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	Quality Assurance Procedure for Verifying High Voltage Plate Positioning		
	ATLAS project document no. ATL-IT-QP-0031	Date last modified. 21 May 2001	Approval status Full Production

1 Scope

1.1 Scope

This procedure establishes requirements for inspection of the high voltage plate positioning during module assembly.

1.2 Applicability

1.2.1 Applicability

This procedure applies to the alignment of all high voltage plates by the Indiana and Duke Production Facilities.

1.2.2 Relation to Other ATLAS Project Requirements

The quality assurance procedure described by this specification is in addition to other tests and inspections required for module assembly. Module assembly may continue only after acceptable results from this procedure.

2 Applicable Documents

2.1 Document List

The following documents of the issue in effect on the effective date of this specification form a part of this specification to the extent specified herein.

2.1.1 ATL-IT-EY-0004, ATLAS U.S. Environmental, Health, and Safety Plan

2.2 Amendments and Revisions

Whenever this procedure is amended or revised subsequent to its effective date, the Revised Version will be placed in the Engineering Data Management System, the Production DataBase displays, and released to the technicians. The Production

Engineers will coordinate release to the technicians.

3 Requirements

3.1 Background

The distance between the outside surfaces of the HV plates needs to be the correct number for the module to fit into the space frame. The HV plate also should be perpendicular to the axis of the module.

Appendix A provides a checklist to be used by Technicians performing this procedure.

4 Preparation for Delivery

4.1.1 Storage, Packing , and Shipping Requirements

There are no storage, packing, and shipping requirements applicable to this procedure.

5 Environment, Health, and Safety (EH&S)

5.1.1 EH&S Invoked


No special EH&S hazards are associated with the conduct of this process.

6 References

6.1 **ATLITB1_0010, Module 1 High Voltage Thick Plate**

6.2 **ATLITB2_0010, Module 2 High Voltage Thick Plate**

6.3 **ATLITB3_0010, Module 3 High Voltage Thick Plate**

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Appendix A

Table Name:

tblChecklistVerifyHVPlatePosition

Step Check List Steps

1 Scan the "Quality Assurance Procedure for Verifying High Voltage Plate Position" Product ID barcode.

2 Check that the glue is dry and that the plate dose not move on both sides before removing the positioning ties. Enter "Done"

3 Obtain the guide bars and scan the barcode.

4 Fit the guide rods against the assembly jig in the 3 standard locations. Refer to the Verify Assembly Jig procedure. The gold frames should match the guide rods within 0.2 mm. Enter "Done".

5 Use the L square between the top edges of the base plates and the assembly jig frame plates. They should be less than 0.2 mm over 15 cm out of square. Enter "Done".

6 Check that the HV plate positioning washers are tightly bolted to the back endplate. Remove the washers on the front end. Push the module up against back washers. Enter "Done".

7 Use the straight edge and feeler gauges to ensure the surface of the HV

plate lines up with the front end plate. Enter "Done".

8 If the module HV plate separation is within the 200 micron limit at all 4 corners, and does not exceed the plate at any point, enter "Accept". Otherwise enter "Reject".

9 Enter "Save" to save the data and exit the form. Otherwise, enter "Cancel" to exit the form without saving.

QA Procedure Verify HV Plate Position Product ID Barcode



Procedure Part Number



Approvals

Name	Signature	Revision	Date
J.Callahan		B	
D.Rust		B	
C. Wang		B	