

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(32-10201), THE TELESCOPE PCB ASSEMBLY (32-10102), AND THE TELESCOPE ASSEMBLY. F/N1 ARE A MATCHED SET PRIOR TO INSTALLING, TELESCOPE, ASSEMBLY F/N 1.

3 TORQUE TO 48 IN-OZ AND SPOT BOND USING F/N 14.

4 INSTALL PURGE TUBE ASSEMBLY AFTER F/N 1 IS INSTALLED TO F/N 2, PER THE FOLLOWING 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 QNTO 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 GROUNDING LOCATION FOR ESD WRIST STRAP OR BANNANA JACK GROUND WIRE.

8. PURGE ASSEMBLY FOR 10 MINUTES AT 10 PSI, WEEKLY. REINSTALL SWAGELOK END CAP AFTER PURGE.

9 TORQUE #6-32 SHCS, TO 16-19 IN-LBS. SPOTBOND USING F/N 14.

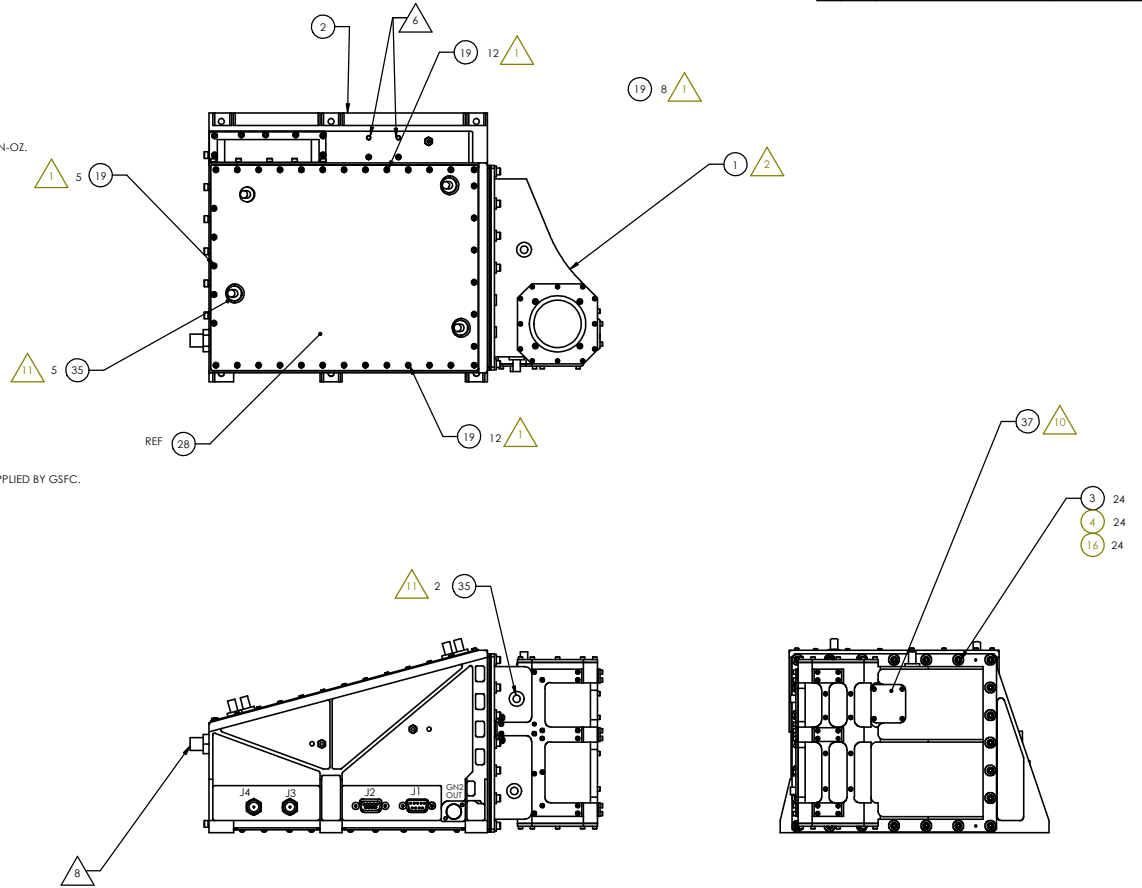
10 ENSURE COVER, F/N 37, IS INSTALLED FOR VIBE TEST. PRIOR TO VIBE TEST AND SHIPPING ENSURE HARDWARE IS TORQUED TO 48 IN-OZ.

11 BOND F/N 35 USING F/N 36 PER GSFC, MATERIALS PROCESSING DOCUMENT, S-313-015. LOCATE PER GSFC TEMPLATE OR DRAWING SUPPLIED BY GSFC.

12. ASSEMBLY IS TO BE VISIBLY CLEAN AND VACUUM BAKED AT +40 C, FOR 48 HOURS.

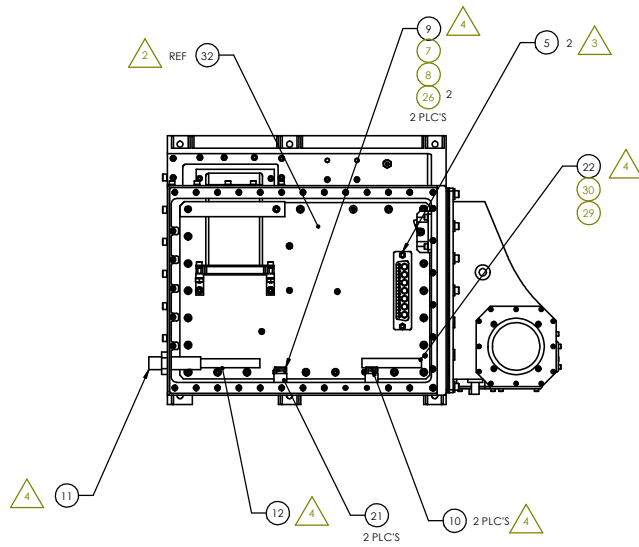
13. TORQUE HARDWARE ON THE TELESCOPE ASSEMBLY PER THE FOLLOWING:
 0-80 HARDWARE TO 1.3 IN-LBS
 2-56 HARDWARE TO 56 IN-OZ.
 4-40 HARDWARE TO 8 IN-LBS.
 6-32 HARDWARE TO 15 IN-LBS.
 SPOTBOND USING F/N 14.

REVISONS				
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	
32-242	A	RELEASE FROM BUILD	DEC 12, 07	

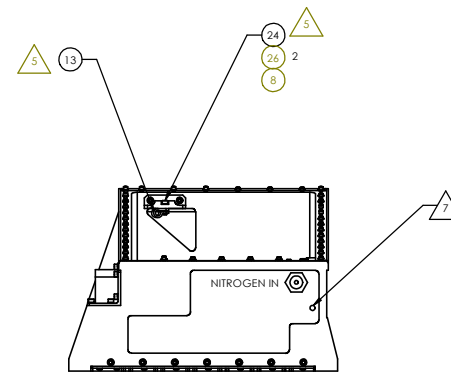


UNLESS OTHERWISE SPECIFIED:		NAME	DATE	MIT/BU CRATER PROJECT	
DESIGNED BY	INCHES	DESIGN	REV	TITLE:	
TOLERANCES	FRACTIONS	CHECKED		Crater ASSEMBLY	
ANGULAR DIMS	DECIMALS	ENG APPR			
HOLE POSITION		ENG APPR			
UNLESS OTHERWISE SPECIFIED:		D.W.			
UNLESS OTHERWISE SPECIFIED:		COMMENTS:			
DATE					
APPROVED					
DATE					
SCALE: 1:2	WEIGHT:				

SIZE DWG. NO. REV
D 32-10000 A
 SCALE: 1:2 WEIGHT: SHEET 1 OF 2



TOP VIEW
TOP COVER REMOVED FOR CLARITY



REAR VIEW
TOP COVER REMOVED FOR CLARITY

NAME	DATE	MIT/BU CRATER PROJECT
DESIGN	01/01/14	1/2014
CHECKED		TITLE:
ENG APPR		CRATER ASSEMBLY
ASST APPR		
D.A.		
COMMENT:		
SIZE	DWG. NO.	REV
D	32-10000	A
SCALE: 1:4	WEIGHT:	SHEET 2 OF 2

32-10000-1A