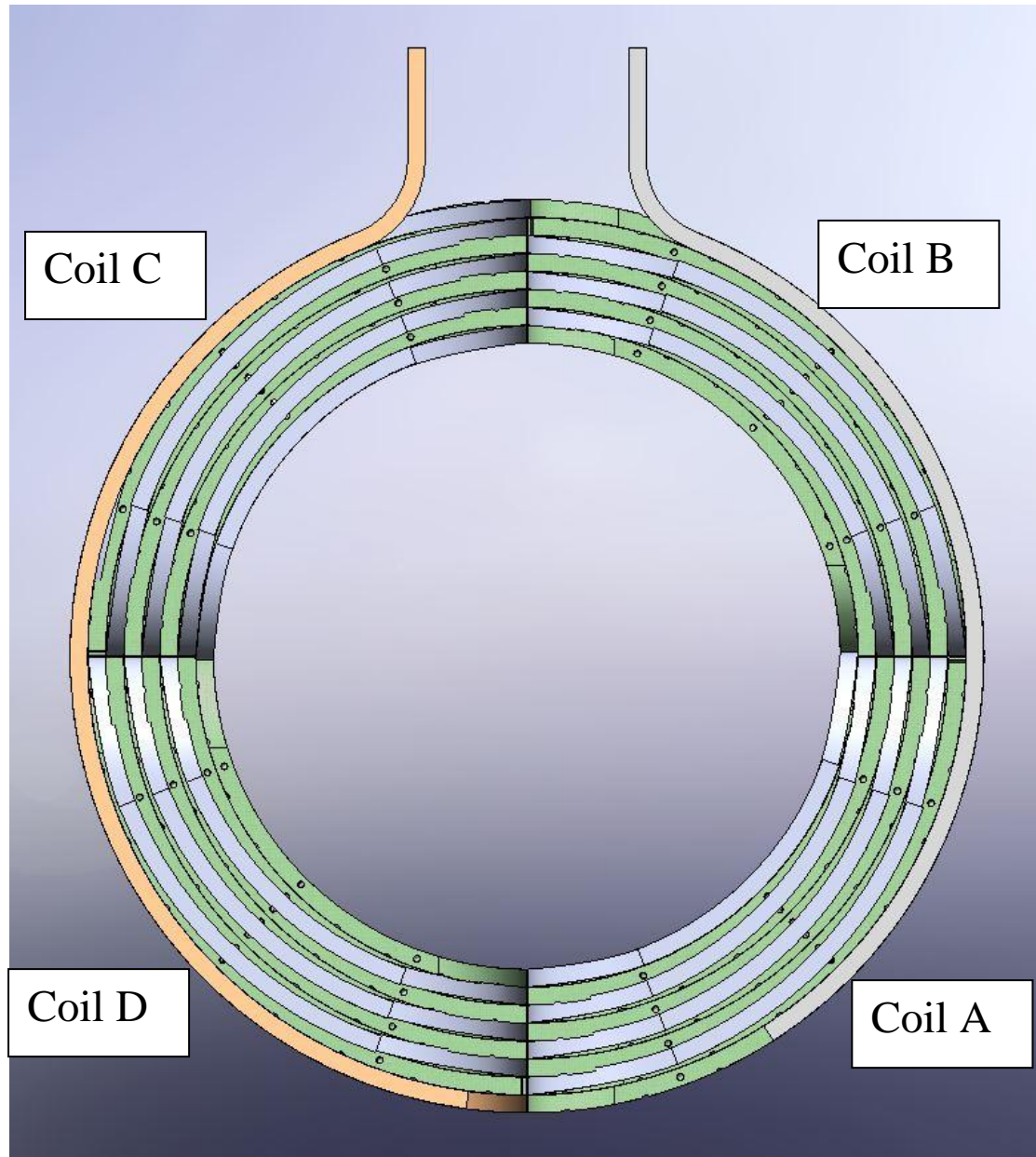


Evolutions	Date
Création	19 mai 2015



Equipment used: DLRO10

1. Before assembly moulding

Required: value after coil moulding and before connection brazing

<u>Designation</u> :	<u>Identification</u> :	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
Coil A	Serial N° : double pancake					
GD n°1 DC resistance value at 20° C (100mA)		mΩ	117	115	LB/DRA 26/05/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	131	130	LB/DRA 26/05/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	148	146	LB/DRA 26/05/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	163	162	LB/DRA 26/05/15	

<u>Designation</u> :	<u>Identification</u> :	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
Coil B	Serial N° : double pancake					
GD n°1 DC resistance value at 20° C (100mA)		mΩ	116	117	LB/DRA 26/05/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	131	131	LB/DRA 26/05/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	145	145	LB/DRA 26/05/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	161	162	LB/DRA 26/05/15	

<u>Designation</u> :	<u>Identification</u> :	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
Coil C	Serial N° : double pancake					
GD n°1 DC resistance value at 20° C (100mA)		mΩ	116	116	LB/DRA 26/05/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	131	130	LB/DRA 26/05/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	146	146	LB/DRA 26/05/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	163	162	LB/DRA 26/05/15	

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 $\Sigma\Phi$ reference : 318711
Revision : A

Designation : Coil D	Identification : Serial N° : double pancake	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
GD n°1 DC resistance value at 20° C (100mA)		mΩ	116	116	LB/DRA 26/05/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	130	130	LB/DRA 26/05/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	147	146	LB/DRA 26/05/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	163	163	LB/DRA 26/05/15	

2. After assembly moulding (before collaring)

Required: value measured before assembly moulding and after connection brazing

Designation : Coil A	Identification : Serial N° : double pancake	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
GD n°1 DC resistance value at 20° C (100mA)		mΩ	115	116	NM/PB 13/07/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	130	130	NM/PB 13/07/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	146	147	NM/PB 13/07/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	162	162	NM/PB 13/07/15	

Designation : Coil B	Identification : Serial N° : double pancake	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
GD n°1 DC resistance value at 20° C (100mA)		mΩ	117	116	NM/PB 13/07/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	131	131	NM/PB 13/07/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	145	145	NM/PB 13/07/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	162	161	NM/PB 13/07/15	

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Revision : A

<u>Designation</u> :	<u>Identification</u> :	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
Coil C	Serial N° : double pancake					
GD n°1 DC resistance value at 20° C (100mA)		mΩ	116	116	NM/PB 13/07/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	130	130	NM/PB 13/07/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	146	145	NM/PB 13/07/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	162	162	NM/PB 13/07/15	

<u>Designation</u> :	<u>Identification</u> :	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
Coil D	Serial N° : double pancake					
GD n°1 DC resistance value at 20° C (100mA)		mΩ	116	116	NM/PB 13/07/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	130	130	NM/PB 13/07/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	146	146	NM/PB 13/07/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	163	163	NM/PB 13/07/15	

<u>Designation</u> :	<u>Identification</u> :	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
Assembly (coil A, B, C and D)	Serial N° : Assembly					
Assembly DC resistance value at 20° C (10mA)		mΩ	2217	2215	NM/PB 13/07/15	

3. After collaring:

Required: value measured after assembly moulding

<u>Designation</u> :	<u>Identification</u> :	UNI	REQUIR	RESULT	Date	ACTIO
Coil A <i>Temperature 24.9°C</i>	Serial N° : double pancake	T	ED		Initial	N
GD n°1 DC resistance value at 20° C (100mA)		mΩ	116	116	YP/LB 10/08/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	130	129	YP/LB 10/08/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	147	146	YP/LB 10/08/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	162	161	YP/LB 10/08/15	

<u>Designation</u> :	<u>Identification</u> :	UNI	REQUIR	RESULT	Date	ACTIO
Coil B <i>Temperature 24.9°C</i>	Serial N° : double pancake	T	ED		Initial	N
GD n°1 DC resistance value at 20° C (100mA)		mΩ	116	116	YP/LB 10/08/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	131	131	YP/LB 10/08/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	145	145	YP/LB 10/08/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	161	161	YP/LB 10/08/15	

<u>Designation</u> :	<u>Identification</u> :	UNI	REQUIR	RESULT	Date	ACTIO
Coil C <i>Temperature 24.8°C</i>	Serial N° : double pancake	T	ED		Initial	N
GD n°1 DC resistance value at 20° C (100mA)		mΩ	116	115	YP/LB 10/08/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	130	129	YP/LB 10/08/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	145	145	YP/LB 10/08/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	162	162	YP/LB 10/08/15	

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Revision : A

<u>Designation</u> :	<u>Identification</u> :	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
Coil D Temperature 24.9°C	Serial N° : double pancake					
GD n°1 DC resistance value at 20° C (100mA)		mΩ	116	115	YP/LB 10/08/15	
GD n°2 DC resistance value at 20° C (100mA)		mΩ	130	129	YP/LB 10/08/15	
GD n°3 DC resistance value at 20° C (100mA)		mΩ	146	146	YP/LB 10/08/15	
GD n°4 DC resistance value at 20° C (100mA)		mΩ	163	162	YP/LB 10/08/15	

<u>Designation</u> :	<u>Identification</u> :	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
Assembly (coil A, B, C and D) Temperature 24.9°C	Serial N° : Assembly					
Assembly DC resistance value at 20° C (100mA)		mΩ	2215	2206 (10mA)	YP/LB 10/08/15	

<u>Designation</u> :	<u>Identification</u> :	UNI T	REQUIR ED	RESULT	Date Initial	ACTIO N
Assembly (coil A, B, C and D)	Serial N° : Assembly					
Insulation resistance during 1mn at 1500 Vdc between Assembly and the collars		Ω	≥ 1.10⁶	112 GΩ	DRA 16/09/15	
Dielectric test during 1mn at 1500Vdc between Assembly and the collars		/	OK	OK I=12.06nA	DRA 16/09/15	