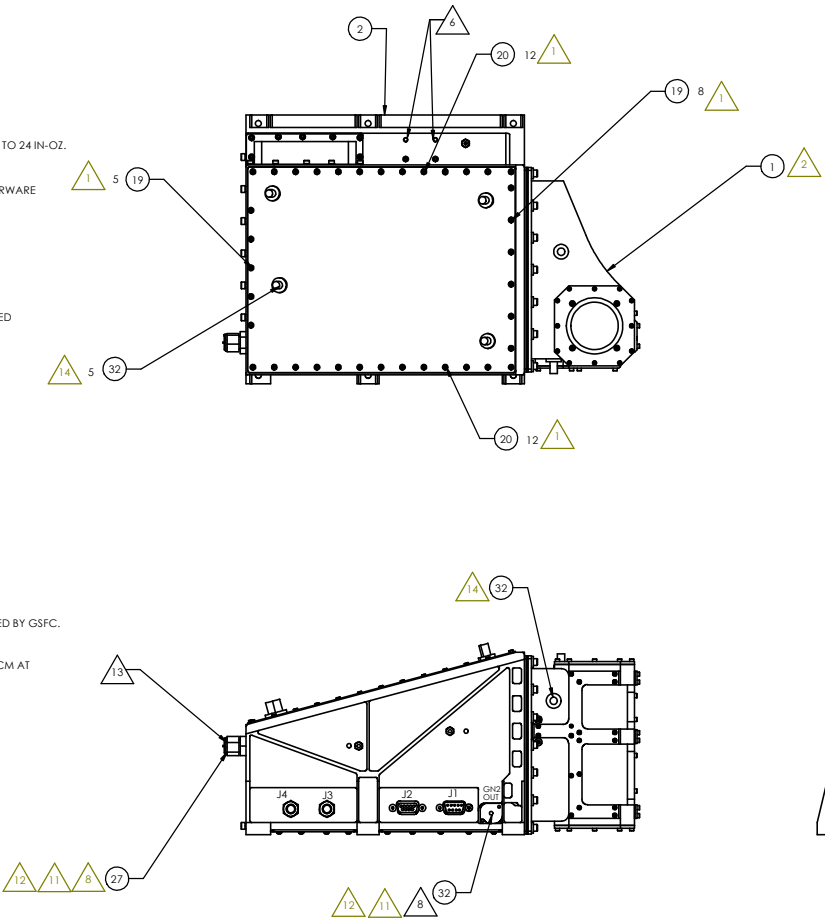
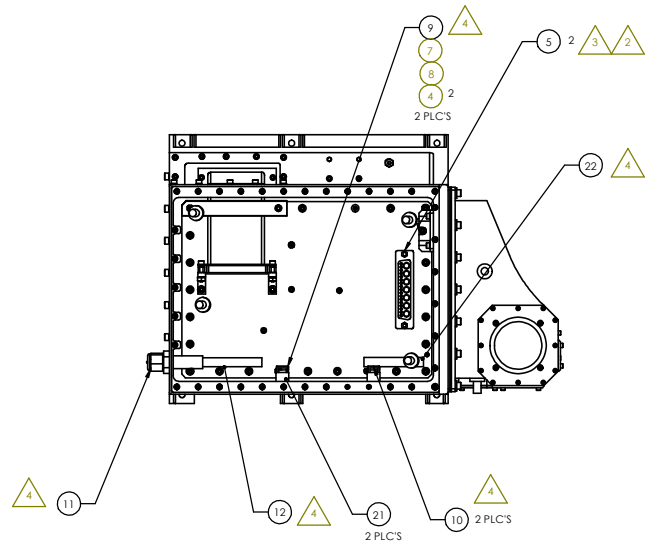


- 1 REMOVE TOP COVER TO INSTALL F/N 1. PRIOR TO VIB TESTING AND SHIPPING REINSTALL TOP COVER USING HARDWARE SHOWN. TORQUE TO 54 IN-OZ. SPOT BOND USING F/N 14 PRIOR TO SHIPPING.
- 2 VERIFY THE ANALOG BOARD, REF F/N 32, AND THE TELESCOPE ASSEMBLY, F/N 1 ARE A MATCHED SET PRIOR TO INSTALLING, TELESCOPE, F/N 1.
- 3 TORQUE TO 5 IN-LBS AND SPOT BOND USING F/N 24.
- 4 INSTALL PURGE TUBE ASSEMBLY AFTER F/N 1 IS INSTALLED TO F/N 2, PER THE FOLLING SEQUENCE OF STEPS:
  1. INSTALL F/N 11 WITH THE LONGER THREADED SECTION INSIDE THE HOUSING.
  2. INSTALL AND TIGHTEN NUT. TORQUE TO 75 IN-LBS. SPOT BOND USING F/N 14.
  3. INSTALL ITEMS 21 AND 9 USING HARDWARE SHOWN. ALIGN SO THAT THE ALUMINUM BLOCK AND THE WRAP BLOCK ARE VERTICAL. TORQUE HARDWARE TO 5 IN-LBS AND SPOT BOND USING F/N 14.
  4. INSTALL SWAGelok NUT FROM F/N 12 INTO F/N 11. HAND TIGHTEN THEN TIGHTEN WITH A WRENCH 1/2 TURN. SPOT BOND WITH F/N 14.
  5. ROUTE TUBING ONTO CABLE TIE BLOCKS AND SECURE WITH F/N 10, 2 PLACES.
  6. SLIDE CABLE CLAMP SUPPLIED WITH THE TELESCOPE ASSEMBLY OVER TEFLON TUBING. FIT TEFLON TUBING INTO THE NIPPLE ON THE TELESCOPE ASSEMBLY (TRIM TO FIT AS NECESSARY). REPOSITION CABLE CLAMP OVER THE NIPPLE AND TORQUE TO 24 IN-OZ. SPOTBOND USING F/N 14.
- 5 ROUTE CABLE FROM F/N 1 TELESCOPE THRU OPENING IN HOUSING AND INSTALL CABLE CLAMP, F/N 13. SECURE F/N 13 WITH HARWARE SHOWN. TORQUE TO 5 IN-LBS AND SPOTBOND USING F/N 14.
- 6 GROUNDING LOCATION FOR THERMAL BLANKETS. # 4-40 INSERT.
- 7 GROUND LOCATION FOR ESD WRIST STRAP OR BANNANA JACK GROUND WIRE.
- 8 REMOVE SWAGelok VENT CAP F/N 27 AND DUST COVER F/N 33. PRIOR TO PURGEING THE SYSTEM. AFTER TELESCOPE IS INSTALLED PURGE ASSEMBLY FOR 10 MINUTES AT 10 PSI. WEEKLY. REINSTALL VENT CAP AND DUST COVER AFTER PURGE.
- 9 TORQUE #6-32 SHCS, TO 19 IN-LBS. SPOTBOND USING F/N 14.
- 10 ENSURE COVER IS INSTALLED FOR VIBE TEST. PRIOR TO VIBE TEST AND SHIPPING ENSURE HARDWARE IS TORQUED TO 48 IN-OZ.
- 11 VENT CAP, F/N 27, AND DUST COVER ARE TO BE REMOVED UPON INSTALLATION OF ASSEMBLY ONTO THE SPACECRAFT AN PRIOR TO INSTALLATION OF THERMAL BLANKET.
- 12 REMOVE F/N 27 AND 32 PRIOR TO VIBRATION TESTING. REINSTALL FOR TRANSPORTING TO AND FROM SHAKE FACILITY.
- 13 REMOVE F/N 27 AND 32 PRIOR TO THERMAL VACUUM TESTING. INSTALL FILTERED END CAP, F/N 34 ONTO PURGE TUBE FOR THERMAL VACUUM.
- 14 BOND F/N 35 PER GSFC. MATERIALS PROCSESSING DOCUMENT, S-313-015. . LOCATE PER GSFC TEMPLATE OR DRAWING SUPPLIED BY GSFC.
- 15 ASSEMBLY IS TO BE VISIBLY CLEAN AND VACUUM BAKED AT 60 C. FOR 7 DAYS. IF APPLICABLE VERIFY CLEANLINES USING TQCM AT A RATE AND TEMPERATURE DEFINED IN THE CONTAMINATION CONTROL PLAN.

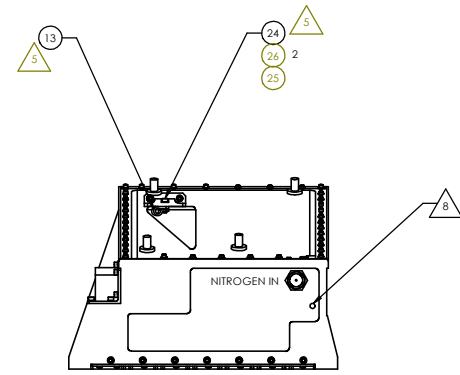
REVISES				
ECD	REV.	DESCRIPTION	DATE	APPROVED
	01	INITIAL RELEASE		
32-208	02	REDRAW AND RELEASE		
32-222	03	ADD NOTES 12,14. ADD F/N'S 32,34.	JUNE 8, 2007	



UNLESS OTHERWISE SPECIFIED:		NAME	DATE	MIT/BU CRATER PROJECT	
DESIGNED BY	SCALE	DESIGN		TITLE:	
CHECKED BY	DATE	CHECKED		Crater ASSEMBLY	
APPROVED BY	DATE	ENG APPR.		SIZE DWG. NO.	
DESIGNED BY	DATE	ENG APPR.		D 32-10000	
DESIGNED BY	DATE	ENG APPR.		REV	
DESIGNED BY	DATE	ENG APPR.		03	
DESIGNED BY	DATE	ENG APPR.		SCALE: 1:2 (WEIGHT)	
DESIGNED BY	DATE	ENG APPR.		SHEET 1 OF 2	



TOP VIEW  
TOP COVER REMOVED FOR CLARITY



REAR VIEW  
TOP COVER REMOVED FOR CLARITY

DRAWN	NAME	DATE	MIT/BU CRATER PROJECT	
CHECKED			TITLE: CrATER ASSEMBLY	
ENG APPR				
ASST APPR				
D.A.				
COMMENTS:				
	SIZE	DWG. NO.	REV	
	D32-10000	r0303		
	SCALE: 1:4	WEIGHT:	SHEET 2 OF 2	

D 30-10000.rvt 100