Naval Research Laboratory – Space Sciences Division – Washington, D.C.

DCN-0015

GLAST ENGINEERING CHANGE ORDER	Drawing No. GLT-LLR-00-09	Current Rev. H	Outstanding ECO NONE	ECO No. 2

Drawing Title : **Close-Out Plate X**

[X] Class 1 [ ] Class 2 Sheet 1 of 1

WBS No. :

Reason : **Threaded holes must be plugged prior to application of plating.**

Next Assy. : **GLT-LLR-00-00**

Used On : **GLAST**

Submitted By : **Paul Dizon** Date : **7 January 2004**

Type of EO : [X] Advance notice of change; drawing will be revised
[ ] Deviation; drawing will not be revised
[ ] Other (EXPLAIN) :

Effective : Serial : ALL
Date : 7 JAN 2004
Other :

Disposition	Use as is	RWK	Scrap	See Above	Other :
Raw Material					
Parts in Process	X				
Assemblies					

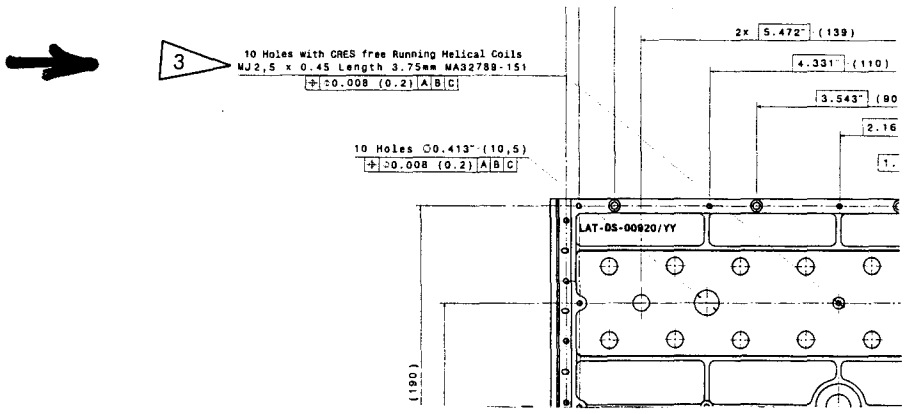
Description :

1. MODIFY NOTE 3 AS SHOWN:

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

2. ADD NOTE FLAG AS SHOWN:

a. Zone P-10



Drafter Date

Checker Date

Engineer 1-7-04 Date

Stress Date

QA 1-13-04 Date

Proj Mgr 1-13-04 Date

Manuf. Date

Date

Issued By :

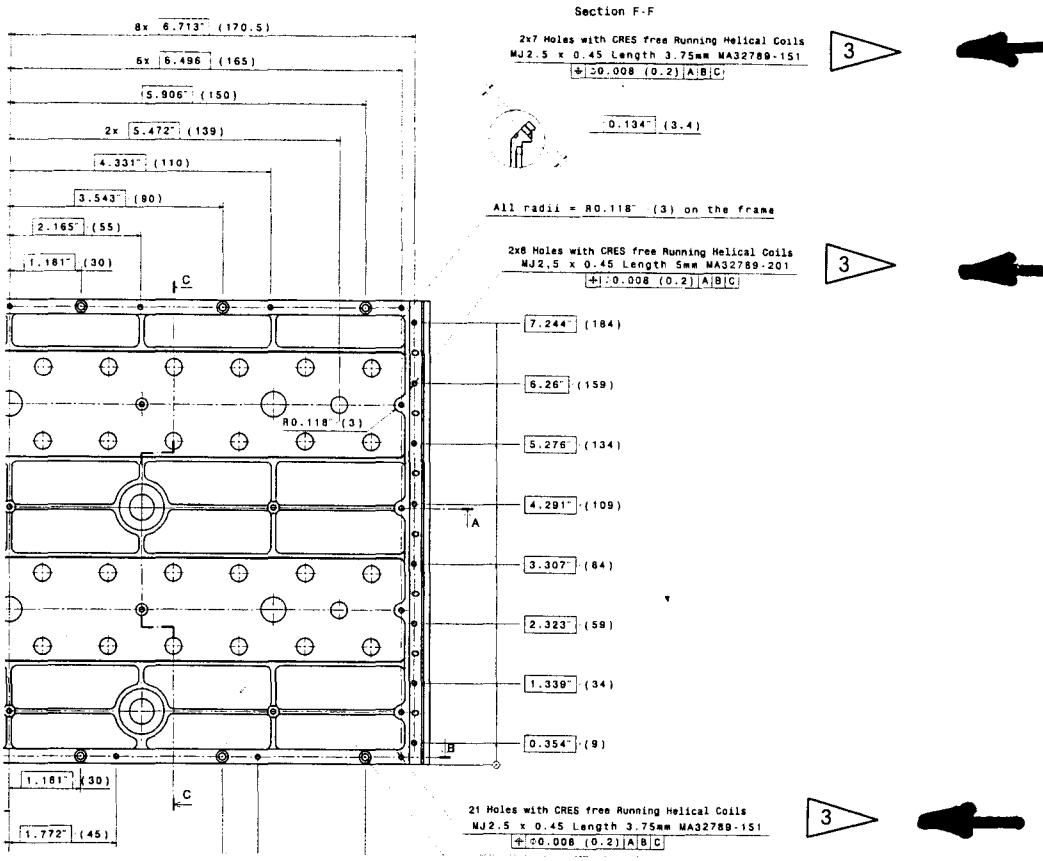
Date

INC. REV.

GLAST ENGINEERING CHANGE ORDER	Drawing No.	Current Rev.	Outstanding ECO	ECO No.
	GLT-LLR-00-09	H	NONE	2

Description :

b. Zones H-5 through H-11



Drafter	Date
Checker	Date
Engineer	1-7-04 Date
Stress	Date
QA	1-13-04 Date
Proj Mgr	1-13-04 Date
Manuf.	Date
Issued By :	Date
INC. REV.	

Naval Research Laboratory – Space Sciences Division – Washington, D.C. DCN-0016

GLAST ENGINEERING CHANGE ORDER	Drawing No. GLT-LLR-00-09	Current Rev. H	Outstanding ECO NONE	ECO No. 3

Drawing Title : Close-Out Plate X

[X] Class 1 [ ] Class 2 Sheet 1 of 3

WBS No. :

Reason : Redefine Datum C to a feature which defines a clearer definition for the centerline of the part

Next Assy. : GLT-LLR-00-00

Used On : GLAST

Submitted By : Paul Dizon Date : 7 January 2004

Effective : Serial : ALL

Date : 7 Jan 2004

Other :

Type of EO : [X] Advance notice of change; drawing will be revised

[ ] Deviation; drawing will not be revised

[ ] Other (EXPLAIN) :

Disposition	Use as is	RWK	Scrap	See Above
Raw Material				
Parts in Process	X			
Assemblies				

Other :

Drafter Date

Checker Date

Engineer 1-9-04 Date

Stress Date

QA 1-13-04 Date

Proj Mgr 1/13/04 Date

Manuf. Date

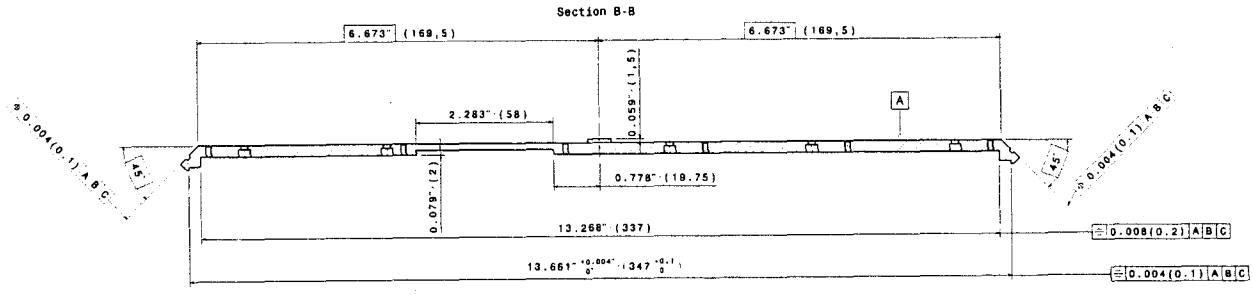
Date

Issued By : Date

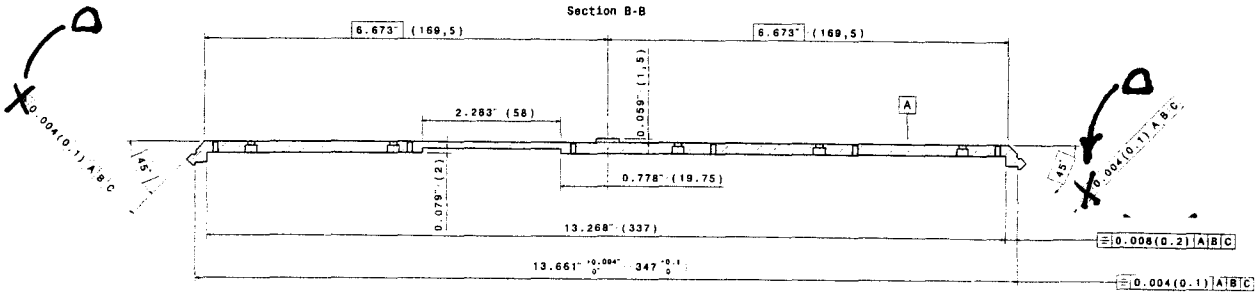
INC. REV.

Description :

1. Was Condition (Section B-B, in Zone L-2):



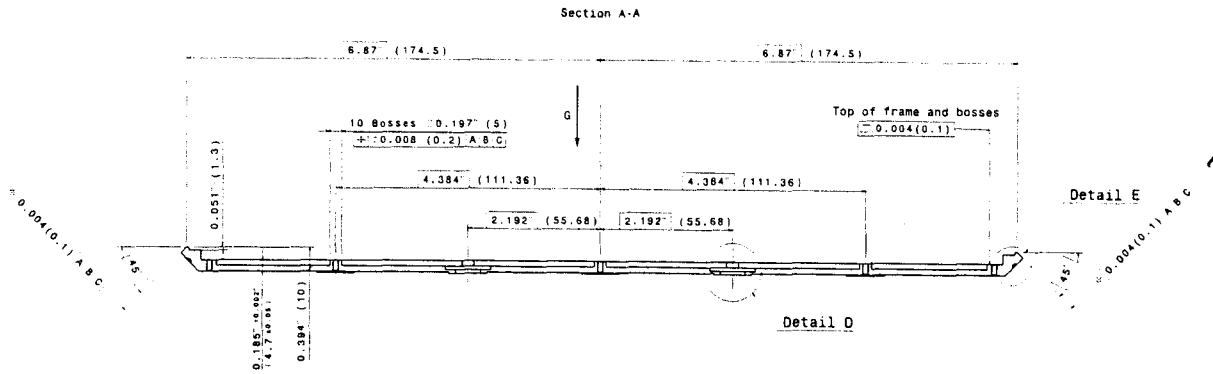
1. Now Condition (Section B-B, in Zone L-2) – Change Positional Tolerance to Profile Tolerance:



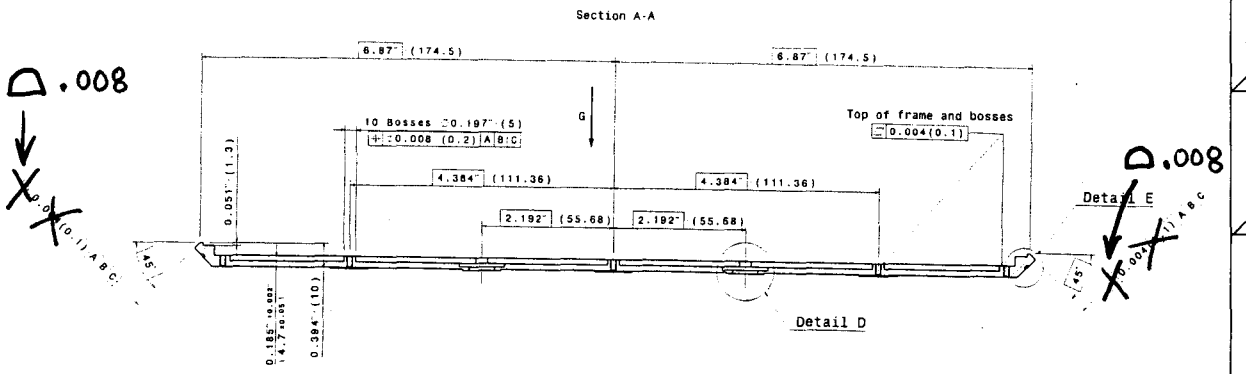
GLAST ENGINEERING CHANGE ORDER	Drawing No.	Current Rev.	Outstanding ECO	ECO No.
	GLT-LLR-00-09	H	NONE	3

Description :

2. Was Condition (Section A-A, in Zone L-14):



2. Now Condition (Section A-A, in Zone L-14) – Change Positional Tolerance to Profile Tolerance:

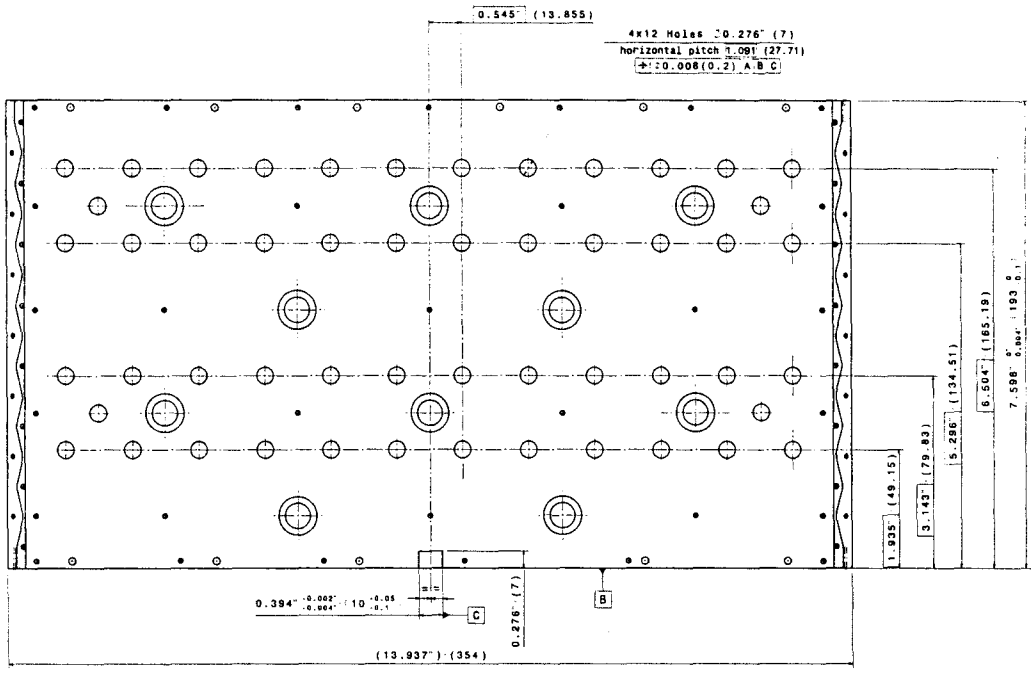


Drafter	Date
Checker	Date
Engineer	Date
Stress	Date
QA	Date
Proj Mgr	Date
Manuf.	Date
Issued By :	Date
INC. REV.	

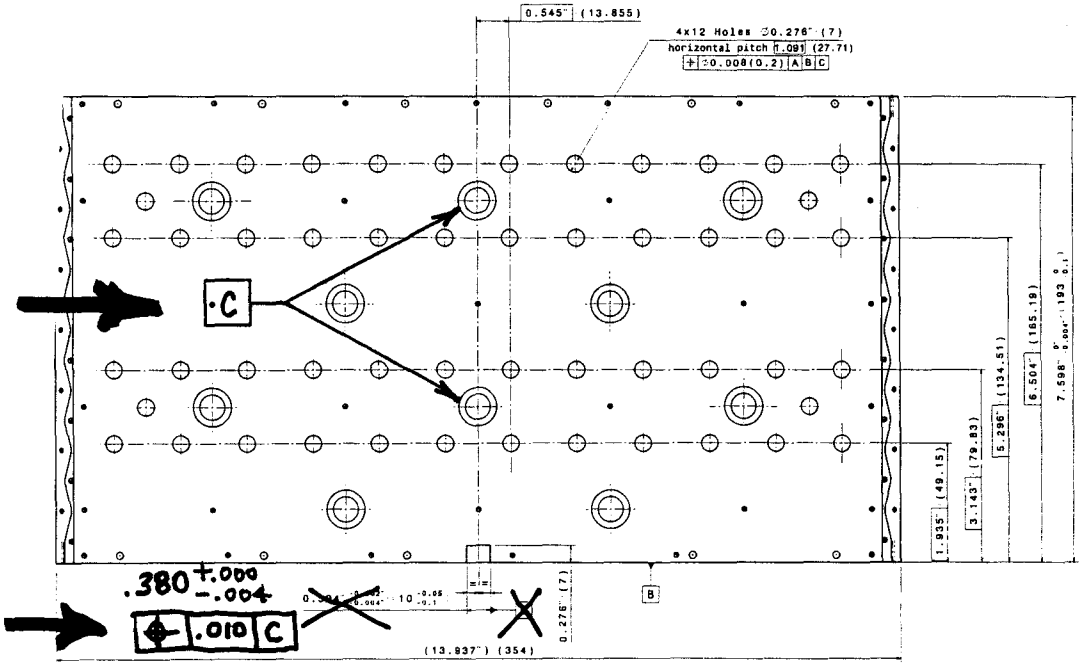
GLAST ENGINEERING CHANGE ORDER	Drawing No.	Current Rev.	Outstanding ECO	ECO No.
	GLT-LLR-00-09	H	NONE	3

Description :

3. Was Condition (Zone E-5 and D-7):

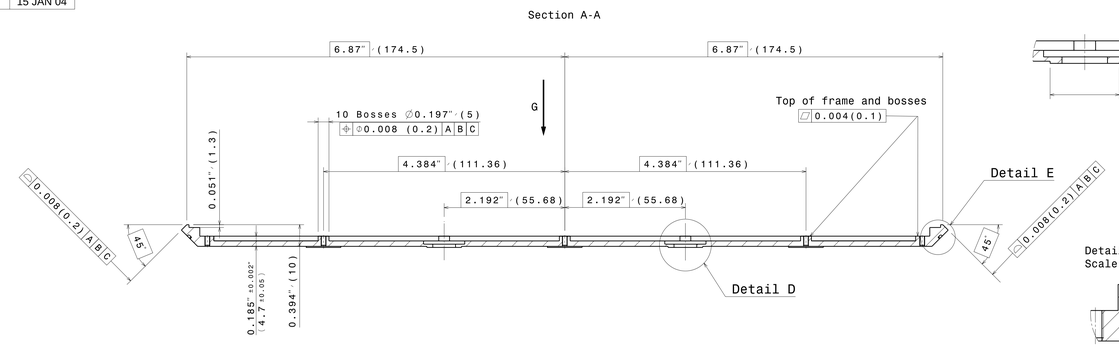


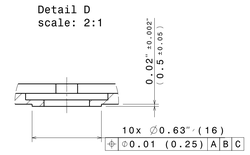
3. Now Condition (Zone E-5 and D-7):

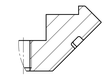


Drafter	Date
Checker	Date
Engineer	1-9-04 Date
Stress	Date
QA	1-13-04 Date
Proj Mgr	1-13-04 Date
Manuf.	Date
Issued By :	Date
INC. REV.	

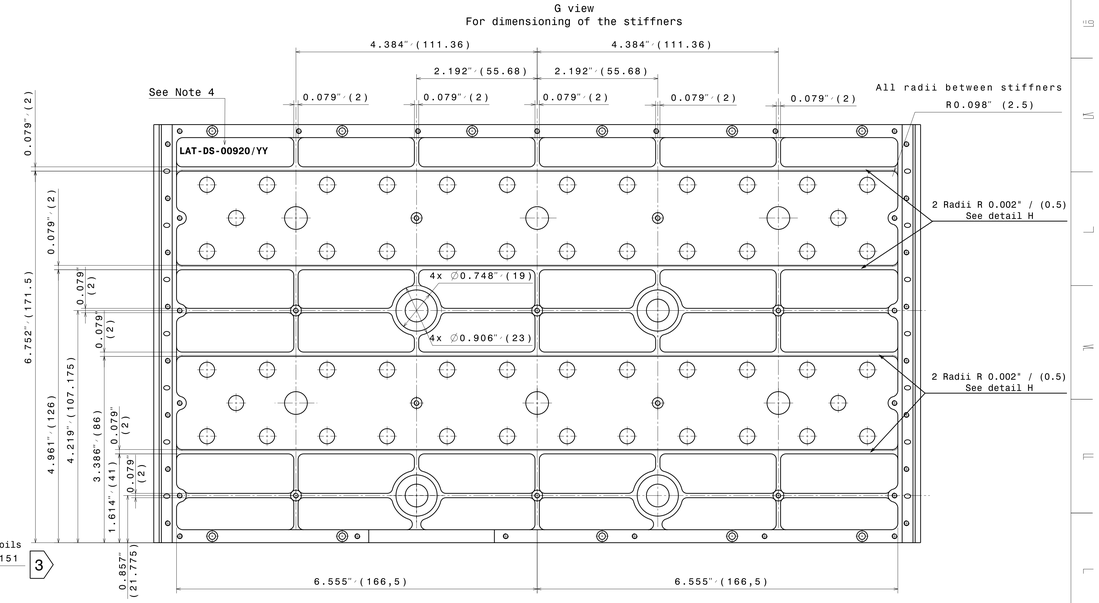
LAT-DS-00920-09	APPROVAL	DATE
CAL PROJECT MANAGER	WCR	15 JAN 04
CAL LEAD ENGINEER	PVD	14 JAN 04
CAL QA	JWL	15 JAN 04



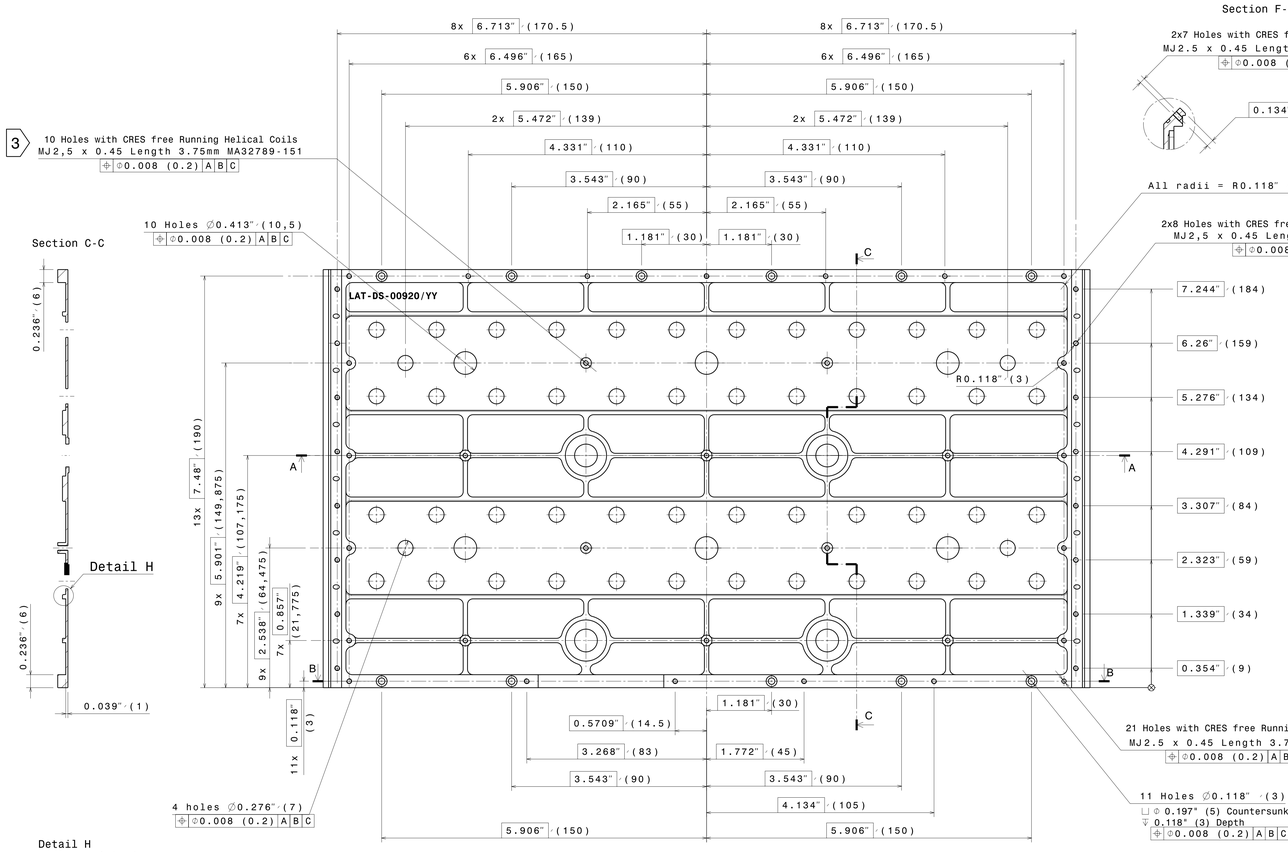


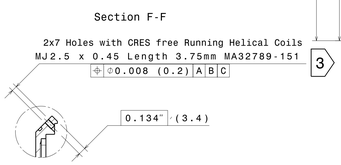


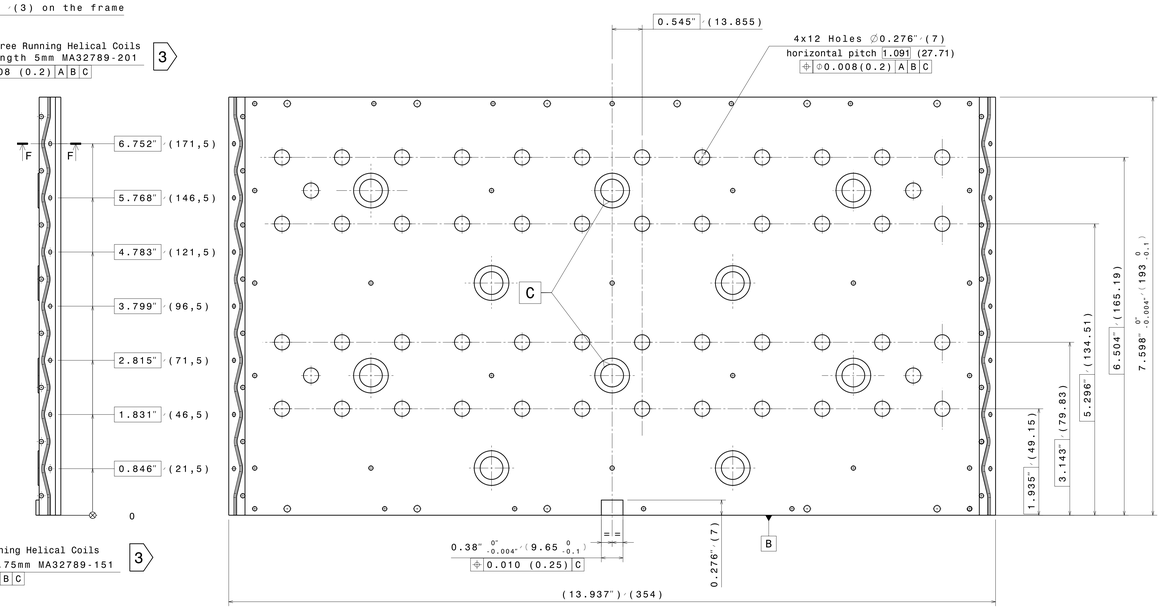
Groove on both corners
Definition on page 2

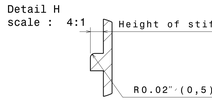


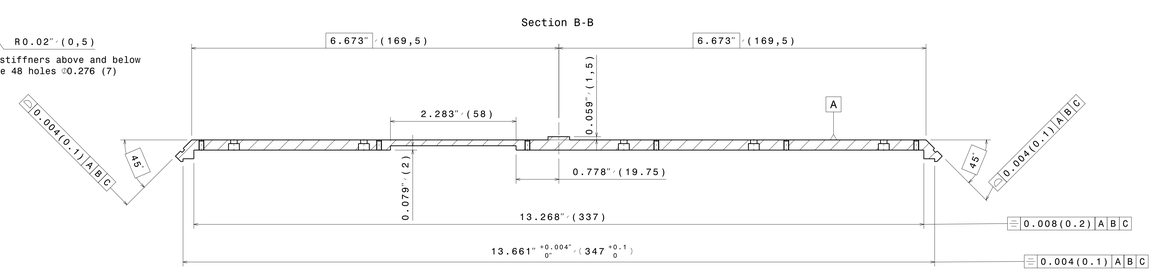
MASTER DOCUMENT
GLAST-CAL CM FILE COPY











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 threaded holes must be plugged prior to plating. All dimensions after plating

NOTE 4:
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-00920/YY with YY serial number 01, 02 to 36

NOTE 5:
All dimensions and tolerances are defined with part fastened on a flat plate using the eleven ∅3 holes with ∅5 countersunk and the ten ∅10.5 holes

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

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15 JAN 2004

Part Number	Thread size/pitch (mm)	Length (mm)	Description	Quantity
MA 3279-201	MJ2.5 x 0.45	5	Insert, Helical Coil, Free Running, CRES	16
MA 3279-151	MJ2.5 x 0.45	3.75	Insert, Helical Coil, Free running, CRES	45

Dimensions: inch (mm)
Unless specified:
Tolerances: ± 0.004
Surface finish: Ra 63 micro inch
A0
Scale: 1:1
Material: 7075 T7351
Surface treatment: Electroless Nickel (note 3)
Quantity: 40
Drawing: Edy mai 2003
Checked: Ferreira
Approuved: -

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

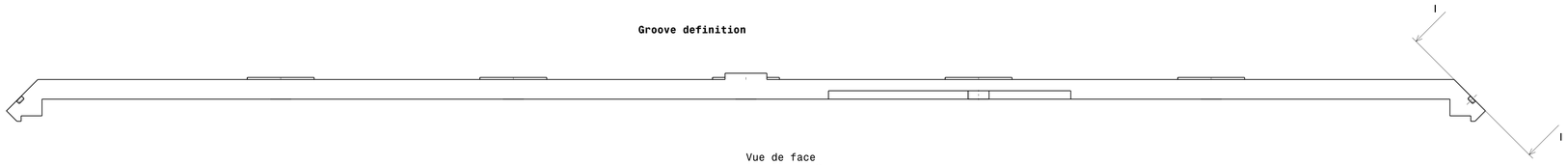
CLOSE OUT PLATE X

GLT-LLR-00-09 1/2

Fichier: GLT-LLR-00-09 I (Closeout plate X).CATDrawing

LAT-DS-00920-09	APPROVAL	DATE
CAL PROJECT MANAGER	WCR	15 JAN 04
CAL LEAD ENGINEER	PVD	14 JAN 04
CAL QA	JWL	15 JAN 04

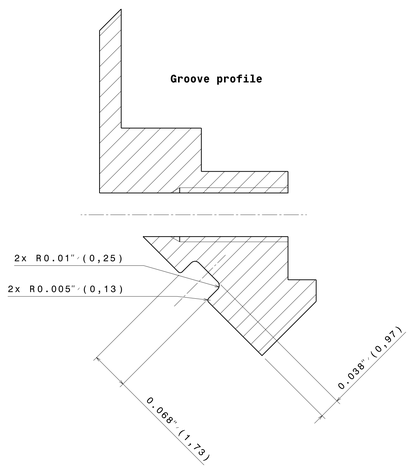
Groove definition



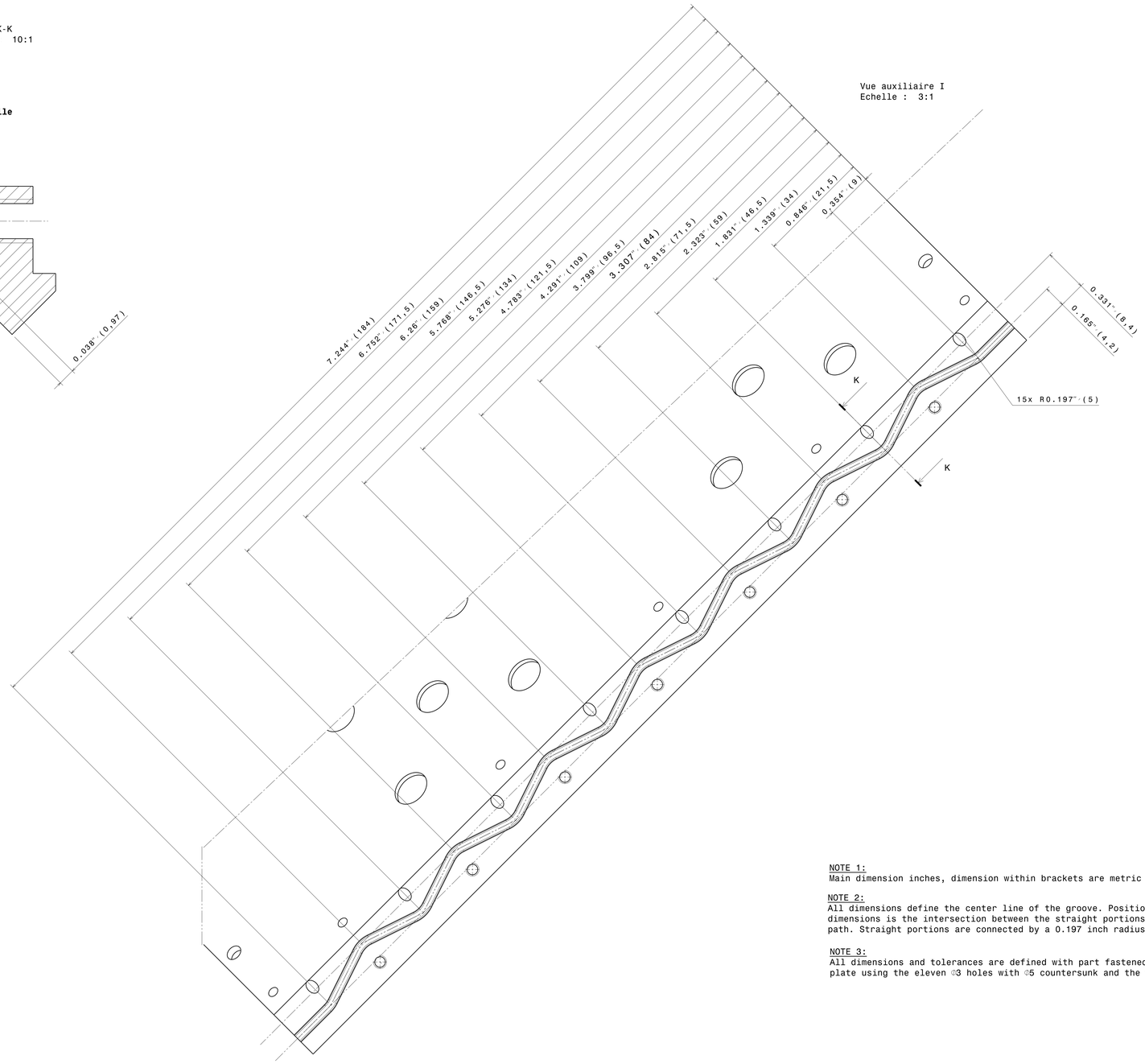
Vue de face
Echelle : 2:1

Section K-K
Echelle : 10:1

Groove profile



Vue auxiliaire I
Echelle : 3:1



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

NOTE 2:
All dimensions define the center line of the groove. Position of the dimensions is the intersection between the straight portions of the path. Straight portions are connected by a 0.197 inch radius

NOTE 3:
All dimensions and tolerances are defined with part fastened on a flat plate using the eleven Ø3 holes with Ø5 countersunk and the ten Ø10.5 holes

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15 JAN 2004

Dimensions: inch (mm) Unless specified: Tolerances: ± 0.004 Surface finish: Ra 63 micro inch	A0 Scale: 1:1	Laboratoire Leprince-Ringuet ECOLE POLYTECHNIQUE 91128 PALAISEAU TEL: 01 69 33 31 87 FAX: 01 69 33 39 62 IN2P3
Material: 7075 T7351 Surface treatment: Electroless Nickel (note 3)	Quantity: 40	CLOSE OUT PLATE X
Drawing: Edy mai 2003 Checked: Ferreira Approuved: -		GLT-LLR-00-09 2/2

Fichier: GLT-LLR-00-09 I (Closeout plate X).CATDrawing