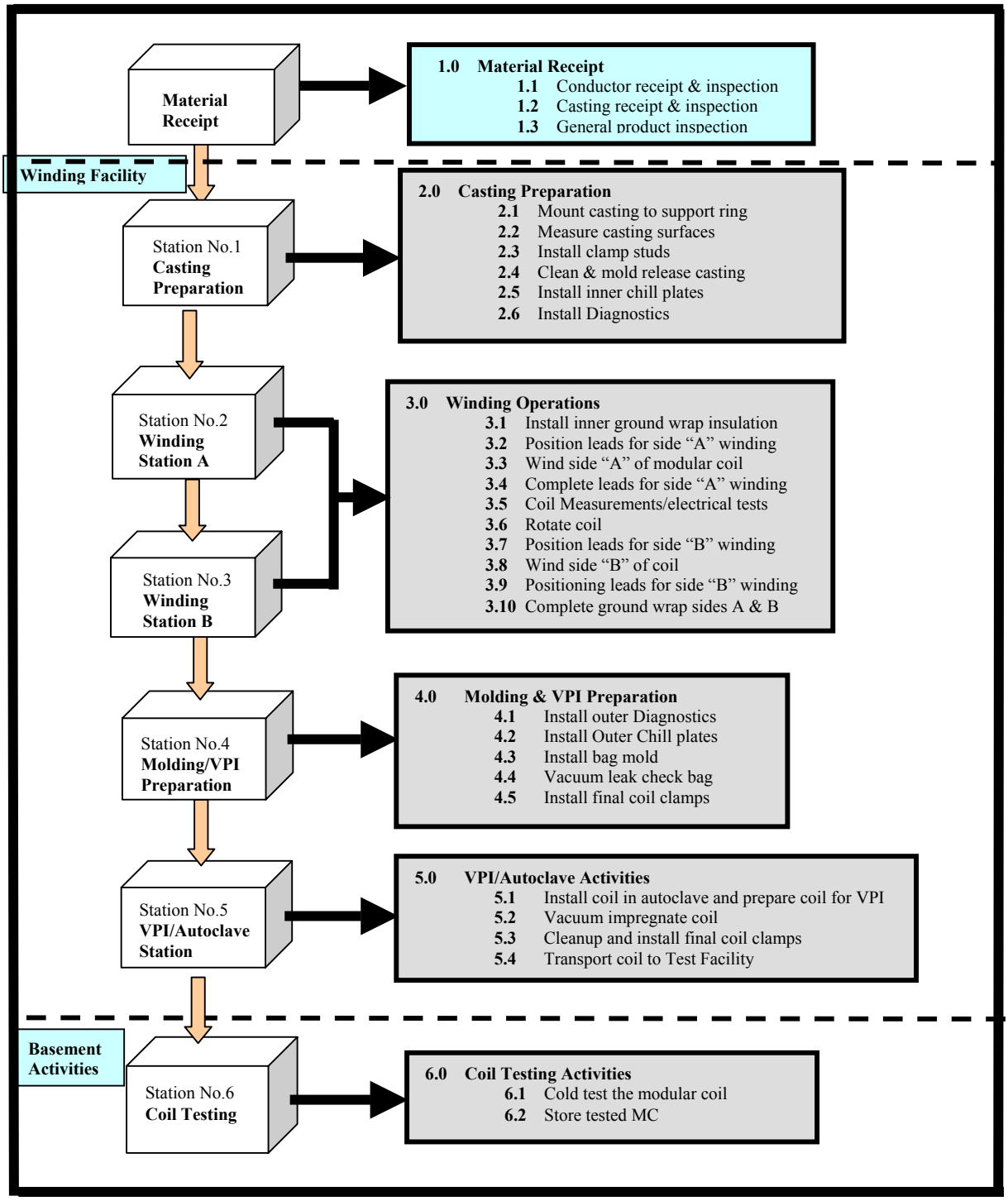
Material Receipt
1.0 Material Receipt
1.1 Conductor receipt & inspection
1.2 Casting receipt & inspection
1.3 General product inspection
Winding Facility
Station No.1 Casting Preparation
2.0 Casting Preparation
2.1 Mount casting to support ring
2.2 Measure casting surfaces
2.3 Install clamp studs
2.4 Clean & mold release casting
2.5 Install inner chill plates
2.6 Install Diagnostics
Station No.2 Winding Station A
Station No.3 Winding Station B
3.0 Winding Operations
3.1 Install inner ground wrap insulation
3.2 Position leads for side "A" winding
3.3 Wind side "A" of modular coil
3.4 Complete leads for side "A" winding
3.5 Coil Measurements/electrical tests
3.6 Rotate coil
3.7 Position leads for side "B" winding
3.8 Wind side "B" of coil
3.9 Positioning leads for side "B" winding
3.10 Complete ground wrap sides A & B
Station No.4 Molding/VPI Preparation
4.0 Molding & VPI Preparation
4.1 Install outer Diagnostics
4.2 Install Outer Chill plates
4.3 Install bag mold
4.4 Vacuum leak check bag
4.5 Install final coil clamps
Station No.5 VPI/Autoclave Station
5.0 VPI/Autoclave Activities
5.1 Install coil in autoclave and prepare coil for VPI
5.2 Vacuum impregnate coil
5.3 Cleanup and install final coil clamps
5.4 Transport coil to Test Facility
Basement Activities
Station No.6 Coil Testing
6.0 Coil Testing Activities
6.1 Cold test the modular coil
6.2 Store tested MC