



TRAVELER S-18

NOTE: This is a Batch traveler

**SHIELD WIRE MOUNT ASSY, RIGHT, DIMENSION,
CONTINUITY, AND RESISTANCE CHECK**

SHIELD WIRE MOUNT ASSY, RIGHT, INNER SECTOR,
dwg # 24A4554

amount: _____ each

SHIELD WIRE MOUNT ASSY, RIGHT, OUTER SECTOR.
dwg # 24A4494

amount: _____ each

After tanswering each of the following questions please initial your name.

VISUAL INSPECTION

1. Is PC board attached in wrong orientation? Yes __, No __

2. Is there excessive squeezed out expoxy? Yes __, No __

3. Are there epoxy drips on the shield wire mount? Yes __, No __

4. Is there epoxy on the contact metal strip? Yes __, No __

5. During gluing together, wire mount assembly must be index to the top side (outer radius / end of wire mount side).

If wire mount wasn't indexed to the top side check "Yes".
If wire mount is indexed to the top side check "No". Yes __, No __

IF THE ANSWER TO ANY QUESTION ABOVE IS **YES** BAG AND TAG
BOARDS with **"REJECTED-VISUAL"** AND NOTIFY
COGNIZANT ENGINEER.

DIMENSIONAL INSPECTION

- 6. MEASURE all Shield wire mount assemblies
Do all assemblies conform to their Dimensions and Tolerances shown on the appropriate drawing?
(Shield wire mount Assembly, right, inner sector: dwg#24A4554)
(Shield wire mount Assembly, right, outer sector: dwg#24A4494)

Yes __, No __

Tag any Assembly that is out of Spec with "**REJECTED- DIMENSIONS**"

Before electronic inspection add lead to shield wire mount PC board's vias.(Note: Two leads on the shield)

ELECTRONIC INSPECTION

- 7. Is there short between PC board and shield wire mount? Yes __, No __
- 8. Check from each of the two lead connectors to the solid trace on the "top" side of PC board with ohm meter for continuity in several places.
Does each measurement show a resistance of 5 ohm or less? Yes __, No __

INSTRUCTIONS

If item 8 is marked **NO**, tag the assembly "**REJECTED**" and mark below and place it in "reject" storage. If item 8 is marked **YES**, attach this inspection record and place the assembly in "to-be-cleaned storage".

PASSED _____

REJECTED _____

Inspector's signature _____ Inspection date: __/__/199__



TRAVELER S-19

NOTE: This is a Batch traveler

SHIELD WIRE MOUNT ASSY, LEFT, DIMENSIONAL CHECK

SHIELD WIRE MOUNT ASSY, LEFT, INNER SECTOR,
dwg # 24A4564

amount: _____ each

SHIELD WIRE MOUNT ASSY, LEFT OUTER SECTOR,
dwg # 24A4484

amount: _____ each

After tanswering each of the following questions please initial your name.

VISUAL INSPECTION

1. Is there excessive squeezed out epoxy? Yes __, No __

2. Are there epoxy drips on the shield wire mount? Yes __, No __

3. Is there any epoxy on the top of the insulation board? Yes __, No __

IF THE ANSWER TO ANY QUESTION ABOVE IS **YES** BAG AND TAG ASSEMBLIES with **"REJECTED-VISUAL"** AND NOTIFY COGNIZANT ENGINEER.

DIMENSIONAL INSPECTION

4. MEASURE all Shield wire mount assemblies
Do all assemblies conform to their Dimensions and Tolerances shown on the appropriate drawing?
(Shield wire mount Assembly, left, inner sector: dwg#24A4564)
(Shield wire mount Assembly, left, outer sector: dwg#24A4484)
Yes __, No __

Tag any Assembly that is out of Spec with **"REJECTED- DIMENSIONS"**

INSTRUCTIONS

If item 4 is marked **NO**, tag the assembly "**REJECTED**" and mark below and place it in "reject storage". If item 4 is marked **YES**, attach this inspection record and place the assembly in "to-be-cleaned storage".

PASSED _____

REJECTED _____

Inspector's signature _____ Inspection date: __/__/199__



TRAVELER S-20

NOTE: This is a Batch traveler

GATED GRID WIRE MOUNT ASSY, RIGHT, DIMENSION, CONTINUITY, AND RESISTANCE CHECK

GATED GRID WIRE MOUNT ASSY, RIGHT, INNER SECTOR
dwg # 24A4574

(ref.minmum 26 unit)

amount: _____ each

GATED GRID WIRE MOUNT ASSY, RIGHT, OUTER SECTOR
dwg # 24A4614

(ref.minmum 26 unit)

amount: _____ each

After answering each of the following questions please initial your name.

VISUAL INSPECTION

1. Is PC board attached in wrong orientation? Yes __, No __
2. Is there excessive squeezed out epoxy? Yes __, No __
3. Are there epoxy drips on the gated grid wire mount? Yes __, No __
4. Are there any epoxy on the contact metal strip? Yes __, No __
5. When glued together, Gated grid wire mount assembly must be indexed to the specified side (it will be specified by the lead tech.John Wirth.)

If Gated grid wire mount assy wasn't indexed to the specified side check "Yes".
If Gated grid wire mount assy was indexed to the specified side check "No".

Yes __, No __

IF THE ANSWER TO ANY QUESTION ABOVE IS **YES** BAG AND TAG
BOARDS with **"REJECTED-VISUAL"** AND NOTIFY
COGNIZANT ENGINEER.

DIMENSIONAL INSPECTION

- 6. MEASURE all Assemblies:
Do all assemblies conform to their Dimensions and Tolerances shown on the appropriate drawing?
(Gated grid wire mount ASSY, right, inner sector: dwg#24A4574)
(Gated grid wire mount ASSY, right, outer sector: dwg#24A4614)

Yes __, No __

Tag any Assembly that is out of Spec with "**REJECTED- DIMENSIONS**"

Before electronic inspection, add leads to gated grid wire mount PC board's vias.

ELECTRONIC INSPECTION

- 7. Are there short between PC board and gated grid wire mount? Yes __, No __
- 8. Check from each of the two leads connectors to the solid trace on the "top" side of PC board with ohm meter for continuity in several places. Does each measurement show a reistance of 5 ohm or less? Yes __, No __

INSTRUCTIONS

If item 7~8 are marked **NO**, tag the assembly "**REJECTED**" and mark below and place it in "reject" storage. If item 7~8 are marked **YES**, attach this inspection record and place the assembly in "to-be-cleaned storage".

PASSED _____

REJECTED _____

Inspector's signature _____ Inspection date: __/__/199__



TRAVELER S-21

NOTE: This is a Batch traveler

GATED GRID WIRE MOUNT ASSY, LEFT, DIMENSIONAL CHECK

GATED GRID WIRE MOUNT ASSY, LEFT, INNER SECTOR,
dwg # 24A4584

amount: _____ each

GATED GRID WIRE MOUNT ASSY, LEFT OUTER SECTOR,
dwg # 24A4604

amount: _____ each

After tanswering each of the following questions please initial your name.

VISUAL INSPECTION

1. Is there excessive squeezed out epoxy?

Yes __, No __

2. Are there epoxy drips on the gated grid wire mount?

Yes __, No __

3. Is there any epoxy on the top of insulation board?

Yes __, No __

IF THE ANSWER TO ANY QUESTION ABOVE IS **YES** BAG AND TAG ASSEMBLIES with **"REJECTED-VISUAL"** AND NOTIFY COGNIZANT ENGINEER.

DIMENSIONAL INSPECTION

4. MEASURE all Gated grid wire mount assemblies
Do all assemblies conform to their Dimensions and Tolerances shown on the appropriate drawing?

(Gated grid wire mount Assembly, left, inner sector: dwg#24A4584)

(Gated grid wire mount Assembly, left, outer sector: dwg#24A4604)

Yes __, No __

Tag any Assembly that is out of Spec with **"REJECTED- DIMENSIONS"**

INSTRUCTIONS

If item 4 is marked **NO**, tag the Assembly "**REJECTED**" and mark it below accordingly and place it in "reject" storage. If item 4 is marked **YES**, attach this inspection record and place the Assembly in "to-be-cleaned storage".

PASSED _____ **REJECTED** _____

Inspectors signature _____ Inspection date: __/__/199__



TRAVELER S-22

SHIELD & GATED GRID WIRE MOUNT PINNING, MARKING, AND DIMENSIONAL CHECK.

(Pinning of wire mounts to the strong back)

SECTOR Type: Outer_____ Inner_____ Serial No._____

WIRE MOUNT PINNING ASSEMBLY INNER SECTOR
dwg # 24A4536 (waiting for the drawing)

WIRE MOUNT PINNING ASSEMBLY OUTER SECTOR
dwg # 24A4546 (waiting for the drawing)

After answering each of the following questions please initial your name.

MARKING

1. Scribe the SECTOR SERIAL No. on the side of the shield wire mount and the gated grid wire mount. The serial number must be at least 1/8 inch high.

Done by:_____

VISUAL INSPECTION

1. Are there any dowel pins incorrectly installed?
(Note: 18 pins must be placed 9 pins on each side flush with outer surface of the gated grid wire mount)
Yes __, No __
2. Are there epoxy drips on the gated grid wire mount?
Yes __, No__
3. Is there any epoxy on the top of insulation board?
Yes __, No__

IF THE ANSWER TO ANY QUESTION ABOVE IS **YES** NOTIFY
COGNIZANT ENGINEER.

DIMENSIONAL INSPECTION

4. MEASURE the heights of the Shield, Gated grid and Anode wire mounts.

Check for high spots along the full length of each wire mount.
The wire mounts should be .004" to .009" below the height standard for that wire mount.

IS THE GATED GRID WIRE MOUNT HEIGHT .004" TO .009" LOWER THAN THE 3.7997" GATED GRID WIRE MOUNT STANDARD?

Yes __, No __

IS THE SHIELD WIRE MOUNT HEIGHT .004" TO .009" LOWER THAN THE 3.5635" GATED GRID WIRE MOUNT STANDARD?

Yes __, No __

IS THE ANODE WIRE MOUNT HEIGHT .004" TO .009" LOWER THAN THE 3.4071" GATED GRID WIRE MOUNT STANDARD?

Yes __, No __

IF ANY ANSWER TO QUESTION 4 ABOVE IS **NO**, TAG THE PART "REJECTED WIRE MOUNT HEIGHT" THEN NOTIFY COGNIZANT ENGINEER.

PASSED _____

REJECTED _____

Inspector's signature _____ Inspection date: ____/____/199__

