

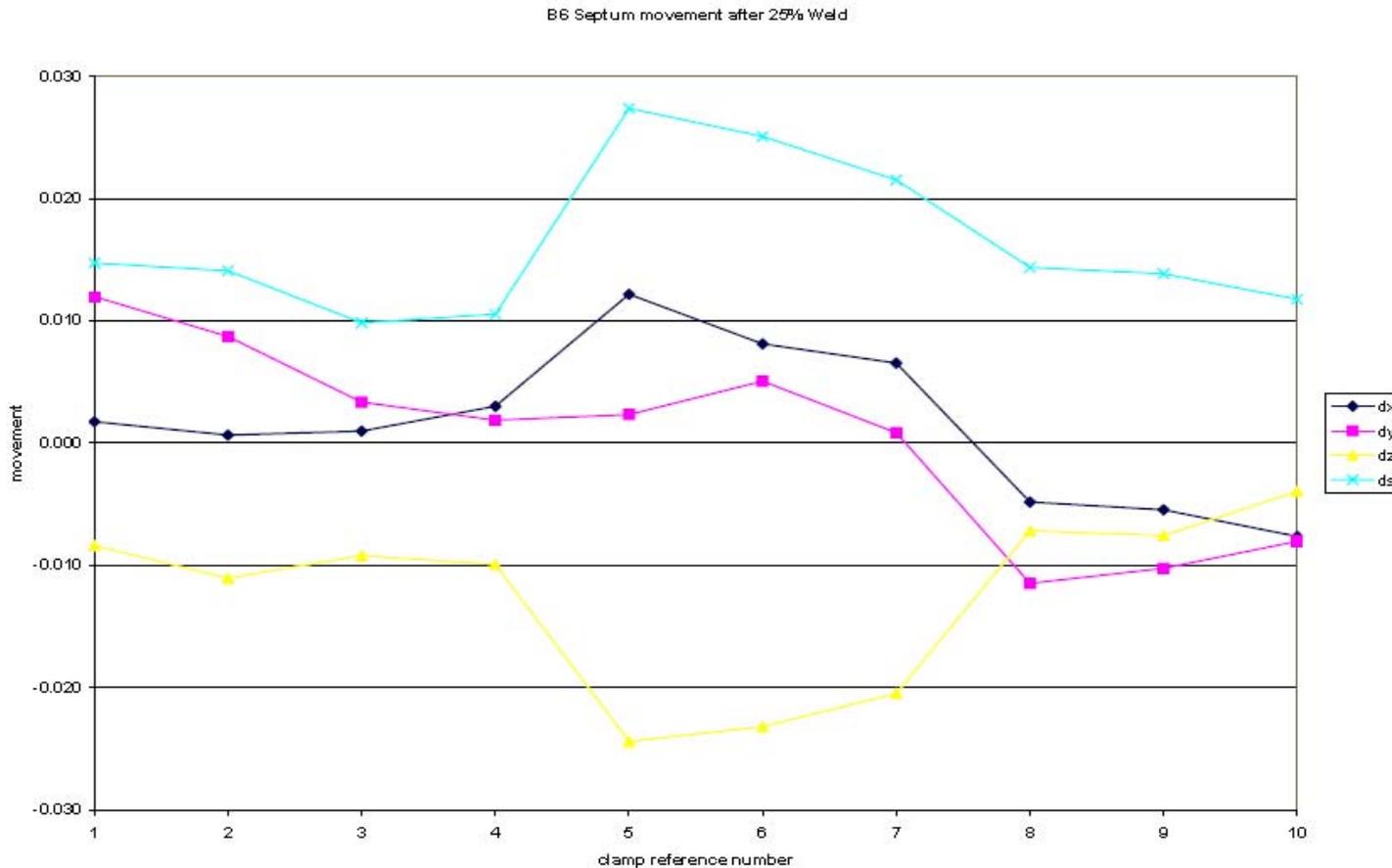
A6/B6 welding



Weld peening & deflection monitoring



Deflections after the first pass



Assembly & metrology techniques are being refined



- Much has been learned about metrology and assembly techniques during the preparations for the A6/B6 coil weld tests. Examples:
 - A reliable metrology methodology has been developed – measurement results duplicate factory CMM measurements.
 - Casting handling and locating techniques have been simplified.
 - Shim installation techniques have been developed compatible with the fit-up requirements of the friction shims.
 - Bolt tensioning by “Supernuts” have been adopted. They are both easier to torque than standard nuts and address access issues.
 - Tension will be accurately measured by ultrasonic bolt tension measuring device.
 - Bushing design and installation techniques are being optimized.
 - Comparing baseline design to double eccentric design.
 - Investigating in-field machining workstation to reduce time.
 - Custom fitting in advance reduces this critical path activity by 70%.

**More details will be
presented by Mike Viola**