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AOS SLC BS Elliptical Baffle  
Production Plan

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**Abstract**

This document describes the plan for acquisition of parts, components, and materials needed for fabrication of six (6) BS Elliptical Baffle.

## 1 Introduction

This document describes the plan for acquisition of parts, components, and materials needed for fabrication of six (6) BS Elliptical Baffle.

### 1.1 Scope

The cost of the production plan is limited to the hardware acquisition costs of the BS Elliptical Baffles.

It does not include labor for procurement, assembly, pre-alignment, test, and installation.

## 2 Production Plan

### 2.1 Fabrication

The BS Elliptical Baffle subassemblies will be manufactured by selected machine shops.

### 2.2 Assembly and Test

The BS Elliptical Baffle sub-assemblies will be pre-assembled in a clean room, wrapped, and transported to a portable clean room near the installation site

The final installation and assembly will be done in situ on the Cartridge assembly.

## 3 Baffle Estimated Unit Cost

BS Elliptical Baffle	1250
Alignment Tooling	1500

### 3.1 Comparison with Cost Book

This is a new item and is not in the Cost Book

## 4 Procurement Plan

### July 2012

Qty 6 BS Elliptical Baffle	7500
Qty 2 Alignment Tooling	3000
Shipping	<u>600</u>

Total Cost	<b>\$11,100</b>
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