G08S1	CONTACT (206071-1)	972.00	115021	LOT 04153
G08S1	CONTACT (206071-1)	510.00	125762	
G08S1	CONTACT (206071-1)	400.00	128557	D/C 04153 LOT#
LRM9146b				
LAT-D8-02831	ASSY, CABLE, TPS O/P PWR	18.00	114947	LOT D/C 0413
M22759/11-24-9	WIRE, 24AWG, WHITE	16340.00	115299	46190

PART#	DESC	QTY	FROM LOT#	FROM LOT
1210B563K251YHTM	CAPACITOR	12.00	114802	200435016
32763-31	INDUCTOR	2.00	114965	SLAC LOT#0412
32786-31	INDUCTOR	12.00	114964	SLAC LOT#0413
596218771002VXA	IC	2.00	114962	SLAC LOT#HC00409A
5962R9582602VXC	IC	6.00	120302	328ABR5, 239ABRV
5962R9663501VXC	IC	5.00	120301	D/C351
APP461	IC FILTER	1.00	114959	D/C 0410
CDR04BX104AKUS	CAP, .10F, 50V	32.00	114935	SLAC LOT#0404
CDR31BP100BKUS	CAPACITOR	14.00	114938	SLAC LOT#040510G
CDR31BP101BKUS	CAPACITOR	4.00	114944	SLAC LOT#0490M
CDR31BP470BKUS	CAPACITOR	4.00	115090	SLAC LOT#0420FN
CDR31HX102BKUS	CAPACITOR	2.00	114936	SLAC LOT#0420RL
CDR32BX103BKUS	CAP 0.010F 100V 10%	22.00	114937	SLAC LOT#0413EM
CDR33BX223BKUS	CAPACITOR	4.00	114940	SLAC LOT#0403VVC
CDR33BX473AKUS	CAPACITOR	7.00	114939	LOT 0419B
CWR09FC476KDB	CAPACITOR	89.00	114943	SLAC LOT#0418
CWR09HC106KCB	CAPACITOR	4.00	114939	SLAC LOT#0409
D55342K07B40ZER	RES, 462K, 1/4W, 1%	1.00	115001	SLAC LOT#112027
D55342K07B511ER	RESISTOR	10.00	115002	SLAC LOT#TR107816
H0705CERX000	THICK FILM JUMPER	15.00	114817	LOT TR107039
IRHNJ597034	TRANSISTOR	3.00	114966	SLAC LOT#D0321662
JANTXV1M4106UR-1	DIODE	4.00	114953	SLAC LOT#V-6966
JANTXV1M4153UR-1	DIODE	8.00	114949	SLAC LOT#V-5869
JANTXV1M4489US	DIODE	1.00	125757	
JANTXV1M4494US	DIODE	1.00	114955	SLAC LOT#Z301190
JANTXV1N5806US	DIODE 1N5806US	8.00	114950	SLAC LOT#H5030088A
JANTXV1N6485US	DIODE	1.00	128556	D/C 0308
JANTXV1N6487US	DIODE	6.00	114952	D/C 0349 LOT#V-7503
JANTXV2N2222A0H	TRANSISTOR MPN	21.00	120303	SLAC LOT#V-7528
JANTXV2N2907AMB	TRANSISTOR	2.00	115007	D/C318
JANTXV2N3439	TRANSISTOR	4.00	115006	SLAC D/C#0330
JAT-DS-02389	PWB, GLAST, TFS	1.00	120305	TOP 0343
JAT-DS-02465	HEAT SINK, TFS	4.00	115014	D/C 3304, 4804
JAT-DS-03598	SUPPORT, CABLE HARNESS	2.00	120309	SLAC LOT# R/A
				MG D/C OR LOT



LAT-DS-03598	SUPPORT, CABLE HARNESS	2.00	125377	
LAT-DS-04101	HEATSINK	2.00	120304	NO LOT OR D/C
M22759/11-24-9	WIRE, 24AWG, WHITE	1.00	115299	46190
M39006/22-0567H	CAPACITOR	30.00	114941	LOT D/C 041ACZ
041ACX				
M55342K06B1B21R	RESISTOR	4.00	114970	SLAC LOT#HR21501
M55342H06B2B21R	RESISTOR	6.00	114979	SLAC LOT#HR21601
M55342K06B100DR	RESISTOR,CHIP,100K,100 OH	4.00	114822	LOT TR107015
M55342K06B109ER	RESISTOR,CHIP,100K,100K	13.00	114823	LOT TR107045
M55342K06B10E0R	RESISTOR,CHIP,100K,10K 0	21.00	114987	SLAC LOT#TR107830
M55342K06B13E0R	RESISTOR	3.00	114985	SLAC LOT#TR107619
M55342K06B15E0R	RESISTOR,CHIP,100K,15K 0	1.00	114990	SLAC LOT#TR107620
M55342K06B18E2R	RESISTOR	2.00	114991	SLAC LOT#TR107040
M55342K06B1E00R	RESISTOR,CHIP,100K,1K OH	6.00	114818	LOT TR107040
M55342K06B1E21R	RESISTOR	3.00	114971	SLAC LOT#TR107523
M55342K06B1E37R	RESISTOR	4.00	114972	SLAC LOT#TR10811
M55342K06B1F00R	RESISTOR,CHIP,100K,1M OHM	6.00	114819	LOT TR107041
M55342K06B20E0R	RESISTOR,20kohms	8.00	114992	SLAC LOT#TR107621

PART#	DESC	QTY	FROM LOT#	FROM LOT
M55342K06B2E1R	RESISTOR	5.00	114994	SLAC LOT#TR107623
M55342K06B2E7R	RESISTOR	3.00	114980	SLAC LOT#TR109928
M55342K06B301DR	RESISTOR	1.00	115000	SLAC LOT#TR112908
M55342K06B33E2R	RESISTOR	1.00	114995	SLAC LOT#TR112391
M55342K06B49E9R	RESISTOR, 49.9Kohms	6.00	114996	SLAC LOT#TR107624
M55342K06B5490R	RESISTOR	2.00	114981	SLAC LOT#TR108586
M55342K06B5E11R	RESISTOR	2.00	115003	SLAC LOT#TR111507
M55342K06B5E62R	RESISTOR	2.00	114829	LOT TR110002
M55342K06B61E9R	RESISTOR	1.00	114984	SLAC LOT#TR107829
M55342K06B8E25R	RESISTOR	1.00	114997	SLAC LOT#TR107625
M55342K09B10D0R	RESISTOR	2.00	114985	SLAC LOT#109510
M55342K09B10F0R	RESISTOR	1.00	114986	SLAC LOT#TR109046
M55342K09B1F0GR	RESISTOR	4.00	114820	LOT 107042
M55342K09B22D1R	RESISTOR	2.00	114828	LOT 109509
M55342K09B2E00R	RESISTOR	1.00	114993	SLAC LOT#TR107622
M55342K09B4E99R	RES, CHIP, 2.00K, 1%, 72W	1.00	115091	SLAC LOT#TR107617
MAX724ECK	IC	2.00	114982	SLAC LOT#TR9044
NAS1149CN432R	WASHER	7.00	114961	LOT D/C 0342PS
NAS1149CN632R	WASHER	4.00	115016	LOT M061404R
NAS1352N04-6	SCREW	19.00	115010	LOT A1205030
NAS1352N06-6	SCREW	4.00	114832	Y6123
NAS671C4	SCREW	7.00	115011	LOT Y2477
NAS671C6	SCREW	4.00	115009	LOT M122600L
PLT1M-C76	NUT, HEX, SS, PASS, 4-40THRD	19.00	122955	
RWR895R230FR	NUT, #6, SM, PNT	100.00	129042	LOT D/C 15419237
RXE065	TIE, CABLE, LOCKING, PANDUIT	1.00	114968	
RXHL10	RESISTOR	2.00	114957	LOT D/C 0329
S311P18-09S7R6	FUSE	2.00	114958	LOT D/C 0412
SSR1040GTXV	FUSE, POLYSWITCH	2.00	115004	LOT D/C 0400Z1
	THERMISTOR, 30K	7.00	114948	SLAC LOT#0404
	DIODE			

MO. LOTS  
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PARTS ISSUED TO MO 113111

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PART#	DESC	QTY	FROM LOT#	FROM LOT
LAT-DS-00554	TEM BOX BASE	1.00	120298	NO d/c or Lot#
LAT-DS-00555	TEM BOX LID	1.00	120297	NO D/C OR LOT#
LAT-DS-01646	CCA, GLAST, TEM	1.00	130014	
NAS1352N03LB4	HARDWARE	26.00	114831	BO89504B
NAS1352N04-6	SCREW	29.00	114832	76123
NAS1352N3-8	HARDWARE	1.00	114833	74803



PART#	DESC	QTY	FROM LOT#	FROM LOT
LAT-DS-00995	BASE, BOX, TFS	1.00	121225	
LAT-DS-00996	LTD, BOX, TEM PS	1.00	121224	
LAT-ES-02388	CGA, GLAST, TFS	1.00	130886	
NA51352NO4-4	SCREEN	20.00	115019	LOT D/C 78364
NA51352NO4-6	SCREEN	30.00	115012	LOT D/C 76123

NOTES:.....

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PARTS ISSUED TO MO 113237

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PART#.....  
NOTES.....

1AV-DS-01487

DESC.....  
SCREW, SKTHD CAP, 832X.62

QTY.....  
40.00

FROM LOG#.....  
120307

FROM LOG#.....  
LOG 68402-1-1