LN2 PROCESS FLOW

ROUGH DRAFT

Instrumentation Hazards, Tools, Parts, PPE

- Hazards:
  - Solder Fumes, Welding Arc, Burns, Cuts
- Tools:
  - Milwaukee Hand Drill, 5/8 Allen wrench, 3/8 Allen Wrench, Wire strippers, Knipex cutters, C clamps, Soldering Iron, Solder fume extractor, Spot welder,
- Parts:
  - Consolidated 26(7) Blue wire, Consolidated 26(7) Orange Wire, Hose Clamps, 2mm shim spacers, 44 Sn40Pb60 Rosin Solder
- PPE:
  - Safety Glasses, Gloves (unsuitable for rotating parts), Welding Glasses

Silver plating Hazards, Tools, Parts PPE

- Hazards:
  - Fumes, Skin Eye irritant, Flammable, Toxic, Corrosive, Electrical Hazard
- Tools:
  - Rapid Portable Plater, Silver Plating Activator, Silver Plating Solution- Coatalyte, Activator swab, Silver Plating Wand, Fume Extractor
- Parts:
  - Silver Plating Activator, Silver Plating Solution- Coatalyte, Sleeve NO. 31-P, Light duty White Scotch Brite, Ultra Fine Gray Scotch brite, General Purpose Red Scotch Brite
- PPE:
  - Safety Glasses, Gloves , Lab Coat, 3M Respirator, hood Pappr

Verify all previous steps have been completed before proceeding

- Ensure cable is prepped and ready to proceed to Test instrumentation

Place cable clamps to hold cable In place

- Use hose clamps to replace the clamping locations of the test cable that’s being held by clam shells.

Remove clam shells

- After each clamp shell has a hose clamp on each side begin removing clam shells.
- Store removed clam shells on the PF holding shelf adjacent to winding.

Remove metal pins

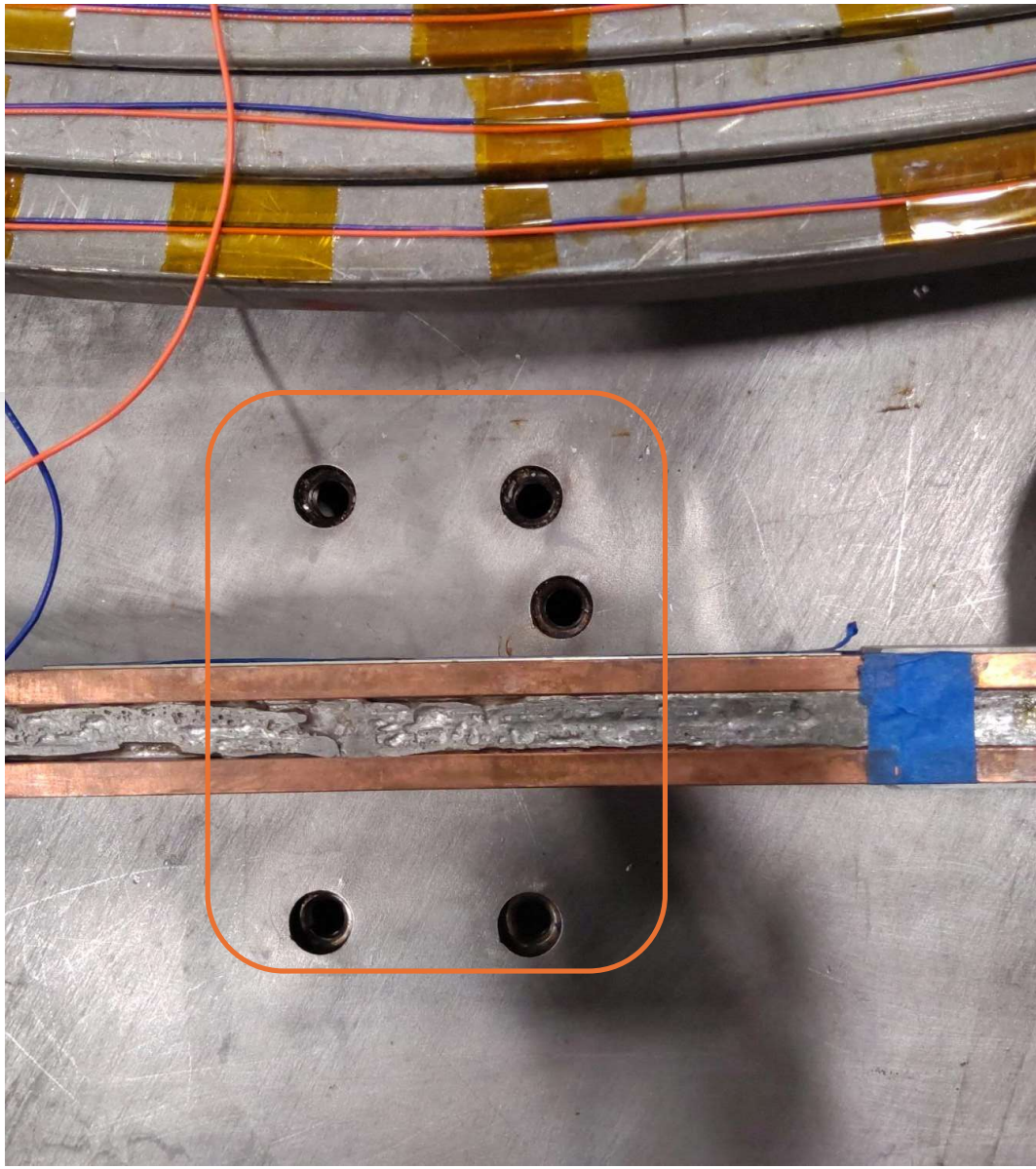
- Slowly work your way around the cable using the pry tools available to release pins from the cable.
- DON’T throw pins into the trash, store them in a bin, and return to winding.

Use plastic shims to create a 2mm gap spacing

- Release tension as needed from the hose clamps.
- Insert 2mm shim spacers into gaps turns at 1/8 pancake sections.

Adjust Cable locations

- Joggles have landing locations on the fry basket and are critical to land busbars to adapter locations.
- Landing location at the centroid of the joint region relative to the centroid of the four screw hole locations.



Verify before proceeding

- Cable clamps are holding the cable in place
- Shims have been replaced with nonmetallic materials
- Joint region has been centeralized

Mark spot welding locations

- Locate and verify the universal instrumentation map either provided or printed out.

Missing instrumentation Map

- If an instrumentation map is not available, generate one by printing the necessary sections and assembling them by cutting and taping the corners to form a complete map.

https://drive.google.com/drive/folders/1ixtibYRzg7C_H6VkZFzLuxyW004w4q_y