



**California Institute of Technology
Massachusetts Institute of Technology**

DCN No. E040016-00-E

Document Change Notice (DCN)

Sheet 1 of 1

DOCUMENT No. (DOC-REV-GP.ID)	TITLE	NEW REV
E030068-B-E	HEPI Actuator Welded Assembly Procedure (Tripod Assembly)	C

CHANGE DESCRIPTION (FROM/TO): B release to C

1. Torque of cap screws attaching tripod to rods, and rods to actuator plate was not noted in earlier revisions. 5/16"-18 cap screws are to be torqued on both ends gradually beginning with 5 ft-lbs on each screw top and bottom, then in steps of 10 ft-lbs and 15 ft-lbs before all screws are torqued to a final 20 ft-lbs.

2. Push the top and bottom bellow guards away from the actuator plate so that they are up against the end plates. Tighten them down and then measure the gap that the actuator can move. It should be +/- .05"

NOTE: Make sure that the three .001" spacers on top of the tripod base are installed before shipping.

REASON FOR CHANGE: Misalignment of tripod during installation due to inconsistent tightening of bolts.

ACTION: Incorporate Change Attach DCN to Drawings Other Action (specify):

DISPOSITION OF HARDWARE (IDENTIFY SERIAL NUMBERS)	DCN DISTRIBUTION		
<input type="checkbox"/> No hardware was affected (record change only):	Abbott	Zucker	Coyne
<input type="checkbox"/> List S/Ns which comply already:	Mason	Lantz	Giaime
<input type="checkbox"/> List S/Ns to be reworked/scrapped:			
<input type="checkbox"/> List S/N's to be built with this change:			
<input type="checkbox"/> List S/Ns to be retested per this change:			
<input type="checkbox"/>			

SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT? NO YES (If YES, enter CR (CCB) or TCP (TRB) #)

APPROVALS:	DATE	OTHER APPROVALS (SPECIFY)	DATE
ORIGINATOR: Kern / Mason / Spjeld	1/30/04	Coyne	
TASK LEADER: Abbott			
GROUP LEADER: Giaime			

DCC RELEASE: