



DOCUMENT CHANGE NOTICE (DCN)

DOCUMENT No. (DOC-REV-GP. ID)	TITLE	NEW REV.
E970038-F-D	Large Optic Suspension (LOS) Structural Fabrication Specification	G
D960504-B-D	LOS1 Leg	C
D960502-B-D	LOS1 Front Stiffener	C
D960133-F-D	Large Optic Suspension Structure Assembly	G
D970551-F-D	Recycling Mirror LOS Structure Assembly	G

CHANGE DESCRIPTION (FROM/TO): E970038: Include a pickle and passivation step after part machining and before welding. Change Figure 1: Process Sequence to include this additional pickle and passivation step. Add a pickle and passivate step after "Grinding & Abrasive Cloth/Paper"

2. D960504: Change drawing to as-built config. and add drain hole on top, centered along with another on the opposite side. Restore drain hole in the middle of the leg to its prior position, in the middle of the stiffener.

3. D960502: Add drain hole in the center of the stiffener.

4. D960133: update drawing with changes above and move crosshair up by 1.000"

5. D970551: update drawing with changes above and move crosshair up by 1.000".

REASON FOR CHANGE: Increase cleanliness of final weldments

ACTION: Incorporate change Attach DCN to drawing(s) Other action (specify):

DISPOSITION OF HARDWARE (IDENTIFY SERIAL NUMBERS)	DCN DISTRIBUTION (X=incl. docs)
<input type="checkbox"/> No hardware affected (record change only)	Althouse Barish Coles
<input type="checkbox"/> List S/Ns which comply already:	X Coyne Lazzarini Lindquist
<input checked="" type="checkbox"/> List S/Ns to be reworked or scrapped: Rework drain holes of D960133, S/N 001	Raab Sanders Shoemaker
<input checked="" type="checkbox"/> List S/Ns to be built with this change: D960133 S/N 002 and up,	Stapfer Tyler Weiss
<input type="checkbox"/> List S/Ns to be retested per this change:	Whitcomb Zydowicz
<input type="checkbox"/>	Bork Zucker
<input checked="" type="checkbox"/> D960145 S/N 003 and up, all S/Ns for all others.	Barton Mason
<input type="checkbox"/>	Camp Jones
<input type="checkbox"/>	X Fine X Petrac
<input type="checkbox"/>	X Hazel Romie *
	X John Bergeron, BM

SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT? No Yes (If yes, enter Change Request number)

APPROVALS:	DATE	OTHER APPROVALS (specify)	DATE
ORIGINATOR: J. Romie	7-31-98		
TASK LEADER:			
GROUP LEADER: <i>J. Coyne</i>	8/5/98		
DCC RELEASE: <i>[Signature]</i>	8/5/98		