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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.

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Log of changes:

v-2

- 1) Added Fabrication, installation and test schedule



## 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.

### 2.3 Fabrication, installation and test schedule

AOS SLC BS Elliptical Baffle	Duration	Start	Finish
<b>BS Elliptical Baffle</b>	<b>30 days</b>	<b>Mon 6/18/12</b>	<b>Fri 7/27/12</b>
Procure Baffles	12 days	Mon 6/18/12	Tue 7/3/12
Procure Metal Works	15 days	Mon 6/18/12	Fri 7/6/12
Procure hardware	22 days	Mon 6/18/12	Tue 7/17/12
Procure tooling	15 days	Tue 7/3/12	Mon 7/23/12
Have parts cleaned and oxidized	10 days	Wed 7/4/12	Tue 7/17/12
ship baffle parts to Observatory	5 days	Wed 7/18/12	Tue 7/24/12
ship metal parts to Observatory	3 days	Wed 7/18/12	Fri 7/20/12
ship tooling to Observatory	3 days	Tue 7/24/12	Thu 7/26/12
Clean & Bake parts - Class A	5 days	Mon 7/23/12	Fri 7/27/12
Clean & Bake tooling - Class B	1 day	Fri 7/27/12	Fri 7/27/12
Ready for Install	0 days	Fri 7/27/12	Fri 7/27/12

L1 Installations	Duration	Start	Finish
INS L1: Finalize Cartridge, AOS Baffles (BSC2)	5 days	Tue 9/18/12	Mon 9/24/12
INS L1: Install Cartridge/CO2P & Align (BSC2)	10 days	Tue 9/25/12	Mon 10/8/12

### 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 **\$11,100**