

## CRaTER As-Built Materials and Processes

ITEM	DESCRIPTION	MFGR.	PART #	QUALIFICATION	Next higher level Assembly	AMOUNT	MATERIAL PREP.
1	CopperTape	3M	#1181	GSFC Material Selection Guide	32-10200	16 Sq.in.	Vacuum Bake@60C
2	KaptonTape-Acrylic adhesive	CHR	K 102	GSFC Material Selection Guide	32-10200	10 Sq.in.	Flight testing
3	Conformal Coating	Conap	CE 1155	GSFC Material Selection Guide	32-10200 32-10202	120 Sq. In, .001 In. Thick	Vacuum Bake @ 60°C
4	Conformal Coating Thinner	Cytec	S-8	GSFC Material Selection Guide	32-10202	2 grams	Vacuum Bake@60C
5	Epoxy-structural	Hysol	EA-9394	GSFC Material Selection Guide	32-10200 32-10202 32-10000	20 grams	Flight testing
6	Epoxy	Hysol	EA-9313	GSFC Material Selection Guide	32-10200 32-10202	3 grams	Vacuum Bake@60C
7	Epoxy-structural	Hysol	EA934NA	GSFC Material Selection Guide	32-10000 32-10100 32-10200	5 grams	Flight testing and Vacuum Bake@60C
8	Epoxy-Urethane	Huntsman	Arathane 5753 A/B (LV)	GSFC Material Selection Guide	32-10200 32-10202	10 grams	Flight testing and Vacuum Bake@60C
9	Bondable Terminal	Micro-measurement	CPF-60D (Polyimide)	GSFC Material Selection Guide	32-10200	1 Sq.in.	Vacuum Bake@60C
10	Cable Clamp	TA Mfg.	TA552TD03 (Teflon)	GSFC Material Selection Guide	32-10200	6 each	Vacuum Bake@60C
11	Tefzel wire tie	Panduit	PLT1M-C76	GSFC Material Selection Guide	32-10200	20 each	Vacuum Bake@60C
12	Tefzel Wire Tie mount	Panduit	TM 3S8 -C76	GSFC Material Selection Guide	32-10200	2 each	Vacuum Bake@60C

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13	Printed Ckt. Board	Speedy Circuit	Polyimide	GSFC Material Selection Guide	32-10202 32-10201	100 Sq. In, .062 In. Thick	Vacuum Bake @ 80°C
14	Shrink Tubing	Raychem	RNF-100 (Kynar)	GSFC Material Selection Guide	32-10200	10 inches	Flight testing
15	Tissue Equivalent Plastic (TEP)	Standard Imaging Inc.	A150	Tested by GSFC	32-10100	22.55 Cu. In. 0.225 lbs.	90C bake, 24 Hrs, -5 Torr
16	Torlon Spacers				32-10200	3 each	Vacuum Bake@60C
17	Teflon Tube,Vent	McMaster-Carr			32-10200	10 inches	Vacuum Bake@60C
18	G-10 Buttons and Spacers	GSFC		GSFC Material Selection Guide	32-10000	7 each	Vacuum Bake@60C
19	Teflon Block - A to D Cable Clamp				32-10200	1 each	Vacuum Bake@60C
20	Label	P-Touch	TZ-211		32-10200	<1 Sq.in.	Cover with EA9313.Bake @80C
21	FR4, .010" Sheet			GSFC Material Selection Guide	32-10200	<1 Sq.in.	Flight testing
22	Aluminum Oxide Powder (Spot Bond Additive)	Goodfellow	AL606010/20		32-10200 32-10202	10 grams	Flight testing
23	Aluminum 6061-T6	Alcoa/ Reynolds		GSFC Material Selection Guide	32-10100 32-10200	6.1 lbs.	

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ITEM	DESCRIPTION	MFGR.	PART #	QUALIFICATION	Next higher level Assembly	AMOUNT	MATERIAL PREP.
24	18-8 Stainless Steel	Talley Metals		MSFC-SPEC-522	32-10100	0.02	
25	302 Stainless Steel	Talley Metals		MSFC-SPEC-522	32-10100	0.005	
26	G-10	Atlas Fiber			32-10100	0.023	
27	Silicone Adhesive, Low Vapor Pressure	Dow Corning	6-1104 Silastic	Outgassing Section C GSFC	32-10100	0.02	
28	Urethane	Huntsman	Arathane 5753 A/B (LV)	Outgassing Section C GSFC	32-10100	0.01	
29	Urethane	Huntsman	Arathane 5750 A/B (LV)	Outgassing Section C GSFC	32-10100	0.01	
30	Urethane	Huntsman	Ultralane 5750 A/B Thinner	Outgassing Section C GSFC	32-10100	0.01	
31	Polyimide HTE/Glass	Circuit Express	MIL-P-13949/10B	GSFC Material Selection Guide	32-10100	0.149	
32	Epoxy	3M	2216 B/A Gray	Outgassing Section C GSFC	32-10100	0.01	
33	Shrink tube	Flexite	7505 HA150C-VWI	GSFC Material Selection Guide	32-10100	0.01	
34	Shrink tube	Chomerics	CHO-Sh R Tube: 70-21-0003-0004	GSFC Material Selection Guide	32-10100	0.01	
35	Lacing Tape	Gudebrod	DPT-H Scoured Dacron	GSFC Material Selection Guide	32-10100	0.01	
36	Sn63/Tn37 Stick Solder	Kester	Ultrapure Sn63	QQ-S-571	32-10100	0.05	
37	Solder, Sn63Pb37 RMA	Kester	282 SN63	QQ-S-571	32-10100	0.05	
38	Flux RMA	Kester	RMA Flux 186	MIL-F-14256D	32-10100	0.04	
39	Wire/Insulation	Judd Wire	SW8000SPA	GSFC Material Selection Guide	32-10100	0.1	
40	Kapton Tape	Mystik Tape	7367 Kapton/Acrylic ADH/F	GSFC Material Selection Guide	32-10100	0.01	
41	CRES	QPL	NAS 1351	FFS 86	32-10200		

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ITEM	DESCRIPTION	MFGR.	PART #	QUALIFICATION	Next higher level Assembly	AMOUNT	MATERIAL PREP.
42	Multilayer Insulation (MLI)	GSFC					
43	CRES 1818	Swagelock	SS-400-61		32-10200	0.25	
44	Alodine conversion coating		MIL-C-5541 Class 3	MIL-C-5541 Class 3	32-10100 32-10200	All Aluminum Surfaces	