

Los Alamos

Los Alamos National Laboratory
Los Alamos, New Mexico 87545

LSND memo

TO: Charles Justice, MAT-11, MS-P274
FROM: Richard Bolton *RB*
SYMBOL: MP-4
SUBJECT: RE-BID OF PURCHASE REQUEST #5448D (LSND PMT SUPPORT FRAMES)

DATE: June 16, 1992
MAIL STOP: H846
TELEPHONE: (505) 667 - 8241

After examining the bids received for the fabrication of PMT (Photo Multiplier Tube) support frames for the LSND detector at LAMPF (PR #5448D), it is clear that some misunderstanding exists as to the finish required for the frames. The frames are to be plain stainless steel that has been cleaned and degreased (as stated in specification 3.4) **without** any other surface treatment. Soap and water would be OK for cleaning and degreasing the frames. Therefore, we need to re-open the bidding with this requirement clarified. The specification MP4-92-038-V3 attached has been modified to clarify this requirements, as indicated by the change bar to the right of the affected paragraph (3.4). We would like this re-bid process to take as short a time as is practical since the required delivery date for the frames remains unchanged (Sept. 1, 1992). Please expedite this request in any way available to you.

RDB:rdb

cc: MP-4 File

Los AlamosLos Alamos National Laboratory
Los Alamos, New Mexico 87545**MP4-92-038-V3**
specification

TO: Charles Justice, MAT-11, MS-P274
FROM: Richard Bolton *RB*
SYMBOL: MP-4
SUBJECT: SPECIFICATION MP4-92-038-V3: LSND PMT SUPPORT FRAMES (PR #5448D) (REVISED)

DATE: June 16, 1992
MAIL STOP: H846
TELEPHONE: (505) 667 - 8241

1.0 GENERAL

- 1.1 These specifications shall cover the design and fabrication of *one set* of PMT (Photo Multiplier Tube) *Support Frames* (Type "A", "B", and Centering Clips) for the LSND detector at LANL (Los Alamos National Laboratory).

2.0 SCOPE OF WORK

- 2.1 The work covered by these specifications shall include the design and fabrication of the *Support Frames* for the LSND detector. Drawings of the completed design shall be submitted to LANL by the seller for review and approval prior to starting fabrication.
- 2.2 The seller shall furnish all material, labor, equipment, tools, and fixtures necessary to design and fabricate the *Support Frames*.

3.0 SUPPORT FRAME DESIGN

- 3.1 LANL shall furnish preliminary design drawings (#135Y-299041: sheets 1-4) of the *Support Frames* showing major design parameters. All detailed fabrication drawings and design calculations shall be done by the seller.

- 3.2 The number of parts required to complete *one set*:

Type "A" Frames.....	550
Type "B" Frames.....	675
Centering Clips.....	2450

No underruns will be accepted.

- 3.3 The *Support Frames* shall be fabricated from all stainless steel material (wire and flat stock) welded together, however, other fabrication methods may be proposed by the seller for evaluation by LANL. Tolerances for the dimensions given in the preliminary design drawings (#135Y-299041: sheets 1-4) are $\pm 1/16$ " unless otherwise specified. The diameter of the wire used for the frames should be 0.100 ± 0.010 ". The sheet stock used for the clamping band should be 0.009 ± 0.002 " thick. The latch shall be of stainless steel and designed so that the clamping bands *minimum* inner diameter is ≥ 8.000 " when the latch is *being operated*, while the clamping bands *maximum* inner diameter is ≤ 8.050 " when the latch is *closed*.

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MP4-92-038-V3 specification

- 3.4 The *Support Frames* shall be degreased and cleaned using soap and water. No other finish (such as passivated) is to be applied.
- 3.5 A LANL representative shall have access to the seller's plant and any subcontractor's facility during normal working hours for the purpose of inspection and design/fabrication consultation.

4.0 DRAWINGS AND DOCUMENTS

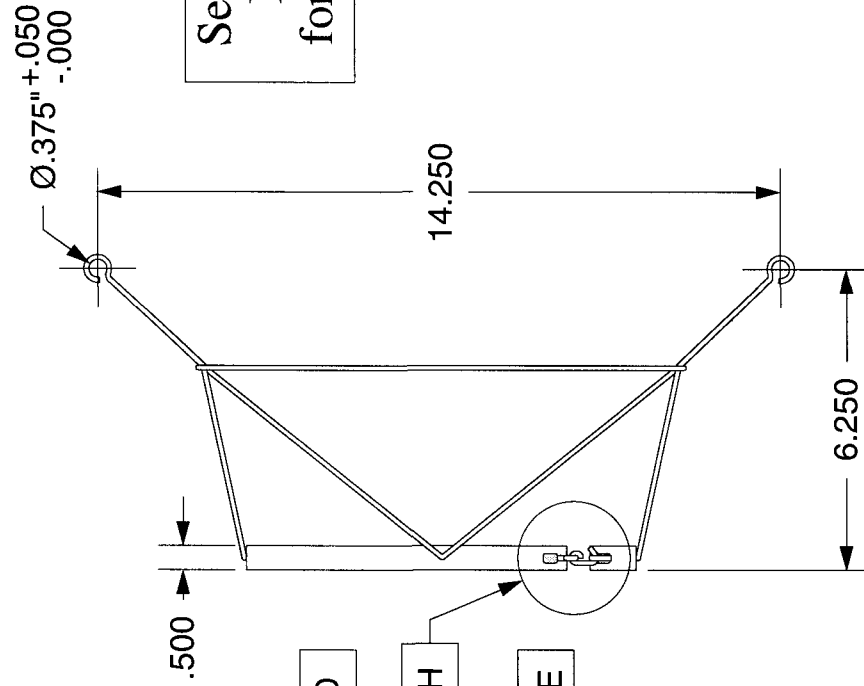
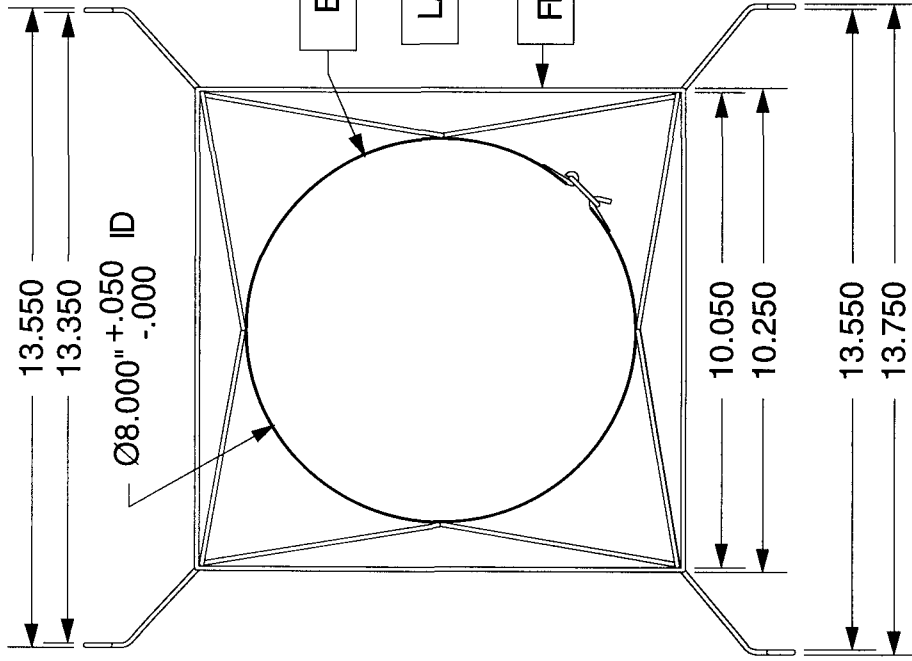
- 4.1 135Y-299041: sheet 1 - LSND PMT Support Frames (Type "A").
135Y-299041: sheet 2 - LSND PMT Support Frames (Type "B").
135Y-299041: sheet 3 - LSND PMT Support Frames (Centering Clip).
135Y-299041: sheet 4 - LSND PMT Support Frames (Typical Assembly).
- 4.2 *Deleted.*

5.0 DELIVERY SCHEDULE

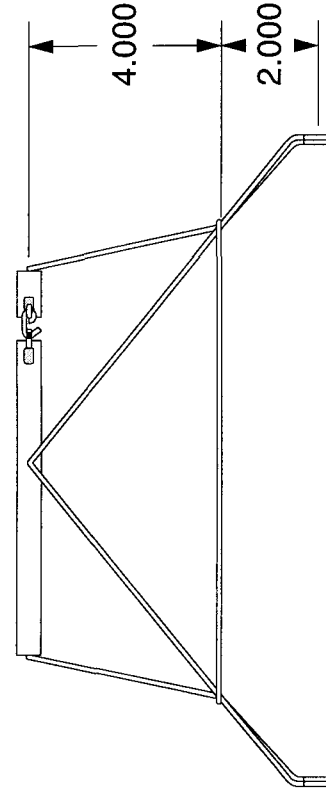
- 5.1 Seller shall be responsible for delivering the Support Frames to LANL. (FOB Destination)
- 5.2 Delivery of the *Support Frames* is to be *completed* by September 1, 1992. Partial shipments will be accepted as soon as fabrication has started.

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cc: MP-4 File



See memorandum
MP-4-92-038
for specifications.

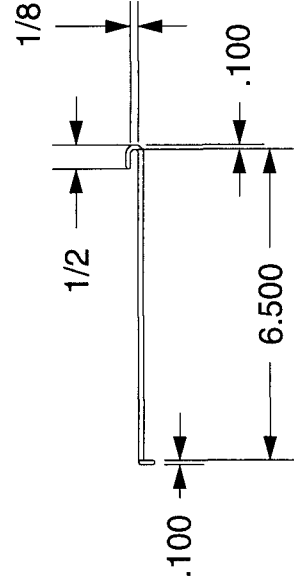
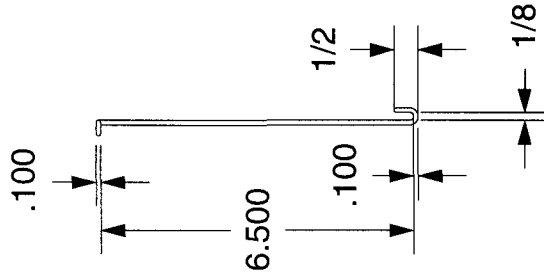
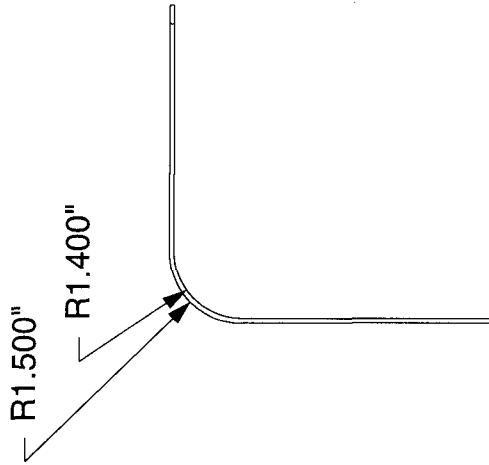


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Revision	ORIGINAL ISSUE	REVISIONS	Date	Changed By	Checked By	Approved By
Los Alamos						
Los Alamos National Laboratory						
Los Alamos, New Mexico 87545						
	NAME	DATE	GROUP	Classification of	Drawing:	UNCL
Originator	RDB	4/1/92	MP-4	Part:	UNCL	UNCL
Drawn	RDB	4/15/92	MP-4	Title:	LSND PMT	
Checked	RDB	4/20/92	MP-4	Support Frames		
			(TYPE "A")			
			Drawing No: 135Y-29904 1			
Pro. Engr.				Scale	Sheets	Sheet No:
Approved				1/4	4	A 1
Released						

A technical line drawing of a door assembly. On the left, a vertical door is shown with a handle and a lock mechanism. The door is hinged to a frame. The frame consists of a vertical post on the left and a horizontal post at the top. A diagonal brace is shown connecting the top of the vertical post to the horizontal post. The door is shown in a slightly open position, revealing the internal hinge mechanism.

15.500

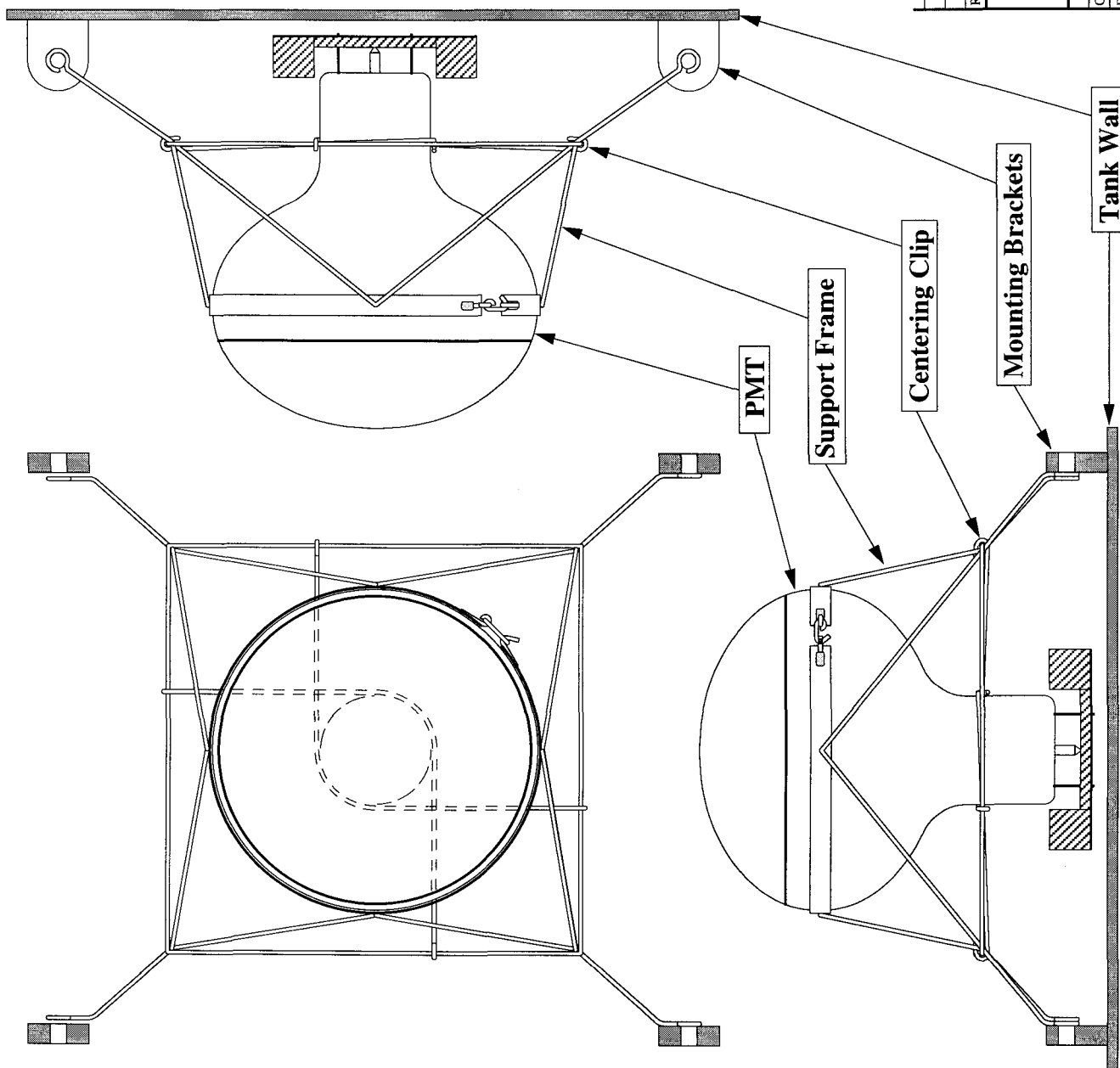
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See memorandum
MP-4-92-038
for specifications.

Revision	ORIGINAL ISSUE	REVISIONS	Date	Changed By	Checked By	Approved By
Los Alamos Los Alamos National Laboratory Los Alamos, New Mexico 87545						
Originator	RDB	4/1/92	MP-4	Classification of Drawing: UNCL		
Drawn	RDB	4/24/92	MP-4	Part: UNCL Title Block: UNCL		
Checked	RDB	4/27/92	MP-4	Title: LSND PMT		
Pro. Engr.				Support Frames		
Approved				(Centering Clip)		
Released				Drawing No: 135Y-29904 1		
Scale			1/4	Sheets		
				Size		
				A		
				Sheet No:		
				3		

See memorandum
MP-4-92-038
for specifications.



Revision	ORIGINAL ISSUE	REVISIONS	Date	Changed By	Checked By	Approved By
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Los Alamos Los Alamos National Laboratory Los Alamos, New Mexico 87545						
Originator	NAME	DATE	GROUP	Classification of Drawing: UNCL		
Drawn	FDB	4/1/92	MP-4	Part: UNCL Title Block: UNCL		
Checked	FDB	4/29/92	MP-4	Title: LSND PMT		
Pro. Engr.	FDB	4/29/92	MP-4	Support Frames		
Approved				(Typical Assembly)		
Released				Drawing No: 135Y-29904 1		
Scale			1/4	Sheets		
			4	Size		
			A	Sheet No:		
			4			