P0183 Version: A Author: B. Muhlfelder Drawing number #23550 Date: 3/22/99

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be used

P0183 Procedure for epoxying readout cable clip and short carrier to heater assy. and for epoxying grt to either a long or short carrier

Document Revision Record

Rev	Date	ECO#	Pages Affected	Description
A	3/22/99	966	all	revise
				procedure
-	3/5/99	NA	NA	new procedure

Note: This part is not ESD sensitive.

Authorized Personnel: M. Bogan, B. Melendez, D. Bardas

Authority to Redline: B. Muhlfelder

Assembly procedure for 23550-101.

Materials & Supplies

- 1. heater assy 23529-101
- 2. clip, thermal ground, on-off 25145-101
- 3. carrier instrumentation, short 22737-101
- 4. adhesive tra-bond 2115

Operator

QA

date

date

1. Preparation 1.1 Record serial number for heater to be used for pins #1 and #2 (heater 1): for pins #3 and #4(heater 2): Record probe C connector ID	Record serial number for heater to
RE date	
 1.2 Prepare trabond epoxy by mixing the 2 halves of the packet together. 1.3 Insert heater 1 into the carrier. Apply epoxy. 1.4 Insert heater 2 into the thermal on-off clip. Apply epoxy. 1.5 Apply drop of epoxy to back nut of lemo connector to prevent loosening of connector. 1.6 Wait a minimum of 12 hours for the epoxy to cure. 	
Operator date	
2. Bag and Tag2.1 Label bag with heater serial numbers and Probe C connector ID.	
2.2 Place assembly into bag.	

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Assembly procedure for 23179-202

Materials & Supplies 1. grt sub-assy 23180-101 2. carrier short 22737-101
3. adhesive tra-bond 2115
 Preparation Record serial number for grt Record probe C connector ID
RE date
1.2 Prepare trabond epoxy by mixing the 2 halves of the packet together.1.3 Insert grt into the carrier. Apply epoxy.1.4 Apply drop of epoxy to back nut of lemo connector to prevent loosening of connector.1.5 Wait a minimum of 12 hours for the epoxy to cure.
Operator date
2. Bag and Tag2.1 Label bag with grt serial number and Probe C connector ID.2.2 Place assembly into bag.
Operator date
QA date
Assembly procedure for 23179-203
Materials & Supplies 1. grt sub-assy 23180-102 2. carrier short 22737-101 3. adhesive tra-bond 2115
 Preparation Record serial number for grt Record probe C connector ID
RE date
1.2 Prepare trabond epoxy by mixing the 2 halves of the packet together.
1.3 Insert grt into the carrier. Apply epoxy.1.4 Apply drop of epoxy to back nut of lemo connector to prevent loosening of connector.1.5 Wait a minimum of 12 hours for the epoxy to cure.
Operator date

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2. Bag and Tag 2.1 Label bag wi 2.2 Place assemb	th grt serial number and Probe	C connector ID.	
Operator	date		
Assembly pro	ocedure for 23179-201		
Materials & Suj	pplies		
1. grt sub-assy 23			
 carrier long 2 adhesive tra-b 			
3. adiiesive tra-b	onu 2113		
 Preparation Record serial 	number for grt	Record probe C connector l	ID
RE date			
1.3 Insert grt into 1.4 Apply drop o	ond epoxy by mixing the 2 halvo the carrier. Apply epoxy. of epoxy to back nut of lemo con num of 12 hours for the epoxy	nnector to prevent loosening of co	onnector.
Operator	date		
2. Bag and Tag 2.1 Label bag wi	th grt serial number and Probe	C connector ID.	
2.2 Place assemb	oly into bag.		
Operator	date		
QA	date		
Assembly pro	ocedure for 23532-103.		
Materials & Suj	pplies		
1. SD sub-assy 2 2. Carrier 22737 3. Epoxy, Tra bo	-101		
 Preparation Record serial 	number for SD:	Record probe C connector II	Ds
RE date			

1.2 Prepare trabond epoxy by mixing the 2 halves of the packet together.1.3 Place SD inside of carrier. Apply epoxy.

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1.4 Wait a mi	nimum of 12 hours for the epoxy to	o cure.			
Operator	date				
1					
2. Bag and T	ag with SD serial number and Probe	C composter IDs			
2.1 Lauer bag	with SD serial number and Frobe	C connector IDs.			
2.2 Place asse	embly into bag.				
Operator	date				
QA	date				
Accombly r	procedure for 23532-101.				
Materials &					
1. SD sub-ass					
2. Carrier 223					
3. Epoxy, Tra	bond 2115				
1 D 4					
1. Preparati	on rial number for SD #1:	Pagerd sarial number for	SD#2:		Pacard proba C connector
ID		Record serial number for	3D#2		Record probe C connector
10	_ ∙				
	_				
RE date					
1.2 Prepare tr	abond epoxy by mixing the 2 halve	es of the packet together			
	s inside of carriers. Apply epoxy.	es of the packet together.			
	nimum of 12 hours for the epoxy to	o cure.			
	1.				
Operator	date				
2. Bag and T					
2.1 Label bag	with SD serial numbers and Probe	e C connector IDs.			
2.2 Place asse	embly into bag.				
2.2 1 face asse	mory mo oag.				
					
Operator	date				
QA	date				
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