UPON INTEGRATION.

- Torque #2-56 hardware to 48 in-OZ. Do not spot bond.
- Install F/N 13 and 18 during storage and remove F/N 17, 13 and 18 during test and upon integration.

- Torque 4-40 hardware to 5 in-LBS. Spot bond using F/N 14.
- Torque #2-56 hardware to 48 in-OZ. Do not spot bond.
- Torque 6-32 hardware to 25 in-LBS. Spot bond using F/N 14.

- Remove top cover and retain hardware. Reinstall after final assembly.
- Torque hardware to 48 in-OZ after final acceptance testing. Spot bond using F/N 14.
- Feed connector from F/N 1 through opening in F/N 2. Secure F/N 1 to F/N 2 using F/Ns 3, 4, and 13. Ensure F/N 16 is in between F/Ns 1 and 2 prior to assembly.
- Mate c'connector from F/N 1 to the analog board in F/N 2 and secure with hardware shown. Secure cable to the existing cable block using F/N 10.

- Secure cable to the existing cable block using F/N 10.
- Connect F/N'S 3, 4, and 15. Ensure F/N 16 is in between F/N'S 1 and 2 prior to assembly.

- Torque nut from F/N 11 to 35 in-LBS. Spot bond using F/N 14.
- Install F/N 13 and 18 during storage and shipping. Remove F/N 17, 13 and 18 during test and upon integration.

- Cut F/N 12 to fit. Torque swagelok fitting on F/N 12 to ___ in-LBS. Spot bond both ends.

- Check electrical isolation between F/N 1 and 2 for resistance greater than 1 Megohm.