P0117 Squid Bracket Kit Assembly | Drawing: #25475
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Document Revision Record

Rev	Date	ECO #	Pages Affected	Description
-	6/22/98	NA	all	new procedure

Squid Bracket Assembly
25098-101

Authority to Redline Procedure
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Authorized Assemblers
M. Bogan
B. Muhlfelder (kit only)
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Note: This assembly is not ESD sensitive.

Materials & Supplies
1. Web, squid bracket # 25095-101
2. Plate, top bracket # 25096-101
3. Plate, bottom bracket # 25097-101
4. Spacer Web # 25102-101
5. 0-80 Screw socket head # 25135-107
6. Non magnetic Allen wrench
7. latex gloves
8. Stycast epoxy #1266
9. Kapton spacers # .005 (0.1075 X 0.810)
10. Teflon sheet
11. Phosphor bronze helicoil 0.112-40 (25096-101 and 25097-101 call out these to be installed at the piece part level).
12. Methanol

Note: Gloves are required to keep the parts clean through all the assembly processing. Plates have been coated with lead / tin.

Procedure

1.1 Insert helical coils in top plate and in bottom plate of the squid bracket. Use a non-magnetic insertion tool only.

1.2 deleted.

1.3 Do a fit check with of web PN25095-101 and plate's PN25096-101 and PN25097-101.

1.3.1 Screw (finger tight only) top Plate onto one side of the web. Use socket head cap screws PN25135-107.

1.3.2 Use socket head cap screws PN25135-107 to assemble (finger tight only) the bottom plate onto the other side of the web.

1.3.3 Make sure the bracket is well seated on the inside of both plates.

1.3.4 Disassemble bracket. Clean piece parts with methanol. Wipe dry.

1.4. Place web spacers (25102-101) above threaded holes of web. Coat with Stycast 1266 the inside of the slots on each of the two plates as shown in drawing 25098-101. Wipe off excess epoxy.

1.5 Reassemble the two plates onto the web. Use a non-magnetic Allen wrench to tighten down the 25135-107 screws to hold the assembly together. Wipe off excess epoxy.

_____ ____
Operator date

SQUID BRACKET KIT
25475-201
Materials and Supplies
Temperature Sensor Assy, SQUID Bracket 25486-201(2 ea.)
Heater Assy, Chip Resistor 23529-101 (1 ea.)
Clasp, Cable routing 25476-101 (6 ea.)
Nut, Hex 23193-101 (6 ea.)
SQUID Bracket Assy 25098-101 (1 ea.)
methanol

Procedure
1. Record here GRT #1 serial number_____ and probe connector ID_____. Record here GRT #2 serial number_____and probe connector ID_____. RE signoff_____ date_____. See drawing 25475-201 for locations on bracket for GRTs #1 and #2. Record here SQUID bracket assy 25098-101 serial #_____. Apply 1266 epoxy to 25486-201 and install into SQUID Bracket Assy (25098-101) as shown in drawing 25475-201. Note on the traveler of the bracket assy 25098-101, the bracket's serial #, the GRT serial numbers, bracket locations and the corresponding probe C connector IDs.

Note: The assembly of the SQUID bracket kit may take place in the class 10 cleanroom during the integration into Probe C.

2. Record here the serial number for heater #1_____ and its probe connector ID_____. Record here the serial number for heater #2_____ and it probe connector ID_____. See drawing 25475-201 for location on the bracket for heaters #1 and #2. RE signoff_____ date_____. Note on the traveler the serial numbers of the two heaters, the heaters probe connector IDs and the heater locations on the bracket. Apply 1266 epoxy to 23529-101 and install into SQUID Bracket Assy (25098-101) as shown in drawing 25475-201. Note on the traveler the location of each heater (include both the location on the bracket, the serial number information and which pins connect to which heater). Allow assembly to dry for at least 12 hours.

3. Install cable routing clasp (25476-101) and hex nut (23193-101) onto SQUID Bracket Assy (25098-101) as shown in drawing 25475-201.

4. Tack wires from 25486-201 and 23529-101 onto the bracket as shown in drawing 25475-201.

5. Allow to dry for at least 12 hours.

6. Clean with methanol. Wipe dry.

_____ ____
Operator date

_____ ____
QA date