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Gravity Probe B Relativity Mission

**PROCEDURE FOR MODIFICATION
OF
CONNECTOR**

GP-B P0414 Rev. A

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Date

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Date

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Date

Overview:

This procedure covers a modification to the connector used in assembly 25671-201 and 202. Both ears of the connector are tapped #4-40.

Materials:

Non-magnetic tap #4-40, ethlcohol and a non-magnetic #4-40 screw.

Qualified Operators:

Marge Bogen or Howard Demroff

Procedure for Adding Threads to Connector:

Record connector lot number or PO number _____

Record number of connectors to process _____

1. Use a miniature drill press, model 101T serial 51422H.
2. Insert a #4-40 non-magnetic tap in the drill press and tighten down.
3. Use a vice to hole the connector in place.
4. Place the vice under the tap and tap both through holes with the #4-40 tap. Use ethyl alcohol (200 Proof) while taping the holes. Use your fingers to turn the drill. Next chamfer the tapped hole to leave a clean edge.
5. Remove residual material with Ethyl Alcohol and run a non-magnetic #4-40 screw through each hole to check threads.
6. Use clean room gloves and clean the connector with Ethyl Alcohol use Q-tips to clean the holes, wipe the connector with ethyl alcohol and ultrasonic for 10 minutes.
7. Package connector for magnetic inspection and cleaning.

Operator _____

Date _____