CAL Document Change Notification

DCN No. 7650-DCN-0024-01

CHANGE TITLE: Tab Radius Correction On The Base Plate

☒ **Internal** ☐ **External**

ORIGINATOR: Paul Dizon **DATE:** 12-Feb-04 **NEXT ASSY:** LAT-DS-00916

DOC or DWG NUMBER	TITLE	AFFECTED REV.	NEW REV.
LAT-DS-00919	Base Plate	15	16

CHANGE DESCRIPTION:

1. Correct radius geometry of the tab with the sharp corner to 3 mm MAX as shown in the attached redlined drawings (page 1, Zone F-6 and Zone K-6; page 2, Zone F-5 and Zone K-5)

REASON FOR CHANGE:

Changes required to reflect actual intent of the design

DISPOSITION OF HARDWARE:

☐ **No hardware affected**

☒ **Serial numbers affected:** 11-20 **Effective date:** 12-Feb-04

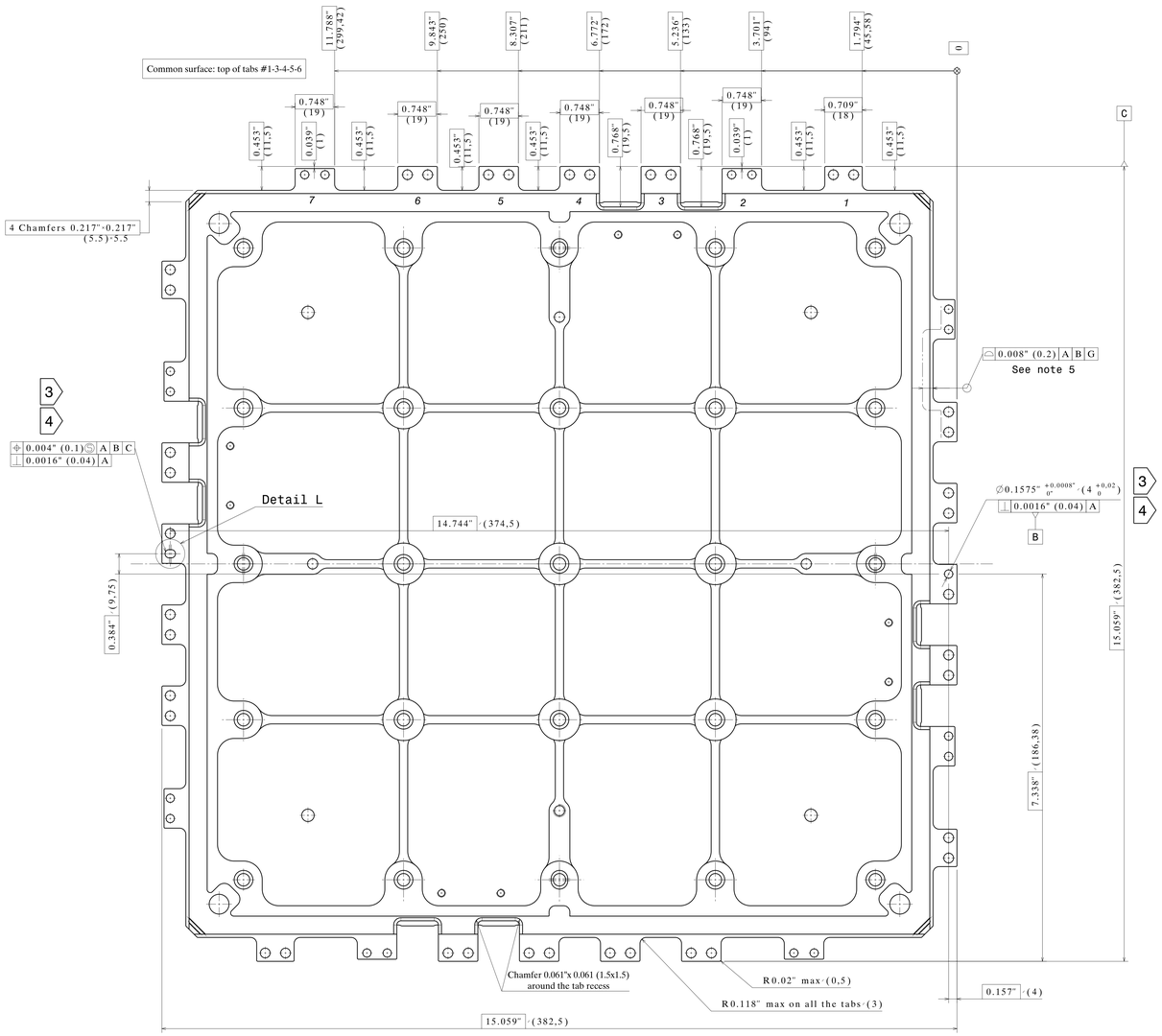
	Use as is	Retest	Rework	Scrap	Other/Comment
Raw material	☐	☐	☐	☐	
Parts in process	☒	☐	☐	☐	
Assemblies	☐	☐	☐	☐	

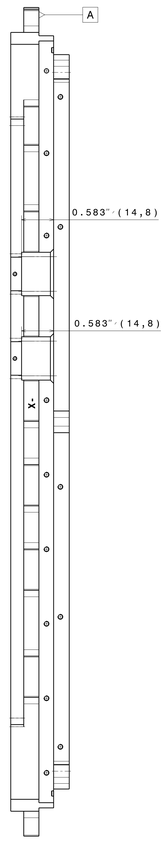
APPROVALS		DATE	OTHER APPROVALS (specify):	DATE
ORIGINATOR:	*Paul V. Dizon*	17-Feb-04	:	
SUBSYSTEM MANAGER:	*Paul V. Dizon*	17-Feb-04	:	
PROJECT MANAGER:	*W. N. Johnson*	24-Feb-04	:	
QUAL ASSUR. MANAGER:	*James W. Lee*	21-Feb-04	:	
CONFIGURED AND RELEASED:	*P. Sandora*	2-25-04		

LAT-DS-00919-16	APPROVAL	DATE
CAL PROJECT MANAGER	WNJ	2/24/04
CAL LEAD ENGINEER	PVD	2/23/04
CAL QA	JWL	2/25/04

BASE PLATE TAB DEFINITION

Rotate tab pattern at 90 degrees. Rotationally symmetric on all 4 sides

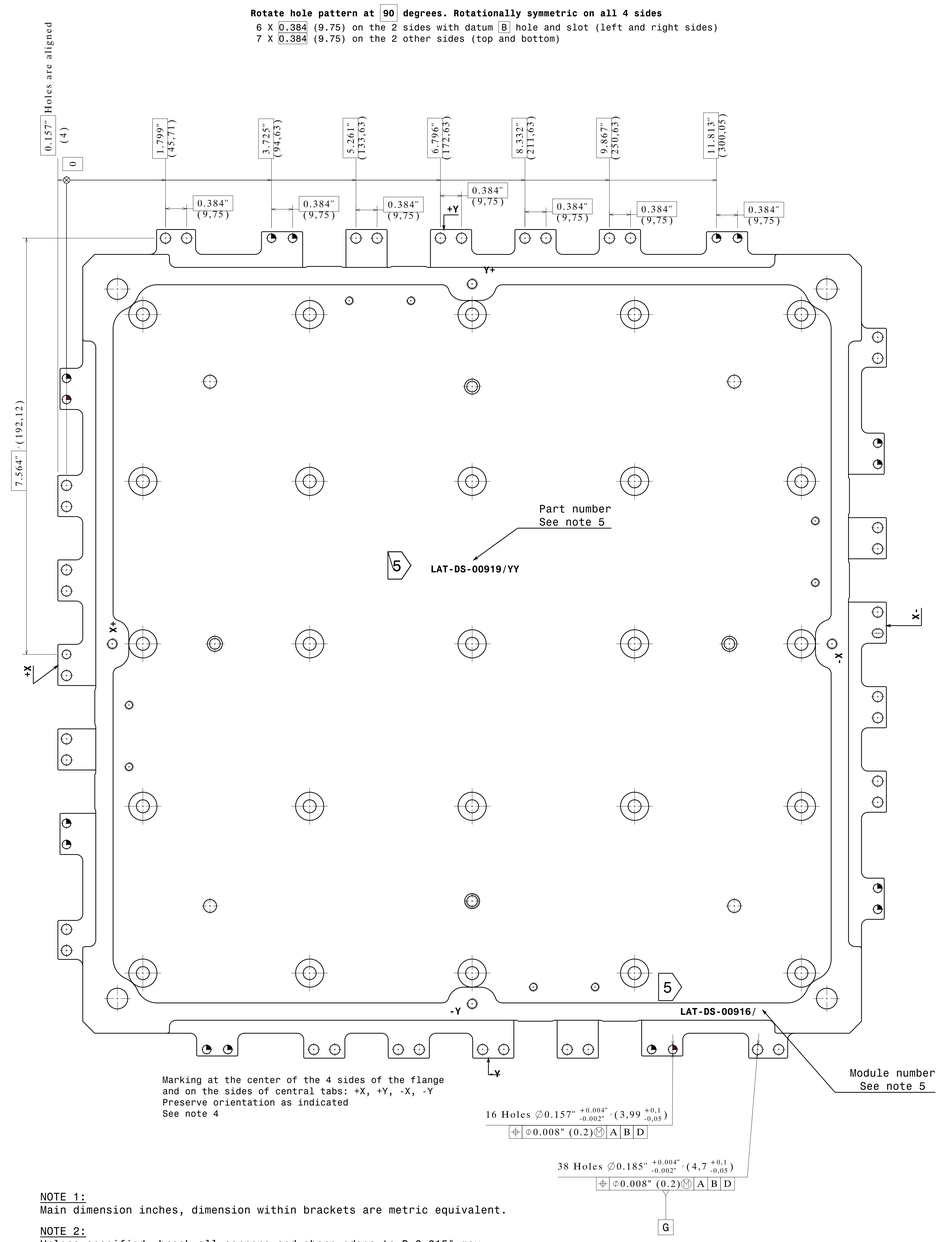


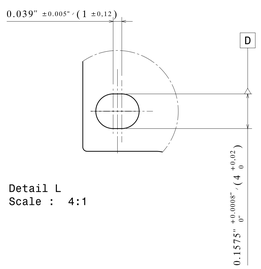


BASE PLATE MOUNTING HOLE DEFINITION

Rotate hole pattern at 90 degrees. Rotationally symmetric on all 4 sides

6 X 0.384 (9.75) on the 2 sides with datum B hole and slot (left and right sides)
7 X 0.384 (9.75) on the 2 other sides (top and bottom)





Detail L
Scale : 4:1

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

NOTE 2:
Unless specified, break all corners and sharp edges to R 0.015" max.

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:
Drawing number and serial number shall be engraved on the parts as specified LAT-DS-00919/YY, where YY is the serial number from 01 to 20. Module number shall be engraved on the parts as specified LAT-DS-00916/XX, where XX will be left as blank spaces. Orientation shall be indicated by +X, +Y, -X, -Y symbols engraved on the flange and on the central tabs
All marking shall be made with normal gordon style characters, minimum number size 7 (1/8 inch).

NOTE 6:
Datum dimensions on tabs define max allowable shape.

NOTE 7:
Tabs with ∅0.157" holes are shorter by 0.039" (tabs number 2 and 7).

MASTER DRAWING
GLAST-CAL CM FILE COPY

RELEASED FOR MANUFACTURE
25 FEB 2004

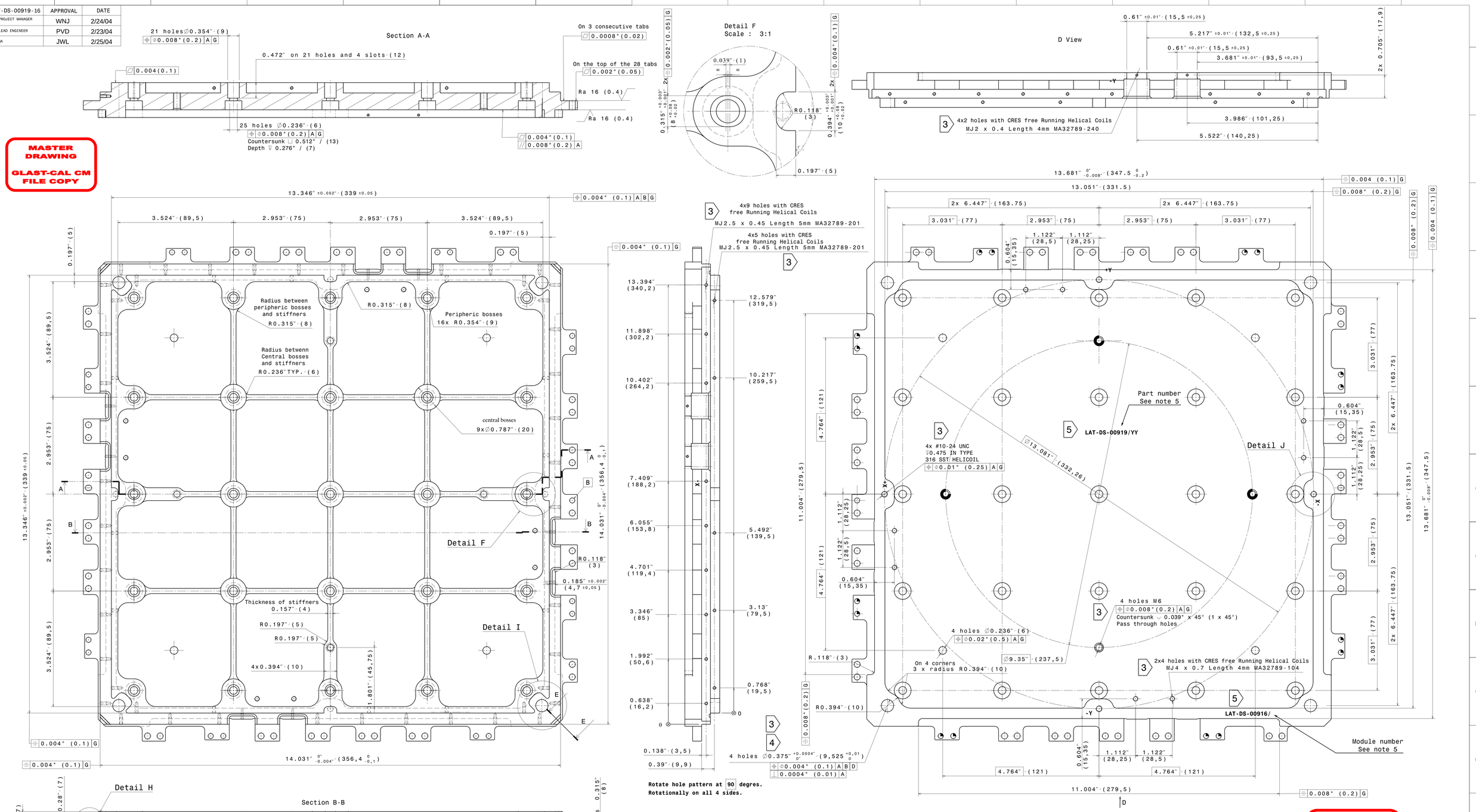
Dimensions: inch (mm)	A0	Laboratoire Leprince-Ringuet
Unless specified: Tolerances: ± 0.004 Surface finish: 63 µinch	Scale: 1:1	ECOLE POLYTECHNIQUE 91128 PALAISEAU
Material: 7075-T7351	Quantity: 20	TEL: 01 69 33 31 87 FAX: 01 69 33 39 62 IN2P3
Surface treatment: Electroless Nickel (note 3)		BASE PLATE
Drawing: Edy mai 2003		
Checked: Ferreira		
Approuved: -		GLT-LLR-00-06 1/2

Fichier: GLT-LLR-00-06 0 (Base plate).CATDrawing

LAT-DS-00919-16	APPROVAL	DATE
CAL PROJECT MANAGER	WNJ	2/24/04
CAL LEAD ENGINEER	PVD	2/23/04
CAL QA	JWL	2/25/04

MASTER DRAWING

GLAST-CAL CM FILE COPY



RELEASED FOR MANUFACTURE

25 FEB 2004

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

NOTE 2:
All metric helicoils per SAE Aerospace Standard MA3279, installed in accordance to SAE Aerospace Standard MA1567
Non metric helicoils per National Aerospace Standard NASM122200, installed in accordance to NASM33537
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:
Drawing number and serial number shall be engraved on the parts as specified LAT-DS-00919/YY where YY is the serial number from 01 to 20.
Module number shall be engraved on the parts as specified LAT-DS-00916/XX, where XX will be left as blank spaces.
Orientation shall be indicated by +X, +Y, -X, -Y symbols engraved on the flange and on the central tabs
All marking shall be made with normal gordon style characters, minimum number size 7 (1/8 inch).

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

Part Number	Thread size/pitch (mm)	Length (mm)	Description	Quantity
NASM 122200	#10-24 UNF (inch)	0.475 (inch)	Insert, Helical coils, Free Running, CRES	4
MA 3279-104	MJ4 x 0.7	5	Insert, Helical Coil, Free Running, CRES	8
MA 3279-201	MJ2.5 x 0.45	5	Insert, Helical Coil, Free Running, CRES	56
MA 3279-240	MJ2 x 0.4	4	Insert, Helical Coil, Free running, CRES	8

Dimensions: inch (mm)
Unless specified:
Tolerances: ± 0.004
Surface finish: 63 µinch
Material: 7075-T7351
Surface treatment: Electroless Nickel (note 3)
Drawing: Edy mai 2003
Checked: Ferreira
Approuved: -

A0
Scale: 1:1
Quantity: 20

Laboratoire Leprince-Ringuet
ECOLE POLYTECHNIQUE
91128 PALAISEAU
TEL: 01 69 33 31 87
FAX: 01 69 33 39 62
IN2P3

BASE PLATE

GLT-LLR-00-06 2/2

Fichier: GLT-LLR-00-06 O (Base plate).CATDrawing