



TRAVELER S-25

ANODE WIRE FRAME VISUAL INSPECTION AND TENSION TEST

RECORD ANODE WIRE WINDING NUMBER # \_\_\_\_\_

RECORD WHICH SPOOLS WIRE WERE USED: # \_\_\_\_\_

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

VISUAL INSPECTION

1. Is there kink in the wires? Yes \_\_, No \_\_
  
2. Are any wires contaminated with oil, dirt, and/or lint? Yes \_\_, No \_\_
  
3. Are there any discolorations of the wire ? Yes \_\_, No \_\_
  
4. Are there any missing wires in the wire frame? Yes \_\_, No \_\_
  
5. Are there any epoxy drippings on wound wires? Yes \_\_, No \_\_
  
6. Is insufficient epoxy applied at both ends of the wires to fixed them in the position?  
(The minimum width of epoxy to be applied at both ends shall be specified by Jon Wirth ) Yes \_\_, No \_\_
  
7. Are there any loose wire?  
(check this without using Laser Wire Tension Scanner) Yes \_\_, No \_\_

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

**DIMENSIONAL INSPECTION**

- 8. Acceptable ANODE WIRE winding spacing is **4 mm ± 1 center to center**. Take a three adjacent measurements at three locations (bother ends and at the center of the frame)

Does wire spacing of the wire winding failed to meet the requirement? Yes \_\_, No \_\_

**NOTE:** If one out of six wire frame from same winding does not meet the spacing requirement we can assume that the other five wire frames also do not meet the spacing requirement.

If item 8 is marked **YES**, bag and tag all six wire frames from same winding "**REJECTED DIMENSIONS**" and put them in "reject storage", and **notify cognizant engineer**.

**TENSION TEST**

**Using Laser Wire Tension Scanner, take a minimum of ten sample wire tension readings and record them. Try to take distributed sample readings from one wire frame.**

<u>Wire Number</u>	<u>Frequency reading (Hz)</u>	<u>Tension (Newtons)</u>
1. _____	_____	_____
2. _____	_____	_____
3. _____	_____	_____
4. _____	_____	_____
5. _____	_____	_____
6. _____	_____	_____
7. _____	_____	_____
8. _____	_____	_____
9. _____	_____	_____
10. _____	_____	_____
11. _____	_____	_____
12. _____	_____	_____
13. _____	_____	_____
14. _____	_____	_____
15. _____	_____	_____

The tension of all wires on the frame should be **0.50 Newtons ± 0.03**

- 9. Were all sample tension measurements within the specified tension limit? Yes \_\_, No \_\_

## INSTRUCTIONS

If item 9 is marked **No**, tag and bag all six wire frames from same winding "**REJECTED TENSIONS**" and mark below and put them in "reject storage". If item 9 is marked **YES**, attach this inspection record and place wire frame inside of LEXAN storage/transporter box.

(Note: When storing the wire frames inside of LEXAN storage/transporter box, **do not put traveler inside of the box**. Place them outside of the LEXAN box).

PASSED \_\_\_\_\_

REJECTED \_\_\_\_\_

Inspector's signature \_\_\_\_\_ Inspection date: \_\_/\_\_/199\_\_





TRAVELER S-26

ANODE WIRE FRAME PRIOR TO USE CHECK  
VISUAL INSPECTION

RECORD ANODE WIRE WINDING NUMBER # \_\_\_\_\_

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

VISUAL INSPECTION

- 1. Is there kink in the wires? Yes \_\_, No\_\_
- 2. Does any wire contaminated with oils, dirt, and/or lint? Yes \_\_, No\_\_
- 3. Are there any discolorations of the wire ? Yes \_\_, No\_\_
- 4. Are there any missing wires in the wire frame? Yes \_\_, No\_\_
- 5. Are there noticeable change in the wire tension?  
(Look for sags or noticeable catenary effect) Yes \_\_, No\_\_
- 6. Are there any broken wires? Yes \_\_, No\_\_

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

INSTRUCTIONS

If visual inspection has failed, bag and tag **"REJECTED WIRE FRAME"** and mark below and put them in "reject storage area".

PASSED \_\_\_\_\_ REJECTED \_\_\_\_\_

Inspector's signature \_\_\_\_\_ Inspection date: \_\_/\_\_/199\_\_





TRAVELER S-27

ANODE WIRE S CHECK

SECTOR type: Outer \_\_\_ Inner \_\_\_ Strongback Serial No. \_\_\_\_\_

SECTOR SERIAL No.: \_\_\_\_\_

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

VISUAL INSPECTION AFTER ANODE WIRES ARE MOUNTED

1. Is there kink in the wires? Yes \_\_, No\_\_
  
2. Does any wire contaminated with oils, dirt, and/or lint? Yes \_\_, No\_\_
  
3. Are there any discolorations of the wire ? Yes \_\_, No\_\_
  
4. Are there any missing wires in the wire frame? Yes \_\_, No\_\_
  
5. Are there noticeable change in the wire tension?  
(Look for sags or noticeable catenary effect) Yes \_\_, No\_\_
  
6. Are there any broken wires? Yes \_\_, No\_\_

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

INSTRUCTIONS

If visual inspection has failed, bag and tag **"REJECTED WIRE FRAME"** and mark below and put them in "reject storage area".

PASSED \_\_\_\_\_ REJECTED \_\_\_\_\_

Inspector's signature \_\_\_\_\_ Inspection date: \_\_/\_\_/199\_\_







TRAVELER S-29

SHIELD WIRE AND GATED GRID WIRE FRAME VISUAL INSPECTION AND TENSION TEST

RECORD SHIELD WIRE /GATED GRID WIRE WINDING NUMBER # \_\_\_\_\_

RECORD WHICH SPOOLS' WIRE WERE USED: # \_\_\_\_\_

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

VISUAL INSPECTION

1. Is there kink in the wires?  
(check every spools) Yes \_\_, No \_\_
2. Does any wire contaminated with oils and dirt (include lint)? Yes \_\_, No \_\_
3. Are there any discoloration of the wire ? Yes \_\_, No \_\_
4. Are there any missing wire in the wire frame? Yes \_\_, No \_\_
5. Are there any epoxy dripping on wounded wires? Yes \_\_, No \_\_
6. Are not enough epoxy applied at both ends of the wires?  
(The minimum width of epoxy to be applied at both ends shall be specified by Jon Wirth ) Yes \_\_, No \_\_

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

DIMENSIONAL INSPECTION

7. SHIELD WIRE/GATED GRID WIRE winding spacing should be **1.0 mm ± 0.3 center to center.**  
Take a three adjacent measurements at three locations (both ends and at the center of the frame)

Are spacing of the wire winding failed to meet the requirement?

Yes \_\_, No \_\_

**NOTE:** If one out of six wire frame from same winding does not meet the spacing requirement we can assume that the other five wire frames also do not meet the spacing requirement.

If item 7 is marked **YES**, bag and tag all six wire frames from same winding "**REJECTED DIMENSIONS**" and put them in "reject" storage. and notify cognizant engineer

### TENSION TEST

Using Laser Tension Scanner take minimum of twenty sample wire tension readings and record them. Try to take distributed sample readings from one wire frame.

<u>Wire Number</u>	<u>Frequency reading (Hz)</u>	<u>Tension (Newtons)</u>
1. _____	_____	_____
2. _____	_____	_____
3. _____	_____	_____
4. _____	_____	_____
5. _____	_____	_____
6. _____	_____	_____
7. _____	_____	_____
8. _____	_____	_____
9. _____	_____	_____
10. _____	_____	_____
11. _____	_____	_____
12. _____	_____	_____
13. _____	_____	_____
14. _____	_____	_____
15. _____	_____	_____
16. _____	_____	_____
17. _____	_____	_____
18. _____	_____	_____
19. _____	_____	_____
20. _____	_____	_____
21. _____	_____	_____

The tension of all wires on the frame should be **1.20 Newtons ± 0.06**

8. Did sample tension measurement stay within the specified tension limit?

Yes \_\_, No \_\_

**INSTRUCTIONS**

If item 8 is marked **NO**, tag and bag all six wire frames from same winding "**REJECTED TENSIONS**" and mark below and put them in "reject" storage. If item 8 is marked **YES**, attach this inspection record and place them inside of LEXAN storage/transporter box.

(Note: When storing the wire frames inside of LEXAN storage/transporter box, **do not put traveler inside of the box**. Place them outside of the LEXAN box).

**PASSED** \_\_\_\_\_

**REJECTED** \_\_\_\_\_

Inspectors signature \_\_\_\_\_ Inspection date: \_\_/\_\_/199\_\_

