CAL Document Change Notification

DCN No. 7650-DCN- 002

CHANGE TITLE: Correction Of Symmetry Tolerance On Top Frame Side Panel Interface

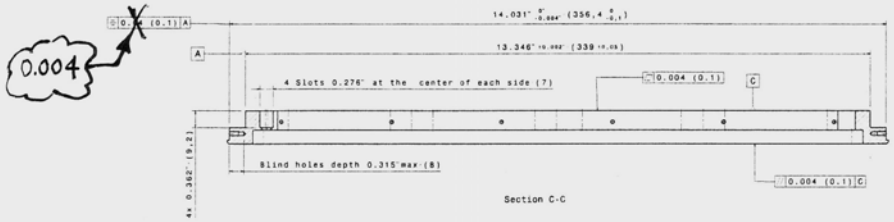
☒ Internal ☐ External

ORIGINATOR: Paul Dizon **DATE:** 2-Feb-04 **NEXT ASSY:** LAT-DS-00916

DOC or DWG NUMBER	TITLE	AFFECTED REV.	NEW REV.
LAT-DS-00917	Top Frame	7	8

CHANGE DESCRIPTION:

1. Correct symmetry tolerance from .04 inch to .004 inch in Zone L-4



REASON FOR CHANGE:

Changes required to reflect actual intent of design

DISPOSITION OF HARDWARE:

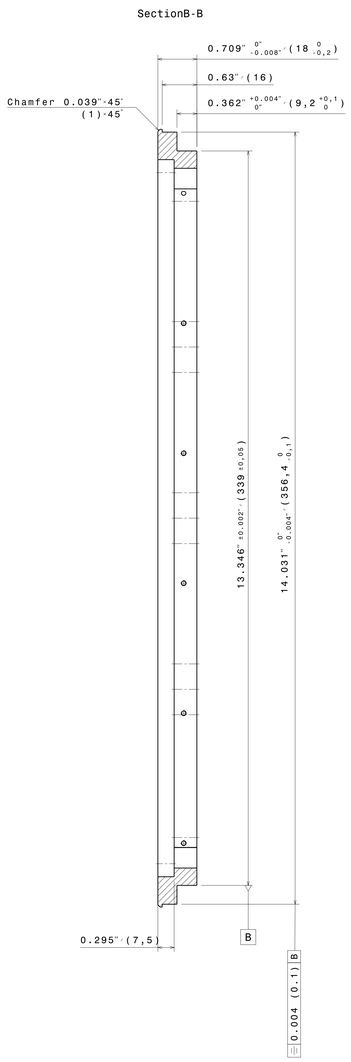
☐ No hardware affected

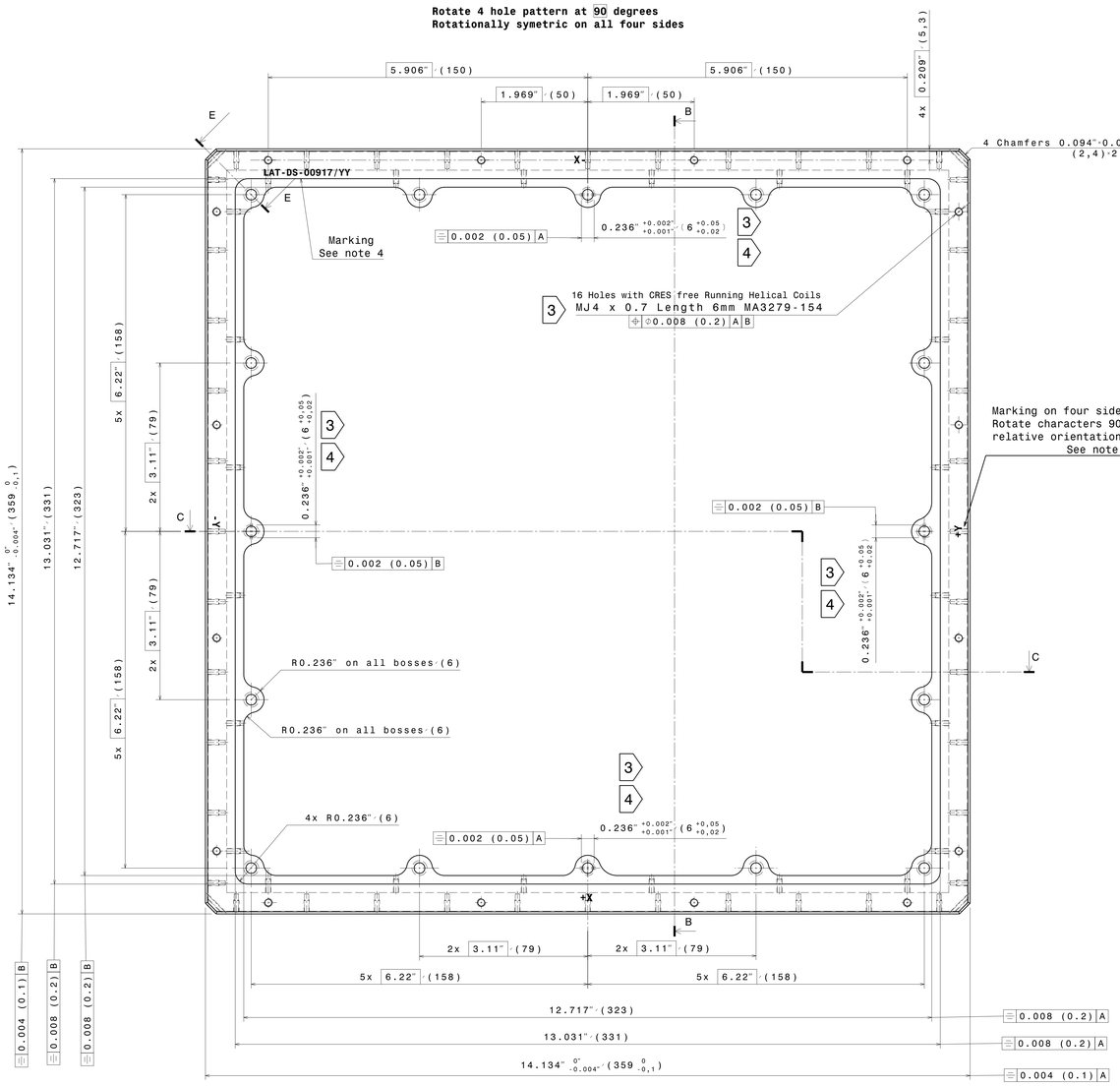
☒ Serial numbers affected: ALL **Effective date:** 2-Feb-04

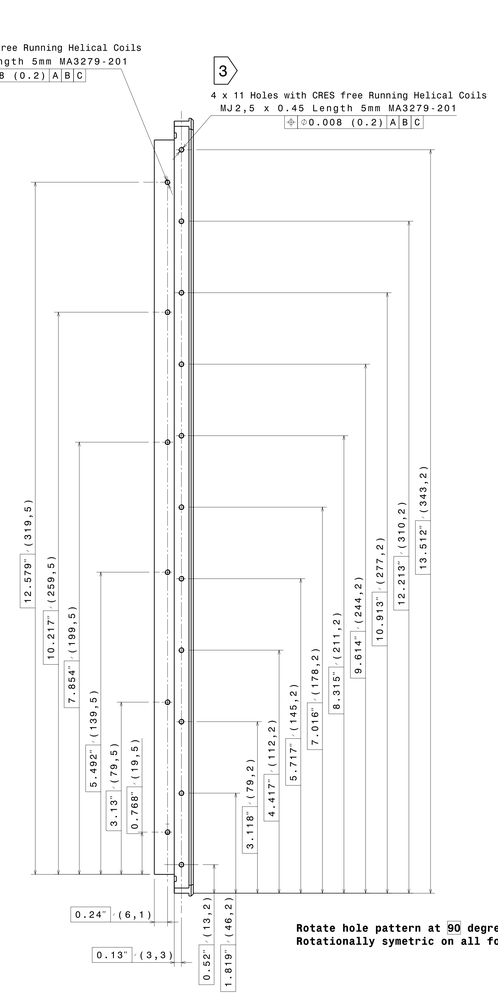
	Use as is	Retest	Rework	Scrap	Other/Comment
Raw material	☐	☐	☐	☐	
Parts in process	☒	☐	☐	☐	
Assemblies	☐	☐	☐	☐	

APPROVALS	DATE	OTHER APPROVALS (specify):	DATE
ORIGINATOR: Paul V. Dizon	2-2-04	:	
SUBSYSTEM MANAGER: Paul V. Dizon	2-2-04	:	
PROJECT MANAGER: [illegible]	2-5-04	:	
QUAL ASSUR. MANAGER: [illegible]	2/6/04	:	
CONFIGURED AND RELEASED: P. Sandoval	2-6-04		

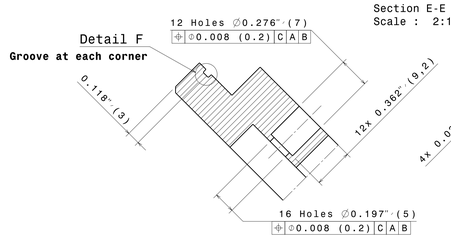
LAT-DS-00917-08	APPROVAL	DATE
CAL PROJECT MANAGER	WCR	2/05/04
CAL LEAD ENGINEER	PVD	2/05/04
CAL QA	JWL	2/06/04

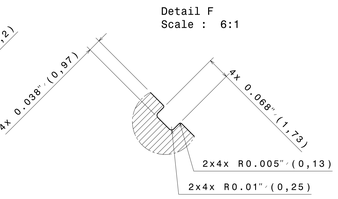


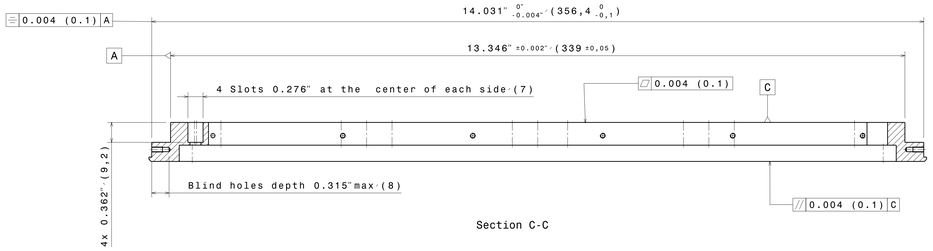




Section E-E
Scale : 2:1







Section C-C

MASTER DRAWING

GLAST-CAL CM FILE COPY

NOTE 1:
Main dimension inches, dimension within brackets are metric equivalent

NOTE 2:
All helicoils per SAE Aerospace Standard MA3279
installed in accordance to SAE Aerospace Standard MA1567
Clean helicoils with isopropyl alcohol prior to installation
Install insert 0.75-1.5 pitch below surface. Remove tang

NOTE 3:
Electroless nickel plating applied in accordance with SAE AMS-C-26074, Class 4, Grade A (not to exceed .0013 inch). All specified holes must be plugged prior to plating. All dimensions after plating

NOTE 4:
Chemical conversion coat applied in accordance with MIL-C-5541 class 3 to specified holes once electroless nickel plating of part is complete

NOTE 5:
Marking: Drawing number and serial number shall be engraved on the parts using normal gordon style characters, number size 7 (1/8 inch) as specified LAT-DS-00917/YY with YY serial number 01, 02 to 18
+X, -X, +Y, -Y Shall be engraved in the top center of each side with orientation as specified on the drawing

NOTE 6:
Break all corners and sharp edges to R 0.015" max unless specified

NOTE 7:
All dimensions and tolerances are defined with part fastened on a flat plate using the twelve ∅0.197 diameter holes

RELEASED FOR MANUFACTURE
06 FEB 2004

Part Number	Thread size/pitch (mm)	Length (mm)	Description	Quantity
MA 3279-154	MJ4 x 0.7	6	Insert, Helical Coil, Free Running, CRES	16
MA 3279-201	MJ2.5 x 0.45	5	Insert, Helical Coil, Free running, CRES	68

Dimensions: inch (mm)
Unless specified:
Tolerances: ± 0.004
Surface finish: Ra 63 micro inch
Material: 7075 T7351
Surface treatment: Electroless Nickel (note 3)
Drawing: Edy mai 2003
Checked: Ferreira
Approuved: -
A0
Scale: 1:1
Quantity: 20

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IN2P3

TOP FRAME

GLT-LLR-00-01

Fichier: GLT-LLR-00-01 I (Top frame).CATDrawing