

**ACIS Verification Summary Report**

<b>Specification:</b>	ACIS Contract End Item Specification
<b>Requirement Number/Title:</b>	3.3.3.1.2.4 Soldering (VRSD 3.3.3.1.2.4)
<b>Requirement Statement:</b> Soldering shall be in accordance with MIT Product Assurance and Safety plan, Section 1, Paragraph 6.0 - 6.0.3.	
<b>Verification Method:</b>	Inspection and Validation of Records
<b>Procedure Number:</b>	
<b>Configuration:</b>	
<b>Cycle Time:</b>	
<b>Verification Discussion/Results:</b>	
<p>Soldering at MIT is in strict conformance with NHB 5300.4 (3A-1). Operators and Inspectors are fully trained and certified to the NHB. The NASA soldering requirement is imposed through the assembly drawings and Assembly Work Orders (AWOs)(travelers). After fabrication, the AWO is reviewed to insure that all process and inspection steps were completed and signed by the responsible person. In-process and final inspections confirm the implementation of soldering in accordance with NHB 5300.4 (3A-1).</p> <p>Soldering at Lockheed Martin Astronautics (LMA) is done in accordance with LMA in-house procedures. These procedures were submitted to MSFC as MIT waiver 36-002. The LMA procedures were reviewed by MSFC and approved on 1/30/96. Operators and Inspectors are fully trained and certified to the LMA procedures. The LMA soldering requirement is imposed through the assembly travelers. After fabrication, the traveler is reviewed to insure that all process and inspection steps were completed and signed by the responsible person. In-process and final inspections confirm the implementation of soldering in accordance with the LMA procedure.</p>	

*Brian Klatt*  
ACIS Cognizant Engineer

*5/13/97*  
Date

36-01510.140

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ACIS Contract End Item Specification

**Requirement Number/Title:**

3.3.3.1.2.4 Soldering (VRSD 3.3.3.1.2.4)

**Requirement Statement:** Soldering shall be in accordance with MIT Product Assurance and Safety plan, Section 1, Paragraph 6.0 - 6.0.3.**Verification Method:**

Inspection and Validation of Records

**Procedure Number:****Configuration:****Cycle Time:****Verification Discussion/Results:**

Soldering at MIT was done in strict conformance with NHB 5300.4 (3A-1). Operators and Inspectors were fully trained and certified to the NHB. The NASA soldering requirement was imposed through the assembly drawings and Assembly Work Orders (AWOs)(travelers). After fabrication, the AWO was reviewed to insure that all process and inspection steps were completed and signed by the responsible person. In-process and final inspections by MIT and the NASA representative confirmed the implementation of soldering in accordance with NHB 5300.4 (3A-1).

Soldering at Lockheed Martin Astronautics (LMA) was done in accordance with LMA in-house procedures. These procedures were submitted to MSFC as MIT waiver 36-002. The LMA procedures were reviewed by MSFC and approved on 1/30/96. Operators and Inspectors were fully trained and certified to the LMA procedures. The LMA soldering requirement was imposed through the assembly travelers. After fabrication, the traveler was reviewed to insure that all process and inspection steps were completed and signed by the responsible person. In-process and final inspections by LMA and DPRO confirmed the implementation of soldering in accordance with the LMA procedure.

*Brian Klatt*  
ACIS Cognizant Engineer

*7/23/97*  
Date