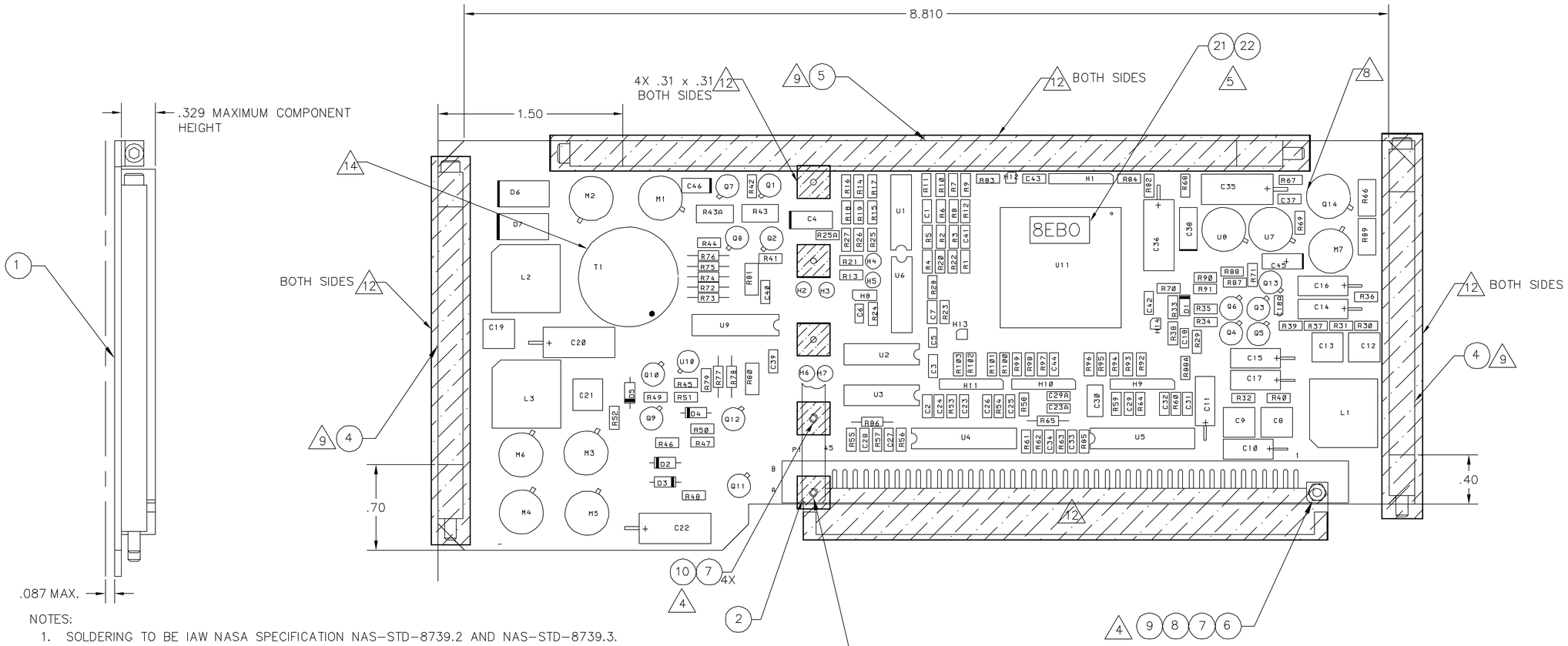
REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
30-012	A	INITIAL RELEASE (FROM 29-20200_rB)	EAB	R. FOSTER	9/3/02
30-041	B	SEPERATE LINCOLN LAB NOTES AND PARTS	EAB	R. FOSTER	3/21/03
30-071	C	AS BUILT	EAB	R. FOSTER	11/13/03
30-0	D	REDESIGN			



NOTES:

1. SOLDERING TO BE IAW NASA SPECIFICATION NAS-STD-8739.2 AND NAS-STD-8739.3.
2. TEST HEADERS ARE NOT INSTALLED.
3. VACUUM BAKE P1 (F/N 3) AT 80C FOR 72 HOURS, PRIOR TO KITTING.
4. REMOVE EXISTING HARDWARE AFTER CONFORMAL COAT. INSTALL F/N 6,7,8,9 AND 2 AS SHOWN. TORQUE #2-56UNC SCREW TO 32 IN-OZ. SPOTBOND WITH F/N 17. MIX RATIO: 4g 828V125/2g ALUMINA POWDER.
5. PLACE CHECKSUM LABEL ON U11 USING F/N 21 AND COAT WITH F/N 22.
6. SPOTBOND CORNERS OF U11 AND C10,11,14-17,20,22,35,36, D6, D7, L1-L3 AND T1 USING F/N 16 PRIOR TO CONFORMAL COAT.
7. PARTS TO RECEIVE CURSORY VISUAL INSPECTION PRIOR TO KITTING AND INSTALLATION.
8. VERIFY C37 IS NOT SHORTED TO VIA UNDERNEATH CAPACITOR.
9. EPOXY F/N 4, 5 AND 20 TO F/N 1 USING F/N 13, AFTER CONFORMAL COAT. MOUNTING DIMENSIONS SPECIFIES STARTING LOCATION FOR EPOXYING FIXED PORTION OF WEDGELOK ASSY.
10. ITEM IS STATIC SENSITIVE. HANDLE IAW MIT PROCEDURE 99-01003 OR EQUIVALENT.
11. MEASURE UNMARKED CAPACITORS PRIOR TO KITTING. BAG AND TAG.
12. MASK FOR CONFORMAL COAT AS INDICATED. PRIOR TO SHIPMENT FOR CONFORMAL COAT; CLEAN, INSPECT AND AIR BAKE FOR 1 HOUR AT 65° C. BAG AND SEAL.
13. CONFORMAL COAT ASSEMBLY WITH F/N 14.
    - CURE AT 25C, AMBIENT PRESSURE FOR 8 HOURS.
    - REMOVE MASKING AND MASKING RESIDUE PRIOR TO VACUUM BAKE.
    - VACUUM BAKE AT 65C, 10^{-5} TORR FOR 24 HOURS.
14. TORQUE F/N 19 TO 80 IN OZ AND SPOTBOND WITH F/N 17.

30-20000	ASTRO-E2
NEXT ASSEMBLY	USED ON
APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCE: ANGLES +/- 1°
3 PLACE DECIMALS +/- .005
2 PLACE DECIMALS +/- .01

MATERIAL N/A
FINISH N/A

	NAME	DATE
DRAWN	M. SMITH	1/29/02
CHECKED	EAB	8/29/02
APPROVED	R. FOSTER	9/3/02
RELEASED	D. GAGE	9/3/02
CAD FILE		

Massachusetts Institute ofTechnology
Center for Space Research
ASTRO-*E2*

CCA, THERMAL CONTROL

SIZE	FSCM NO.	DWG NO.	REV
D	80230	30-20200	D

SCALE 1:1 SHEET 1 OF 1