

LAT ASSEMBLY AND INSPECTION DATA Record #669

LAT Assembly Information:

Equipment Title	Drawing No.	Rev	Serial No.
TEM/TPS ACCEPTANCE TESTING	LAT-DS-01643	52	GLAT1752
Reference Designator	Subsystem	Equipment Class	Prepared by
	Electronics and Data Acquisition	Flight	

Approvers:

Responsible Engineer

Manufacturing Engineer

Quality Engineer

Date Signed:

[Signature]
1/24/05

Date Signed:

[Signature]
1-24-05

Date Signed:

[Signature]
1-24-05



Step Instructions:

Step#	Step Instruction	Operator	ID	Operator	Date	Operator	Stamp	Upda
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10 The purpose of this work order is to receive in the TEM/TPS Acceptance Unit, perform acceptance level testing, final inspect, and data review for subsequent delivery to I&T. Mass properties measurements may be performed at any time.



1-24-05

1/24/2005
12:02:2

20 UNIT IS TO BE HANDLED USING FLIGHT HARDWARE PRECAUTIONS TO PREVENT ESD OR PHYSICAL DAMAGE PER LAT-TD-02797.



1-24-05

ISSUED 1-25-05 ASC

30 Perform incoming inspection of shipping container, shock monitors. QA verify and report.



1-24-05

4FC 25g indicator tripped
1-24-05

40 QC inspect TEM/TPS and review data package for completeness. Record TEM/TPS tracking # GLAT1752



1-24-05

4FC No EIDP received - TBD at later date per GT
1-21-05

50 Perform Reference Performance Test per LAT-TD-04085-2. Engineering and QA approve performance test data.



1-25-05

C.S. 1/24/05

60 QC inspect TEM/TPS. Review and approve performance test data. Remove and retain connector savers and record on mate/demate log. Install connector covers. Clean with solvent. Wipe as required. Tape seal open holes and gaps between connectors and housing with kapton tape as required to maintain cleanliness.



1-25-05

70 Bag TEM/TPS and package in shipping container. Install shock monitors (1 each 25, 50, and 100g in both vertical and lateral directions). Deliver TEM/TPS to Wyle Labs for vibration. QA report shock monitor trips.




1-25-05

FTC
2-17-05


80 Perform vibration test per LAT-TD-05649-1. QA and Engineering approve test data.

 1-25-05

90 Bag TEM/TPS and package in shipping container. Ensure shock monitors are installed properly and reset if necessary. Return to SLAC.

 1-26-05

100 QC inspect TEM/TPS and review data package for completeness. Inspect connectors for damage. Wipe clean with alcohol.

 1/26/05

110 Perform post vibration performance test per LAT-TD-04085-2. Engineering and QA approve test data. Install connector savers and record on mate/demate log.


SSC 1/27/05

120 Perform thermal cycle test, 5 cycles, between -40C and +55C with a 15 minute soak at each temperature. The rate of change in temperature shall not exceed 5C per minute. The thermal chamber shall be continuously purged with clean dry air or gaseous N2 to prevent water from condensing in the chamber and on the TEM/TPS assemblies. Cycling shall start at ambient then increase to the high temperature for the first soak, then continue for 5 cycles ending with a 30 minute cool down period at 25C. Technician to record equipment name, model #, and cal dates. QA verify.

TENNEY, 10C
6/16/05
Dickson Temp. Probe
FH125
cal due date 2/05
1/24/2006
12:51:2

130 Perform post thermal cycle test per LAT-TD=04085-2. Engineering and QA approve test data.


140 Perform EM/EMC test per 1196 E0 E4315 000. Engineering and QA approve test data.


Redline
FTC
1-31-05
Delete

150 QC inspect TEM/TPS and review data package for completeness. Wipe clean with alcohol.

160 Perform Final Performance. Engineering and QA approve test data.

Unit is to be transported to and from Metrology in shipping container. Ensure shock monitors are installed properly and reset if necessary. QC to report any shock monitor trips. Following mass properties measurements, unit is to be QC inspected and wiped clean with alcohol prior to entry into cleanroom. Perform Mass Properties Measurements.
MASS 7.39 kg

 1-27-05

70 Bag TEM/TPS and package in shipping container. Install shock monitors (1 each 25, 50, and 100g in both vertical and lateral directions). Deliver TEM/TPS to Wyle Labs for vibration. QA report shock monitor trips.

80 Perform vibration test per LAT-TD-05649-1. QA and Engineering approve test data.

90 Bag TEM/TPS and package in shipping container. Ensure shock monitors are installed properly and reset if necessary. Return to SLAC.

100 QC inspect TEM/TPS and review data package for completeness. Inspect connectors for damage. Wipe clean with alcohol.

110 Perform post vibration performance test per LAT-TD-04085-2. Engineering and QA approve test data. Install connector savers and record on mate/demate log.

120 Perform thermal cycle test, 5 cycles, between -40C and +55C with a 15 minute soak at each temperature. The rate of change in temperature shall not exceed 5C per minute. The thermal chamber shall be continuously purged with clean dry air or gaseous N2 to prevent water from condensing in the chamber and on the TEM/TPS assemblies. Cycling shall start at ambient then increase to the high temperature for the first soak, then continue for 5 cycles ending with a 30 minute cool down period at 25C. Technician to record equipment name, model #, and cal dates. QA verify.

Redline

ATC

1-31-05



Delete

130 Perform post thermal cycle test per LAT-TD=04085-2. Engineering and QA approve test data.

JSL

2/2/05



2-2-05

135 Perform TVAC Test per LAT-TD-03631-03. Engineering and QA approve test data.

ATC 2-17-05



L.S 2/17/05

ATC 2-17-05
LAT 2 QA
136

Perform EMI/EMC Acceptance Testing per LAT-TD-05671 rev 2.

Engineering & QA approve data



ATC 2-17-05

150 QC inspect TEM/TPS and review data package for completeness. Wipe clean with alcohol.

ATC 3-3-05



L.S 2/17/05

160 Perform Final Performance. Engineering and QA approve test data.

Unit is to be transported to and from Metrology in shipping container. Ensure shock monitors are installed properly and reset if necessary. QC to report any shock monitor trips. Following mass properties measurements, unit is to be QC inspected and wiped clean with alcohol prior to entry into cleanroom. Perform Mass Properties Measurements.

170

MASS 7.39 Kg

1-31-05



Data taken 1-27-05

see page 2 of AIDS

FINAL INSPECTION. Be sure to remove any tape installed in sequence 50. Bag TEM/TPS in static dissipative material and place in shipping container.

180

AFC 3-3-05



185

See Black Line Below

190

Perform Data Review

L.S. 3/3/05

200

Close this work order and return to LAT QA Bldg. 33 for record retention and deliver to I&T.

185

Black Line

Perform Safe to Mate Tests on TEM/TPS

J.M. Perform TPS EICIT LAT-TD-04099

Para. ~~5.1.3, 5.1.4~~, 5.2.2.1, 5.2.2.3, 5.2.2.5

Feb 02/14/0

J.M. Perform TEM EICIT LAT-TD-03875

Para. 5.2 (SKIP para 5.2.3) Also, 5.4 steps to measure signal isolation from ground.

Feb 22/14/0

J.M. Perform TEM SUT LAT-TD-04097

Para. 5.3

Feb 23/14/05

Attach ^{any} data sheets to this AIDS if applicable

AFC
2-11-05

