

**LET Switching Magnets (BISM)  
Manufacturing Plan and Status**

Jack M. Jagger  
4/25/01 Revision A

**Manufacturing Plan**

**Completion Target Date**

Magnet Number One:

Assemble the magnet using the existing Coils and a new laminated core.  
Test and Measure

September 5<sup>th</sup>

Magnets two, three, four:

Assemble the magnets using new coils and new laminated cores  
Test and measure

September 12<sup>th</sup>, 21<sup>st</sup> and 27<sup>th</sup>

**Installation Plan**

Install magnets two, three, four

October Maintenance Period

Retrofit new coils in magnet one, test and measure

Circa October 19<sup>th</sup>

**Back-Up Plan:**

Any magnet can be assembled using existing coils and installed with or without magnet measurement.  
This plan would be used only if new coils were not available.

**M & S**

Description	PO/Svc. Req.	Delivery	Vendor	Cost
Laminations and Steel	1A-11307	7/20/01	Progressive Mfg.	\$59,346.00
Conductor	1A-09256	Complete	Wolverine Prod.	14,070.00
Conductor Insulation	1A-09219	4/20/01	Essex	12,099.00
Magnet Parts	R04192	6/22/01	Central Shops	36,000.00
Coil Winding Tensioner	R26567	5/18/01	Central Shops	14,000.00
Coil and Brazing Tooling	R04194	5/18/01	Central Shops	11,000.00
Coil Winding Fixtures (3)	R23739	5/23/01	Central Shops	23,000.00
Coil Potting Fixtures (2)	R04193	7/6/01	Central Shops	17,000.00
Stacking Fixture	R04194	6/29/01	Central Shops	19,500.00
			Total M&S	\$206,015.00

64,000.00 Ask Jack

Magnet water manifolds, Coil stand offs and incidentals not designed yet are included in the M&S

**Revisions**

A 1. Stacking fixture JMJ estimate was \$32,000, Total M&S was \$218,524.75