

# SPIRE

**SUBJECT: SPIRE FPU Handling and Integration Procedure**

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**Project Document**

SPIRE FPU Handling and Integration  
Procedure

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**Distribution**

## Change Record

| ISSUE    | DATE            |   |
|----------|-----------------|---|
| Draft    | 3/12/03         | First draft   |
| Draft 2  | 15/12/03        | Additions from MSSL<br>Inclusion of electrical integration procedure  |
| 1        | 20/5/04         | Comments from ASSED incorporated as appropriate<br>Drawings added   |
| 2        | 21/10/04        | Revised §6.2 to comply with doc. " <i>Making SPIRE ESD Safe - SPIRE-RAL-NOT-002028</i> , Issue 1.0"<br>Deleted Cryoharness Crosstalk test   |
| 3        | 6/12/04         | Section 5.1 and 5.2 Deleted requirement to purge during AIT phases  |
| <u>4</u> | <u>08/07/05</u> | <ul style="list-style-type: none"><li>• <u>Included new section (§7.3.7.3) outlining the procedure for integrating the EQM Harness</u></li><li>• <u>Deleted references to EQM in §7.3.7.1 and §7.3.7.2</u></li><li>• <u>Included note in §8 regarding the stage when the various red-tag items must be removed.</u></li><li>• <u>Added RD 4</u></li></ul> |

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## Glossary

|            |  |
|------------|--|
| Cold Units | SPIRE FPU, JFP and JFS   |
| CQM        | Cold Qualification Model   |
| DCU        | Detector Control Unit  |
| DPU        | Digital Processing Unit  |
| DRCU       | SPIRE DCU and FCU, i.e the two units with interfaces with the SIH-SS |
| ESD        | Electro static Discharge   |
| FCU        | Focal plane Control Unit   |
| FPU        | Focal Plane Unit   |
| HOB        | Herschel Optical Bench   |
| JFP        | Herschel Spire JFET Photometer Module                                |
| JFS        | Herschel Spire JFET Spectrometer Module                              |
| JFET       | Junction Field Effect Transistor                                     |
| L0         | Level 0 (Zero)   |
| MSSL       | Mullard Space Science Laboratory                                     |
| OBA        | Optical Bench Assembly   |
| PFM        | Proto Flight Model   |
| RAL        | Rutherford Appleton Laboratory                                       |
| SIH-CS     | Cryogenic Cryoharness between CVV-CB and Instrument                  |
| SIH-IS     | Intermediate Cryoharness between CVV-CB and SVM-CB                   |
| SIH-SS     | SVM Cryoharness between SVM-CB and DRCU                              |
| SPIRE      | Spectral and Photometric Imaging REceiver                            |
| TBC        | To Be Confirmed  |
| Warm Units | SPIRE DPU, FCU and DCU   |
| WIH        | (SPIRE) Warm Interconnection Harness                                 |

## References

### Applicable Documents

|      |                      |  |
|------|----------------------|--|
| AD 1 | SPIRE-RAL-DOC-001132 | SPIRE warm electronics integration plan                      |
| AD 2 |                      | Obsolete   |
| AD 3 | SPIRE-RAL-DOC-000608 | SPIRE Harness Definition Document                            |
| AD 4 | SPIRE-RAL-PRC-002181 | SPIRE Warm Electronics Handling and Integration<br>Procedure |

### Reference Documents

|             |   |
|-------------|---|
| RD 1        | <i>"Making SPIRE ESD Safe - SPIRE-RAL-NOT-002028, Issue 1.0"</i>                                  |
| RD 2        | SPIRE INSTRUMENT BLOCK DIAGRAM - SPIRE-RAL-DWG-000646, Issue:<br>5.8                              |
| RD 3        | HP-2-ASED-MN-0753   |
| <u>RD 4</u> | <u><i>SPIRE-RAL-NOT-002383 "SPIRE External DCU Power Switch for EQM<br/>Testing", Issue 2</i></u> |

## 1. INTRODUCTION

The general AIT flow for the integration of the instrument (Cold Plane Units and Warm Units) is indicated in Figure 1.

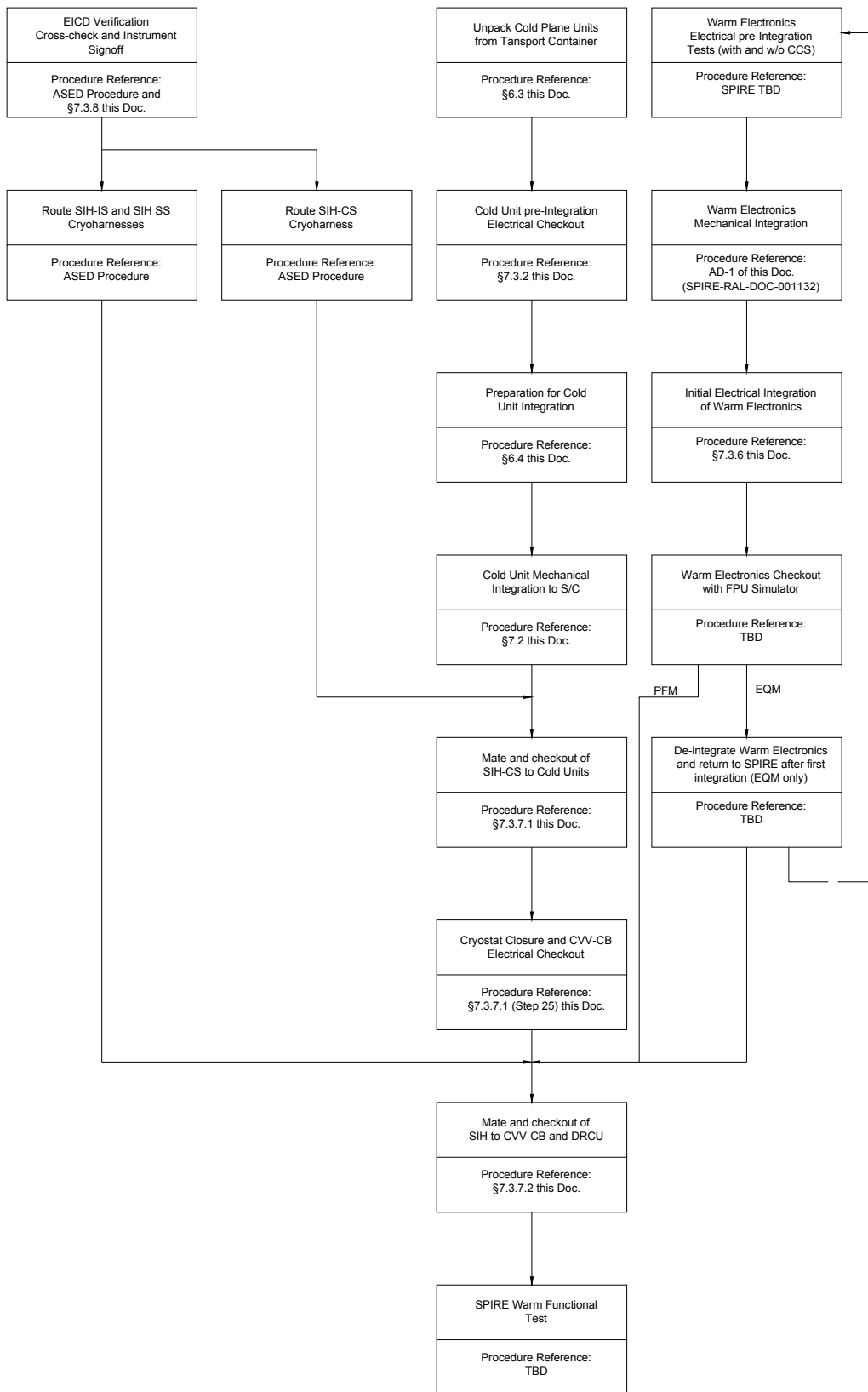


Figure 1 - General AIT Flow for the Integration of the cold plane units and the Warm Electronics to the S/C.



## 2. SCOPE

This document describes the procedures to be followed when handing the SPIRE FPU after delivery to ESA/Alcatel.

It covers the handling and integration procedures to be followed.

It covers both the CQM and PFM units

## 3. DELIVERY CONDITION

The SPIRE instrument is delivered in the following condition:-

The FPU is supplied in a dedicated, re-useable, container.

Alignment cube is fitted to the FPU. (red tag item). See section 8 for further details.

FPU aperture cover fitted (red tag item). See section 8 for further details.

Harnesses between the FPU and JFETs fitted.

FPU and JFETs attached to a baseplate.

Shorting plus or covers will be fitted to all electrical connectors See section 8 for further details.

FPU and JFETs double wrapped in polythene or lumalloy film.

Witness mirrors and/or PFO plates will be fitted to the baseplate

Silica gel moisture control devices will not be used

### 3.1 Shock recorders

Attached to the FPU baseplate, inside the transportation container are re-settable shock indicators These operate in three axis and are set to 5,10 and 25g.

Upon inspection, if any of these recorders have triggered the project team at RAL should be informed.

‘Tip and Tell’ tilt sensors are attached to the outside of the FPU container.

Upon inspection, if any of these recorders have triggered the project team at RAL should be informed

## 4. TRANSPORT

### 4.1 In dedicated experiment containers

Protect from rain and moisture.

Transport in closed vehicles only.

Protect from extremes of temperature, -10°C to +50°C, and prevent the formation of dew at any time.

### 4.2 After integration on the spacecraft (in spacecraft container)

Equivalent to Cleanroom 100 conditions

Assuming that the cryostat is closed:

FPU Aperture cover (red-tag item) shall be removed

Alignment cube (red-tag item) shall be removed

No other specific requirement.

For transport the CVV is closed, evacuated, cooled, OBA in vertical position, z-axis downwards]

## 5. STORAGE

### 5.1 In dedicated experiment container

Ensure aperture cover (red-tag item) is fitted.

Protect from rain and moisture.

Protect from extremes of temperature, 10°C to +30°C.

Alignment cube is fitted.

### 5.2 Out of container (in RR100 cleanroom, awaiting integration)

Ensure aperture cover (red-tag item) is fitted.

Alignment cube is fitted

## 6. HANDLING

### 6.1 General.

The FPU is a delicate optical instrument and should be handled with extreme care at all time.

Contamination of the optical surfaces within the instrument is prevented by the aperture cover. This cover should remain in place unless it is necessary to remove it.

**WARNING:** The bipod legs on two corners of the instrument are very thin section and easily damaged.

Care must be taken at all times not to put side loads into these items. These are at risk at all times when the FPU is not attached to a rigid plate. When it is attached to a rigid plate i.e. the HOB or its transport plate then it is tolerant of loads from vibration, lateral expansion, thermal tests, etc.

## 6.2 ESD protection

The SPIRE instrument contains very sensitive detectors that are susceptible to damage by Electro static discharge. On delivery all connectors will be protected by covers or shorting plugs as appropriate. When handling, all personnel shall wear anti static protection (wrist straps or other suitable method) When the cryoharness is not connected to the DRCU and the FPU Faraday Shield Link connected to Backshell at the warm end, then the FPU is electrically floating and prone to ESD damage.

## 6.3 Unpacking from dedicated experiment container

The FPU is supplied attached to a baseplate together with the JFETs and the JFET harness already integrated. It is bagged in polythene or lumaloy film.

To remove the FPU and JFETs from its container, the following procedure should be followed: -

In an area with a cleanliness of class 100,000 minimum, undo the eight latches that secure the container lid and remove the lid.

The protective bagging encloses the FPU, JFETs and harness and is taped to the baseplate.

Unscrew and remove the four off M8 cap head screws that secure the baseplate to the anti vibration mounts. Attach the lifting frame Ref MSSSL/5264/404 to a crane and hydra-set. Lower the lifting frame to the baseplate and attach to the eyebolts provided on the baseplate.

The FPU, JFETs and baseplate can now be lifted out of the container with a crane.

Clean bagging material and baseplate, then transport to RR100 airlock.

Remove bagging

The instrument can now enter RR100

Shorting plugs on the JFP and JFS provide ESD protection at this stage.

## 6.4 Preparation for integration

The FPU is supplied with the JFETs and associated harness already fitted.

The following tasks need to be carried out before integration onto the spacecraft.

Only standard tools are required at this stage.

### a) Fitting of JFET supports

The JFETs will be fitted to the spacecraft together with the FPU. They will need supporting during this activity.

The SPIRE supplied MGSE provides provision to support the JFETS during integration.

### b) Fitting of Lifting attachment

Fit the lifting attachment to the FPU as shown in annex A.

Attach the lifting wires to the JFETS.

### c) Alignment cube.

The FPU is supplied with the alignment cube fitted, and should be left in place until all alignment activities are complete, it can be removed and replaced within the alignment tolerances required if necessary..

### d) Thermal strap.

Remove the detector level 0 thermal strap and the Torlon support frames; leave the other two thermal straps in place

e) **Grounding strap.**

The FPU is electrically connected to the baseplate for ESD protection, this strap to be disconnected from the baseplate.

f) **Fitting of RFI tight EMI backshells**

The Herschel/SPIRE EQM cryoharness implements only a subset of the PFM cryoharness bundles for cost a schedule reasons. As a consequence, a number of open connectors are present on the SPIRE Cold Plane Units. These open connectors are to be sealed against RFI by backshells to be supplied by ASED. This activity is to be carried out at this stage providing that the extra length of backshell does not cause a mechanical interference during the integration of the instrument onto the OBA.

g) **Removal from baseplate**

**WARNING:** The bipod legs on two corners of the instrument are very thin section and easily damaged. Care must be taken at all times not to put side loads into these items. These are at risk at all times when the FPU is not attached to a rigid plate.

Undo the five M4 fasteners which secure the Photometer JFET rack (HSJP) (8 JFETs) to the baseplate. Leave the screws in position as they cannot be removed from the JFET rack.

Undo the four M4 fasteners that secure the Spectrometer JFET rack (HSJS) (2 JFETs) to the baseplate. Note that two of these fasteners are studs with nuts on the top, the nuts should be removed and the studs left in place.

The two remaining L0 straps are also secured to the baseplate. To release these from the baseplate, undo the 4 off M4 fasteners on each strap and remove the fasteners. NOTE. The undersides of these straps form the thermal interface to the spacecraft helium tank pods. Their surfaces are flat and soft gold plated, these surfaces can easily be damaged and the thermal performance of the instrument may suffer as a result.

Unbolt the cone from the FPU by undoing the M8 nut, thus leaving the cone on the baseplate.

Undo and remove the 8 fasteners on the blade mounts that attach the FPU to the baseplate.

The FPU and JFETs can now be lifted from the baseplate.

Undo and remove the FPU cone from the baseplate and re-attach it onto the Optical Bench. Note: there are special washers (part number A3/5264/302-3) under the head of each screw and also Vespel insulating bushes (A3/5264/302-2) either side of the mounting flange.

Torque the screws to 8.1 Nm. +/- 10% above running torque

The FPU and JFETs are now ready for integration.

Note: All screws that interface to the spacecraft are metric threads.

## 6.5 Preparation for packing

All units should be wrapped in clean film and replaced in their transit containers. The FPU should be refitted to its baseplate using the following procedure:

Assuming activities described in section 6.3 have been carried out, and the FPU and JFETs are supported on a crane, with the FPU mounting cone still attached to the optics bench.

Remove the cone mount from the spacecraft optics bench

Fix the cone to the SPIRE baseplate using the four M6x21 cap head screws. Note: there are special washers (part number A3/5264/302-3) under the head of each screw and also Vespel insulating bushes (A3/5264/302-2) either side of the mounting flange.

Torque the screws to 8.1 Nm. +/- 10% above running torque.

The Spectrometer JFET studs (2 off) as indicated on interface drawing 0-KE-0104-360. Should still be fitted to the baseplate

Lift the FPU and JFETs using the lifting gear as described in section 6.

Very gently lower the assembly onto the baseplate, ensuring that the JFET studs engage on the JFETs and the cone mount engages in its location on the FPU.

NOTE: the cone is very thin walled section and large moments can be applied if the FPU is not lowered with its interface plane parallel to the baseplate

When all units are resting on the baseplate, fit the attachment screws (M6X21) to the bipod feet as for the cone mount, torque the screws to 8.1 Nm. +/- 10% above running torque.

Fit the M8 nut and Belleville washer to the mounting cone. Torque to 8.25 Nm. +/- 10% above running torque.

Remove the lifting/handling fixture.

Fit the two long bolts and two nuts to secure the spectrometer JFET. Torque the screws to 2.1 Nm. +/- 10% above running torque.

Fit the 5 long bolts to secure the photometer JFET. Torque the screws to 2.1 Nm. +/- 10% above running torque.

Secure the L0 straps to the baseplate using M4X20 socket head cap screws. Torque the screws to 1.5 Nm. +/- 10% above running torque.

Fit the electrical grounding strap between the FPU and the baseplate.

Cover the FPU and JFETs with a double layer of clean polythene or lumaloy film and secure each one with tape to the baseplate.

Fit the lifting frame Ref MSSSL/5264/404 to the four eyebolts in the plate.

## 6.6 Packing in containers.

Fit guide pins onto anti vibration mounts.

Lift the plate into the container.

Remove lifting frame.

Remove guide pins from anti vibration mounts

Secure baseplate to the anti-vibrations mounts in the floor of the transit container.

Fit container lid.

## 7. INTEGRATION

### 7.1 Required tools/MGSE

SPIRE supplied tools/MGSE:-

FPU and JFET handling frame.

FPU/JFET/baseplate lifting gear

JFET fixation hardware

Isolation washers, special screws and studs

L3 pressure plates 2-off

L1 strap screws M8 2off, M3 4off (these screws will be prepared for wire locking)

Wire for locking above screws.

L1 bushes for the vent line end

Temporary FPU Grounding Strap including M4 x 6mm fastener to connect to OBA

Supplied by spacecraft

NOTE, Could possibly be attached to the unused harness support bracket holes, or any other convenient tapped hole.

Crane, with Hydraset

Fixation bolts,

FPU M6 12 off -

L0 straps M4 16 off -

L0 pressure plate 4 off

L3 strap M4 4off

Torque wrench to cover 1.5 to 8.25 Nm

Allan key, spanners etc

DVM for electrical isolation testing

## 7.2 Mechanical integration to spacecraft

### FPU and JFETs

Assuming activities described in section 6 have been carried out, and the FPU and JFETs are supported on a crane.

Fix the cone to the SPIRE baseplate using the four M6x21 cap head screws. Note: there are special washers (part number A3/5264/302-3) under the head of each screw and also Vespel insulating bushes (A3/5264/302-2) either side of the mounting flange.

Torque the screws to 8.1 Nm. +/- 10% above running torque.

Fix the Spectrometer JFET studs (2 off) as indicated on interface drawing 0-KE-0104-360. Note these should be screwed into the HOB until 45mm of stud are protruding from the surface.

Lift the FPU and JFETs using the lifting gear as described in section 6.

Very gently lower the assembly onto the HOB, ensuring that the JFET studs engage on the JFETs and the cone mount engages in its location on the FPU.

The flexible ends of the L0 straps are unsupported at this stage and will need to be guided by hand into place as the FPU is lowered

NOTE: the cone is very thin walled section and large moments can be applied if the FPU is not lowered with its interface plane parallel to the HOB

When all units are resting on the HOB, fit the attachment screws (M6X21) to the bipod feet as for the cone mount.

Fit the two Bellville washers and the M8 Kaylock nut to the cone mount. Torque to 8.25Nm.

Remove the lifting/handling fixture.

### L0 straps

- The cooler pump and evaporator straps

These will be in place at this stage.

Ensure that the lower flexibles of these two straps align with the pod interfaces. Fit the attachment screws (ten M4 For the evaporator strap, six M4 screws for the pump)

Torque to specification defined by Astrium

- Detector strap

The light baffle, upper flexible strap should already be in place on the FPU.

Fit the Torlon support frames.

Move the level 0 main strap into place and align the dowel holes (see Assembly drawing 5264/309).

Push in Dowels and ensure that the flexibles are aligned.

Place the cold strap support clamp plates over the top.

Fit the four 4-40 UNC fixings to the cold strap support clamp plates to secure the main strap. Torque to 0.76 Nm. +/- 10% above running torque.

Ensure that the lower flexibles align with the pod interface. Fit the six M4 attachment screws . Torque in accordance with Astrium specification.  
Fit the joining plates of the main supports to the joining plates of the upper flexibles, using eight 4-40 UNC bolts and Kaylock nuts. Torque to 0.76 Nm. +/- 10% above running torque

**L1 straps.**

Fit the two L1 straps to the FPU using at each location, one Bellville washer type B0750-056-S and one M8 bolt, torque to 10.5 Nm +/- 10% above running torque. And two M4 bolts and two Bellville washers (type B0375-020-S) under each screw head. Torque to 1.5 Nm +/- 10% above running torque. On final assembly the M8 fasteners to be wire locked to the M4 fasteners. Screws will be prepared for wire locking

**L3 straps.**

Fit the two L3 straps to the JFETs using the attachment hardware (L3 thermal strap clamp provided by SPIRE) as shown in interface drawings 0-KE-0104-350 and 0-KE-0104-360. Torque to 2.5 Nm.  
Note. Spacecraft temperature sensors, two sensors on each clamp, fit to this interface.

**Isolation test**

Measure and record the electrical isolation between the chassis of the FPU and the cryostat. Reading should be more than 1 M $\Omega$ . Fix the temporary grounding strap from the FPU to the OBA. Repeat the measurement of the resistance between the cryostat and the FPU to ensure that grounding has been successful, reading should be less than 3 $\Omega$

**7.3 Electrical integration****7.3.1 General**

Several subsystems with the SPIRE FPU are ESD sensitive and especially vulnerable during the integration process. All normal precautions shall be taken when handling the FPU especially when open connectors are present. This includes the wearing of a correctly terminated ESD wrist strap (or equivalent) whilst carrying out any handling operation of the Cold Plane Units or Warm Electronics.

The sequence of the integration is to follow Figure 1.

**7.3.2 Cold Units pre-Integration Electrical Checkout**

The MDM connectors on the FPU, JFP and JFS are probed with a DVM to verify the correct ground isolation and critical signal isolation exists. The connectors are to be cross checked against the SPIRE Harness Definition Document (AD-3). The functions to be checked are outlined in Table 7-1.

| Unit | Function  |
|------|---|
| FPU  | P-Cal Impedance, S-Cal Impedance, BSM Impedances, SMEC Impedances, Thermistor Impedances, Cooler Impedances |
| JFP  | Photometer analogue ground isolation, JFET Bias, JFET Heater Bias and Bolometer Bias Impedances             |
| JFS  | Spectrometer analogue ground isolation, JFET Bias, JFET Heater Bias and Bolometer Bias Impedances           |

**Table 7-1 Cold unit electrical interface verification**

### 7.3.3 Cryo-harness Cross talk checks (now obsolete)

No cross-talk test will be carried out on the S/C Cryoharness as a part of the instrument integration.

### 7.3.4 Cryo-Harness grounding check

#### 7.3.4.1 For PFM

Requisites:

1. The SIH-CS has been routed from the CVV-CB to the location of the I/Fs with SPIRE
2. SPIRE Cold Plane Units have not been integrated onto the OBA

Before any electrical integration of the SPIRE FPU a check of the grounding within the cryoharness shall be carried out. This must verify that the FPU Faraday shield<sup>1</sup> is isolated from the chassis of the CVV/SVM. when the Cold SIH, the Intermediate SIH and the Warm SIH are routed on the S/C but not mated with either the focal plane units or the SVM units. To verify this, it may be necessary to temporarily isolate the unmated cryoharness connectors backshells of the cold units from the CVV. To achieve this, the connector backshells are to be temporarily placed inside plastic bags.

For each of the Cryoharnesses listed in Table 7-2, the isolation between the specified pin on the outside of the CVV-CB and the chassis of the cryostat is to be greater than 5M $\Omega$ .

Note: The CB312300 J01 and J02 (Mechanism Launch Latch confirm) must be removed prior to carrying out this verification and replaced at the end of the test.

| Cryoharness | Applicability | Pin |
|-------------|---------------|-----|
| C1          | EQM and PFM   | 5   |
| C2          | PFM           | 1   |
| C3          | EQM and PFM   | 2   |
| C4          | PFM           | 1   |
| C5          | PFM           | 1   |
| C6          | EQM and PFM   | 1   |
| C7          | PFM           | 1   |
| C8          | PFM           | 1   |
| C9          | PFM           | 1   |
| C10         | EQM and PFM   | 1   |
| C11         | EQM and PFM   | 1   |
| C12         | PFM           | 1   |
| C13         | PFM           | 1   |

**Table 7-2 - Cryoharness grounding isolation check.**

<sup>1</sup> The FPU Faraday Shield is fully explained in the SPIRE Harness Definition Document, SPIRE-RAL-PRJ-000608, Issue 1.1, 05/03/03.



**7.3.4.2 For EOM****Requisites:**

1. SIH-SS, SIH-IS and SIH-CS has been integrated, routed and connected together at the CVV-CB and the SVM-CB
2. The Backshells of the FPU and the JFP/JFS connectors are electrically isolated from the spacecraft
3. SIH-CS has not been mated to the FPU
4. SIH-SS has not been mated to the DRCU

The isolation of the FPU Faraday Shield is to be verified sequentially for each of the following harnesses according to the procedure outlined below.

The isolation is to be greater than 5MΩ.

| <u>Cryoharness</u> | <u>Method</u>  |
|--------------------|--|
| <u>C1</u>          | <u>Remove the FPU Faraday shield jumper from DCU P27, P28, P31 and P32 and measure the resistance between the FPU Faraday Shield Link and the backshell of the connector</u><br><br><u>Un-mate 312200 SVM-CB P06 from 312200 J06</u><br><br><u>Mate a 128-Way break-out-box to 312200 J06 and measure the resistance between Pin 5 and S/C Chassis</u>   |
| <u>C3</u>          | <u>Remove the FPU Faraday shield jumper from DCU P29 and P30 and measure the resistance between the FPU Faraday Shield Link and the backshell of the connector</u><br><br><u>Un-mate 312100 SVM-CB P04 from 312100 J04</u><br><br><u>Measure the resistance between Pin 5 of 312200 J04 and S/C Chassis (This should now be O/C)</u><br><br><u>Demate the 128-Way Break-out Box from 312100 J06 and mate it to 312200 J04</u><br><br><u>Measure the resistance between Pin 5 of 312100 P04 and S/C Chassis. This should now be O/C</u> |
| <u>C6</u>          | <u>Remove the FPU Faraday shield jumper from DCU P14, P15 and P16 and measure the resistance between the FPU Faraday Shield Link and the backshell of the connector</u>  |
| <u>C10</u>         | <u>Remove the FPU Faraday shield jumper from FCU P11, P23 and P25 (PLW LIA LIAs) and measure the resistance between the FPU Faraday Shield Link and the backshell of the connector</u>   |
| <u>C11</u>         | <u>Remove the FPU Faraday shield jumper from FCU P13, P17, P19, P21 and P29</u>  |

|            |  |
|------------|--|
|            | <u>and measure the resistance between the FPU Faraday Shield Link and the backshell of the connector</u> |
| <u>C1</u>  | <u>Mate 312200 P06 to J06. Re-connect FPU Faraday Shield Link</u>  |
| <u>C3</u>  | <u>Remove breakout box from 312100 P04 and re-mate to J04. Re-connect FPU Faraday Shield Link</u>        |
| <u>C6</u>  | <u>Re-connect FPU Faraday Shield Links</u>   |
| <u>C10</u> | <u>Re-connect FPU Faraday Shield Links</u>   |
| <u>C11</u> | <u>Re-connect FPU Faraday Shield Links</u>   |

### 7.3.5 Warm electronics mechanical integration

Before any electrical integration of the SPIRE FPU, the warm electronics shall be integrated according to the warm electronics integration procedure. AD 4.

### 7.3.6 Initial electrical integration of Warm Electronics

Requisites:

1. The Warm Electronics have completed their pre-Integration tests with the Instrument and PLM EGSE
2. The Warm Electronics have been mechanically integrated to the SVM according to AD-1

| Step | Applicability | Activity   |
|------|---------------|--|
| 1    | EQM and PFM   | Connect grounding strap from the DPU to the SVM  |
| 2    | EQM and PFM   | Measure and record the resistance between the chassis of the DPU and the SVM and verify that it is less than 10mΩ.                                     |
| 3    | EQM and PFM   | Connect grounding strap from the DCU to the SVM  |
| 4    | EQM and PFM   | Measure and record the resistance between the chassis of the DCU and the SVM and verify that it is less than 10mΩ.                                     |
| 5    | EQM and PFM   | Connect grounding strap from the FCU to the SVM  |
| 6    | EQM and PFM   | Measure and record the resistance between the chassis of the FCU and the SVM and verify that it is less than 10mΩ.                                     |
| 7    | EQM           | Route and secure W1, W3 and W5 to SVM attachment points. Remove and store connector covers   |
| 8    | PFM           | Route and secure W1 through W6 to SVM attachment points. Remove and store connector covers   |
| 9    | EQM           | Remove and store the connector covers from DPU J07, J08 and J09 then mate W1, W3 and W5 to J07, J08 and J09  |
| 10   | PFM           | Remove and store the connector covers from DPU J07 through J12 then mate W1 through W6 to DPU J07 through J12  |
| 11   | EQM           | Remove and store connector covers from FCU J01, FCU J03 and DCU J01 and mate W1, W3 and W5   |
| 12   | PFM           | Remove and store connector covers from FCU J01 through J04, DCU J01 and DCU J02 then mate W1 through W6  |
| 13   | EQM           | Remove and store connector covers from FCU J31, FCU J35 and DCU J03. Route EGSE Bench power supply harnesses and mate to FCU J31, FCU J35 and DCU J03. |
| 14   | PFM           | Route and secure W7 and W8 to SVM. Remove and store connector  |

|    |     |   |
|----|-----|---|
|    |     | covers for FCU J07 and J08. Remove and store connector covers for DCU J03 and J04. Remove and store connector covers from W7 and W8 then mate firstly to the appropriate FCU then DCU connectors.                                       |
| 15 | PFM | Route and secure Prime DPU primary power harness from DPU LCL. Remove and store harness connector covers. Remove and store connector cover from DPU J01. Mate harness to LCL connector then to DPU J01.                                 |
| 16 | PFM | Route and secure Prime and Redundant DPU primary power harness from DPU LCL. Remove and store harness connector covers. Remove and store connector covers from DPU J01 and J02. Mate harness to LCL connectors then to DPU J01 and J02. |
| 17 | EQM | Route and secure S/C 1553 bus harnesses. Remove and store DPU P03, J03, J04 and P04 connector covers  |

### 7.3.7 Electrical Connection (Mating of DRCU and Cold Plane Units)

When delivered, the JFET units will be fitted with safeing plugs (Type-III See RD 1) on the MDM 37 bias connectors on JFS and JFP. Covers will be present to protect the open MDM 25P detector connectors and the MDM 37S Subsystem connectors. These should be left in place during the mechanical integration.

NOTE: This order of connection must be maintained to protect the sensitive electronics in the SPIRE FPU and warm electronics.

It is not planned to use connector savers on the cold end of the cryo-harness as multiple insertions are not expected.

#### 7.3.7.1 Connection of Internal Cryoharness (SIH-CS) to SPIRE Cold Plane Units

Requisites:

1. External cryoharness is not connected to the CVV vacuum connectors (CVV-CB)
2. JFP and JFS have Type-III Safeing plugs connected.
3. Cryoharness is routed within cryostat but not mated to instrument
4. The Cold Units are mechanically integrated onto the OBA
5. FPU Grounding Strap shorts FPU Chassis to the OBA

| Step Number  | Applicability          | Activity  |
|--------------|------------------------|---|
| <del>1</del> | <del>EQM only</del>    | <del>Install RFI tight backshells on any remaining open connectors on FPU, JFP and JFS</del>  |
| 2            | PFM only               | Mate the 128-way safeing plug for harnesses C11 and C13 (SPIRE Type-VIII) to the mating connector on the outside of the CVV (CVV-CB P29 and CVV-CB P30) |
| <del>3</del> | <del>EQM only</del>    | <del>Connect the cryo-harness C10 and C11 to connectors J19, J21, J23, J25, J27 and J29 to the FPU.</del>   |
| 4            | PFM only               | Connect the cryo-harness C10, C11, C12 and C13 to connectors J19 through J30 to the FPU.  |
| 5            | <del>EQM and</del> PFM | Mate the 128-way safeing plug for C1 (SPIRE Type-VI) to the mating connector on the outside of the CVV (CVV-CB P32)                                     |
| 6            | <del>EQM and</del> PFM | Mate the 128-way safeing plug for harnesses C3 (SPIRE Type-V) to the mating connector on the outside of the CVV (CVV-CB P26)                            |

| Step Number   | Applicability              | Activity  |
|---------------|----------------------------|---|
| <del>7</del>  | <del>EQM only</del>        | <del>Remove the Type-III safeing plugs from JFP J27</del>   |
| 8             | PFM only                   | Remove the Type-III safeing plugs from JFP J25 and J27  |
| 9             | <del>EQM and</del> PFM     | Mate JFP P25 and JFP P27 to JFP J25 and JFP J27   |
| <del>10</del> | <del>EQM only</del>        | <del>Remove the Type-III safeing plugs from JFP J28</del>   |
| 11            | PFM only                   | Remove the Type-III safeing plugs from JFP J26 and J28  |
| 12            | <del>EQM and</del> PFM     | Mate JFP P26 and JFP P28 to JFP J26 and JFP J28   |
| 13            | PFM only                   | Remove the Type-III safeing plug from JFS J09   |
| 14            | <del>EQM and</del> PFM     | Mate JFS P09 to JFS J09   |
| 15            | PFM only                   | Remove the Type-III safeing plug from JFS J10   |
| 16            | <del>EQM and</del> PFM     | Mate JFS P10 to JFS J10   |
| <del>17</del> | <del>EQM only</del>        | <del>Mate 128-way safeing cover for C6 (SPIRE Type-VII) to CVV-CB P24</del>   |
| 18            | PFM only                   | Mate 128-way safeing cover for C2, C4, C5, C6, C7, C8 and C9 (SPIRE Type-VII) to CVV-CB P31, P22, P23, P24, P25, P27 and P28  |
| <del>19</del> | <del>EQM only</del>        | <del>Mate JFP P13, P14, P15 and P16 to JFP J13, J14, J15 and J16</del>  |
| 20            | PFM only                   | Mate JFP P01 through P24 to JFP J01 through J25   |
| <del>21</del> | <del>EQM only</del>        | <del>Mate JFS P05 and P06 to JFS J05 and J06</del>  |
| 22            | PFM only                   | Mate JFS P01 through P24 to JFS J01 through J07   |
| 23            | <del>EQM and</del> PFM     | Remove red-tag FPU grounding strap  |
| 24            | <del>EQM and</del> PFM     | During the final closure of the cryostat, the remaining red-tag items are to be removed from the cold plane units   |
| 25            | <del>EQM</del><br>PFM(TBD) | Using two ASED provided Break-out boxes and SPIRE provided EGSE, the grounding configuration electrical interface will be probed at the 128-Way CVV-CB <sup>2</sup> |

After this stage has been carried out, the cold plane instrument is safe from an ESD point of view. The Cryostat can be closed (provided Cold Plane Red-tag Items have been removed!) and transported from one establishment to another.

#### 7.3.7.2 Connection of SVM Cryoharness (SIH-SS) to SPIRE DRCU and SIH-IS to CVV-CB

Requisites:

- External cryoharness (SIH-IS and SIH-SS) is routed but not connected to the CVV vacuum connectors
- The SIH-IS and SIH-SS Cryoharnesses are mated at the SVM-CB<sup>3</sup>
- The SIH-CS is connected to the instrument
- The SIH-IS is not connected to the CVV-CB

This part of the electrical integration carries out the following activities:

- Verification of the correct grounding configuration of the Cold Plane Units and the Cryoharness

<sup>2</sup> This step is required during the EQM programme as the SIH-CS will be in

<sup>3</sup> Providing that SIH-IS is not connected to the CVV-CB and that the SIH-SS is not mated with the DRCU, the SIH-IS and SIH-SS can be mated in no particular order without any particular ESD precautions.

- Partial verification of critical electrical interfaces between the cryoharness and the Cold Plane Units
- Safe mating of the cold plane units and the DRCU

See Table 7-3 for procedure details.

| Step  |  | Activity  | Notes  | Applicability  |     |
|-------|--|---|--|----------------|-----|
|       |  |   |  | EQM            | PFM |
| 1.1   | Prepare cryoharness DRCU connector backshells            | Remove inspection covers from cryoharness backshells (DCU J05 to J32 and FCU J11, J12, J13, J14, J17, J18, J19, J20, J21, J22, J23, J24, J25, J26, J29 and J30) |  | <del>No</del>  | Yes |
| 1.2   |  | Remove inspection covers from cryoharness backshells (DCU J14, J15, J16, J29, J30, J31, J32 and FCU J11, J13, J17, J19, J21, J23, J25 and J29)                  |  | <del>Yes</del> | No  |
| 1.3   |  | Break and electrically isolate all the FPU Faraday Shield Link connection to the DRCU backshells  |  | <del>Yes</del> | Yes |
| 2.1.1 | Connect cryogenic Phot Analogue grounds to DRCU via LIAs | Mate SIH-SS-06 P14, P15 and P16 to DCU J14, J15 and J16   |  | <del>Yes</del> | Yes |
| 2.1.2 |  | Remove SPIRE Safeing Plug Type-VII from CVV-CB J24  |  | <del>Yes</del> | Yes |
| 2.1.3 |  | Mate SIH-IS-06 P24 to CVV-CB J24  | PLW Analogue ground connected to cold end via detector harness. JFETs connected to analogue ground via ESD resistors | <del>Yes</del> | Yes |
| 2.2.1 |  | Mate SIH-SS-09 P05, P06 and P07 to DCU J05, J06 and J07   |  | <del>No</del>  | Yes |
| 2.2.2 |  | Remove SPIRE Safeing Plug Type-VII from CVV-CB J28  |  | <del>No</del>  | Yes |
| 2.2.3 |  | Mate SIH-IS-09 P28 to CVV-CB J28  | PSW Analogue ground connected to cold end via detector harness. JFETs connected to analogue ground via ESD resistors | <del>No</del>  | Yes |

| Step  |   | Activity  | Notes   | Applicability |     |
|-------|---|---|---|---------------|-----|
|       |   |   |   | EQM           | PFM |
| 2.3.1 |   | Mate SIH-SS-04 P20, P21 and P22 to DCU J20, J21 and J22   |   | No            | Yes |
| 2.3.2 |   | Remove SPIRE Safeing Plug Type-VII from CVV-CB J22  |   | No            | Yes |
| 2.3.3 |   | Mate SIH-IS-04 P22 to CVV-CB J22  | PMW Analogue ground connected to cold end via detector harness. JFETs connected to analogue ground via ESD resistors                      | No            | Yes |
| 3.1   | Connect cryogenic Phot Analogue grounds to Bias harness | Mate SPIRE Safeing Plug Type-IX to SIH-SS-03 P30  |   | Yes           | Yes |
| 3.2   |   | Remove SPIRE Safeing Plug Type-V from CVV-CB J26  |   | Yes           | Yes |
| 3.3   |   | Mate SIH-IS-03 P26 to SVM-CB J26  | PLW, PMW and PSW Analogue grounds connected to cold end via terminated bias harness. JFETs connected to analogue ground via ESD resistors | Yes           | Yes |
| 4.1   | Remove Phot harness connections to DCU                  | Demate:<br>SIH-SS-C6 P14, P15 and P16 from DRCU.<br>Place connector dust caps over contacts   |   | Yes           | No  |
| 4.2   |   | Demate:<br>SIH-SS-C6 P14, P15 and P16 from DRCU.<br>SIH-SS-C9 P05, P06 and P07 from DRCU<br>SIH-SS-C4 P20, P21 and P22 from DRCU<br>Place connector dust caps over contacts |   | No            | Yes |

| Step |  | Activity   | Notes  | Applicability |     |
|------|--|--|--|---------------|-----|
|      |  |  |  | EQM           | PFM |
| 5.0  | Mate remaining Phot. Harnesses           | Mate:<br>SIH-IS-05 P23 to CVV-CB J23<br>SIH-IS-07 P25 to CVV-CB J25<br>SIH-IS-08 P27 to CVV-CB J27 | All Phot harnesses mated to CVV-CB but not connected to DRCU.<br>Safeing plug on SIH-C3-P30 keeping entire Phot cryo system safe!                                | No            | Yes |
| 6.1  | Confirmation of Phot Harnesses grounding | Measure isolation of FPU Faraday shield on SIH-SS-P29 from connector backshell                     | Correct configuration of FPU faraday shield confirmed for Phot harnesses   | Yes           | Yes |
| 6.2  |  | Remove SPIRE Safeing plug Type-IX from SIH-SS-03-P30   | SPIRE is temporarily ESD vulnerable  | Yes           | Yes |
| 6.3  |  | Measure isolation of Pins 21, 30 and 78 of SIH-SS-03 P30 from connector backshell.                 | Isolation test to be carried out with a DVM. The common terminal to be connected firstly to backshell of P30. The measure probe is then used on the pin contacts | Yes           | Yes |
| 6.4  |  | Mate SPIRE Safeing Plug Type-IX to SIH-SS-03 P30   | SPIRE is ESD safe  | Yes           | Yes |
| 7.1  | Safe mating of Spect harnesses to CVV-CB | Mate SPIRE Safeing Plug Type-X to SIH-SS-01 P32  |  | Yes           | Yes |
| 7.2  |  | Remove SPIRE Safeing plug Type-VII from CVV-CB-J31   |  | No            | Yes |
| 7.3  |  | Mate SIH-SS-02 P23, P24, P26 and P26 to DRCU J23, J24, J25 and J26                                 |  | Yes           | Yes |
| 7.4  |  | Mate SIH-IS-02 P31 to CVV-CB J31   | SSW (and SLW!) analogue grounds connected to DRCU Spec Analogue ground plane   | No            | Yes |
| 7.5  |  | Remove SPIRE Safeing plug Type-VI from CVV-CB-J32  |  | No            | Yes |
| 7.6  |  | Mate SIH-IS-01 J32 to CVV-CB P32   |  | Yes           | Yes |
| 7.7  |  | Demate:<br>SIH-SS-C02 P23, P24, P24 and P26 from DRCU  |  | Yes           | Yes |



|      |  |   |  |     |     |
|------|--|---|--|-----|-----|
| 8.1  | Confirmation of Spect Harnesses          | Measure isolation of FPU Faraday shield on SIH-SS-01 P31 from connector backshell                   | Correct configuration of FPU faraday shield confirmed for Spect harnesses  | Yes | Yes |
| 8.2  |  | Remove SPIRE Safeing plug Type-X from SIH-SS-03-P32   | SPIRE is temporarily ESD vulnerable  | Yes | Yes |
| 8.3  |  | Measure isolation of Pins 6 and 12 of SIH-SS-01 P32 from connector backshell.                       | Isolation test to be carried out with a DVM. The common terminal to be connected firstly to backshell of P32. The measure probe is then used on the pin contacts | Yes | Yes |
| 8.4  |  | Mate SPIRE Safeing Plug Type-IX to SIH-SS-03 P30  | SPIRE is ESD safe  | Yes | Yes |
| 9.1  | Connection of S/S Harness to CVV-CB      | Mate SIH-IS-10 P32 to CVV-CB J32  | Check critical impedances up cryoharness towards Cold Plane Units with DVM   | Yes | Yes |
| 9.2  |  | Remove SPIRE Safeing Plug Type VIII from CVV-CB J30   |  | Yes | Yes |
| 9.3  |  | Mate SIH-IS-11 P30 to CVV-CB J30  | Check critical impedances up cryoharness towards Cold Plane Units with DVM   | Yes | Yes |
| 9.4  |  | Mate SIH-IS-12 P33 to CVV-CB J33  | Check critical impedances up cryoharness towards Cold Plane Units with DVM   | No  | Yes |
| 9.5  |  | Remove SPIRE Safeing Plug Type VIII from CVV-CB J29   |  | No  | Yes |
| 9.6  |  | Mate SIH-IS-13 P29 to CVV-CB J29  | Check critical impedances up cryoharness towards Cold Plane Units with DVM   | No  | Yes |
| 10.1 | Confirmation of Phot Harnesses grounding | Measure isolation of FPU Faraday shield on SIH-SS-01 P31 from connector backshell                   | Correct configuration of FPU faraday shield confirmed for FPU Subsystem harnesses  | Yes | Yes |
| 11.1 |  | Connect the FPU Faraday Shield link to all the SIH-SS harnesses and re-install the connector covers |  | Yes | Yes |

|       |   |  |   |     |     |
|-------|---|--|---|-----|-----|
| 12.1  | Final connection of Photometer and Spectrometer Bias and Detector output channels | Mate SIH-SS-03 P29 to DCU J29                                      |   | Yes | Yes |
| 12.2  |   | Demate SPIRE Safeing Plug Type-IX from SIH-SS-03 J30               |   | Yes | Yes |
| 12.3  |   | Mate SIH-SS-03 P30 to DCU J30                                      | Check analogue ground and critical impedances up cryoharness towards Cold Plane Units | Yes | Yes |
| 12.4  |   | Mate SIH-SS-01 P31 to DCU J31                                      |   | Yes | Yes |
| 12.5  |   | Demate SPIRE Safeing Plug Type-X from SIH-SS-01 J32                |   | Yes | Yes |
| 12.6  |   | Mate SIH-SS-01 P32 to DCU J32                                      | Check analogue ground and critical impedances up cryoharness towards Cold Plane Units | Yes | Yes |
| 12.7  |   | Mate SIH-SS-04 P20, P21 and P22 to DCU J20, J21 and J22            | Idem  | No  | Yes |
| 12.8  |   | Mate SIH-SS-05 P17, P18 and P19 to DCU J17, J18 and J19            | Idem  | No  | Yes |
| 12.9  |   | Mate SIH-SS-06 P14, P15 and P16 to DCU J14, J15 and J16            | Idem  | Yes | Yes |
| 12.10 |   | Mate SIH-SS-07 P11, P12 and P13 to DCU J11, J12 and J13            | Idem  | No  | Yes |
| 12.11 |   | Mate SIH-SS-08 P08, P09 and P10 to DCU J08, J09 and J10            | Idem  | No  | Yes |
| 12.12 |   | Mate SIH-SS-09 P05, P06 and P07 to DCU J05, J06 and J07            | Idem  | No  | Yes |
| 12.13 |   | Mate SIH-SS-01 P32, P27 and P28 to DCU J32, J27 and J28            | Idem  | Yes | Yes |
| 12.14 |   | Mate SIH-SS-02 P23, P24, P26 and P26 to DRCU J23, J24, J25 and J26 | Idem.<br>Phot and Spect detectors fully connected to DRCU                             | No  | Yes |

|      |  |   |  |                |     |
|------|--|---|--|----------------|-----|
| 13.1 | Final Connection of Cryoharness to FCU | Mate SIH-SS-10 P11, P23 and P25 to FCU            |  | <del>Yes</del> | Yes |
| 13.2 |  | Mate SIH-SS-11 P13, P17, P19, P21 and P29 to FCU  |  | <del>No</del>  | Yes |
| 13.3 |  | Mate SIH-SS-11 P13 and P29 to FCU                 |  | <del>Yes</del> | No  |
| 13.4 |  | Mate EGSE harnesses to SIH-SS-11 P17, P19 and P29 |  | <del>Yes</del> | No  |
| 13.5 |  | Mate SIH-SS-13 P12, P24 and P26 to FCU            |  | <del>No</del>  | Yes |
| 13.6 |  | Mate SIH-SS-12 P14, P26, P20, P22and P30 to FCU   |  | <del>No</del>  | Yes |

**Table 7-3 Sequence for the mating of the cold units and the warm units via the cryoharness**

#### 7.3.7.3 EOM Harness Integration Procedure

##### Requisites:

1. External cryoharness (SIH-IS and SIH-SS) is routed and mated to the CVV vacuum connectors
2. The SIH-IS and SIH-SS Cryoharnesses are mated at the SVM-CB
3. The SIH-CS is routed in the cryostat and but not mated to the instrument
4. The FPU is mechanically integrated to the Herschel Optical Bench
5. The Warm Units are mechanically integrated to the SVM
6. The Cryoharness grounding Check has been completed (c.f. §7.3.4)

When mating a connector any stray charge on the contacts is to be neutralised by utilizing either a Air Ionizer or other suitable technique.

When mating connectors to the FPU/JFP/JFS, a Break-out Box shall be mated to the connector to verify a “safe to mate” condition for all contacts.

| <u>Step</u> | <u>Activity</u>   |
|-------------|---|
| <u>1</u>    | <u>Integrate external DCU Power Switch (as described in RD4). The switch is to be in the “On” position when this operation is being carried out</u> |
| <u>2</u>    | <u>Mate HSDCU 12230 P29 to the external power switch connector. (Phot Bias Prime)</u>   |
| <u>3</u>    | <u>Remove safeing plug from JFP 121210 J25 (PSW Prime)</u>  |
| <u>4</u>    | <u>Mate HSJFP 121210 P25 to J25 (PSW Prime)</u>   |
| <u>5</u>    | <u>Mate HSDCU 122300 J30 with P30 (Bias Red.)</u>   |
| <u>6</u>    | <u>Remove safeing plug from JFP J26 (PSW Red.)</u>  |
| <u>7</u>    | <u>Mate HSJFP 121210 P26 to J26 (PSW Red.)</u>  |
| <u>8</u>    | <u>Remove safeing plug from JFP J27 (PLW/PMW Prime)</u>   |
| <u>9</u>    | <u>Mate HSJFP 121210 P27 to J27 (PLW/PMW Prime)</u>   |
| <u>10</u>   | <u>Remove safeing plug from JFP J28 (PLW/PMW Red)</u>   |
| <u>11</u>   | <u>Mate HSJFP 121210 P28 to J28 (PLW/PMW Red)</u>   |
| <u>12</u>   | <u>Mate HSDCU 122300 P14, P15 and P16 with J14, J15 and J16</u>   |
| <u>13</u>   | <u>Mate HSJFP 121210 P13, P14, P15 and P16 to J13, J14, J15 and J16</u>   |
| <u>14</u>   | <u>Mate HSFCU 122200 P11, P13, P17, P19, P21, P23, P25 and P29 with J11, J13, J17, J19, J21, J23</u>  |
| <u>15</u>   | <u>Remove the grounding strap between the FPU and the OBA</u>   |

### 7.3.8 SIH EICD Cross-check and Instrument Sign-off

For EQM: This cross-check of the SIH EICD involves the connection of the ASED harness checkout EGSE to the SPIRE instrument test cryoharness which has been programmed according to the SIH EICD.

ASED are to provide the procedure for the test.

A review of the results of the test will be carried out to give clearance for the integration of the SIH to the DRCU and Cold Units.

For PFM: TBD

## 7.4 Electrical disconnection

Disconnection is the reverse of connection

## 7.5 Removal from spacecraft

**WARNING:** The bipod legs on two corners of the instrument are very thin section and easily damaged. Care must be taken at all times not to put side loads into these items. These are at risk at all times when the FPU is not attached to a rigid plate.

Unbolt the cone from the FPU by undoing the M8 nut, thus leaving the cone on the baseplate.

Remove all electrical connections, see section 7.4

Undo the five M4 fasteners which secure the Photometer JFET rack (HSJFP) to the HOB.

Undo the four M4 fasteners that secure the Spectrometer JFET rack (HSJFS) to the HOB. Note that two of these fasteners are studs with nuts on the top.

Undo the 6 off M4 fasteners on each L0 strap and remove, separate the cold strap from the helium tank pod. NOTE. The underside of these straps form the thermal interface to the spacecraft helium tank pods. Their surfaces are flat and soft gold plated, these surfaces can easily be damaged and the thermal performance of the instrument may suffer as a result.

Remove the Detector Level 0 strap from the supports by undoing the clamps at the top of the strap support frames, the lower flexibles from the spacecraft pod interface and the bolts at the joining plates with the upper flexibles.

Undo and remove the one M8 and two M4 screws from each of two L1 cold strap interface, separate the cold strap from the FPU

Undo and remove the two M4 screws from the L3 interfaces on each JFET, separate the cold strap from the JFET.

Undo and remove the 8 fasteners that attach the FPU to the baseplate.

The FPU and JFETs can now be lifted from the HOB

## 8. RED TAG ITEMS

The following red tag items are fitted to the FPU when delivered.

- 1 An aperture cover – To be removed at the latest opportunity prior to closure of the cryostat taking into account the possibility that the cover may not be able to be removed once the Instrument Shield is integrated.
- 2 Alignment cube – To be removed after alignment activities has ended and prior to closure of the cryostat taking into account the possibility that the cover may not be able to be removed once the Instrument Shield is integrated.
- 3 Temporary grounding strap – Removed during the Cryoharness Integration Procedure. (must be removed prior to integration of Instrument Shield)
- 4 Shorting plugs – Removed during the Cryoharness Integration Procedure. (must be removed prior to integration of Instrument Shield)

When removed all red tag items shall be bagged and stored in the dedicated “red tag box”.

The aperture cover is removed by unscrewing the four 2-56 UNC (imperial) cap head screws, which are captive in the cover, and lifting the cover clear.

The alignment cube is removed by unscrewing the three fixing screws and lifting clear.

## 9. GREEN TAG ITEMS

There are no green tag items

**SPIRE**

**Project Document**

SPIRE FPU Handling and Integration  
Procedure

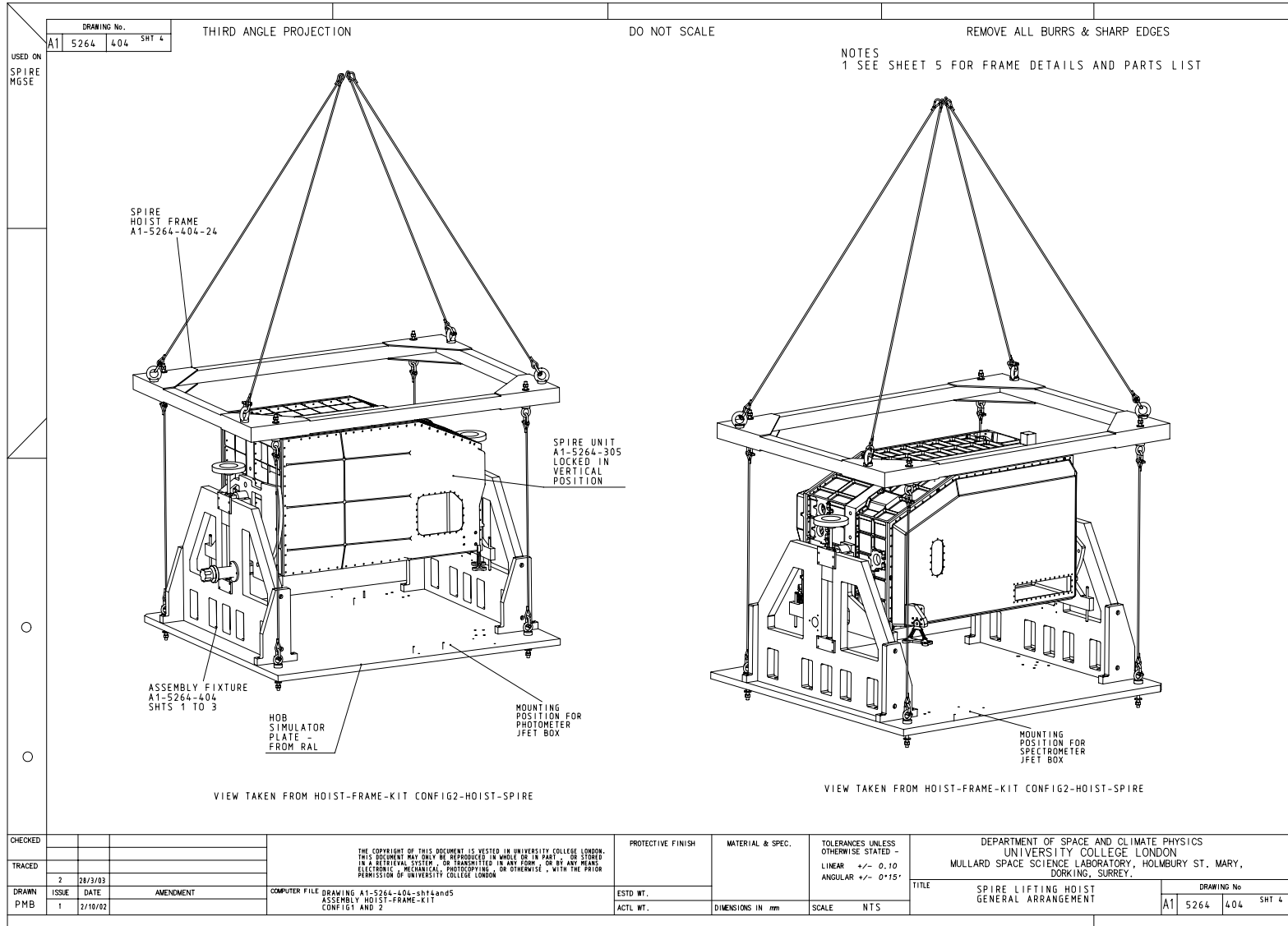
**Ref:** SPIRE-RAL-PRC-  
001923

**Issue:** 4

**Date:** 08/07/2005

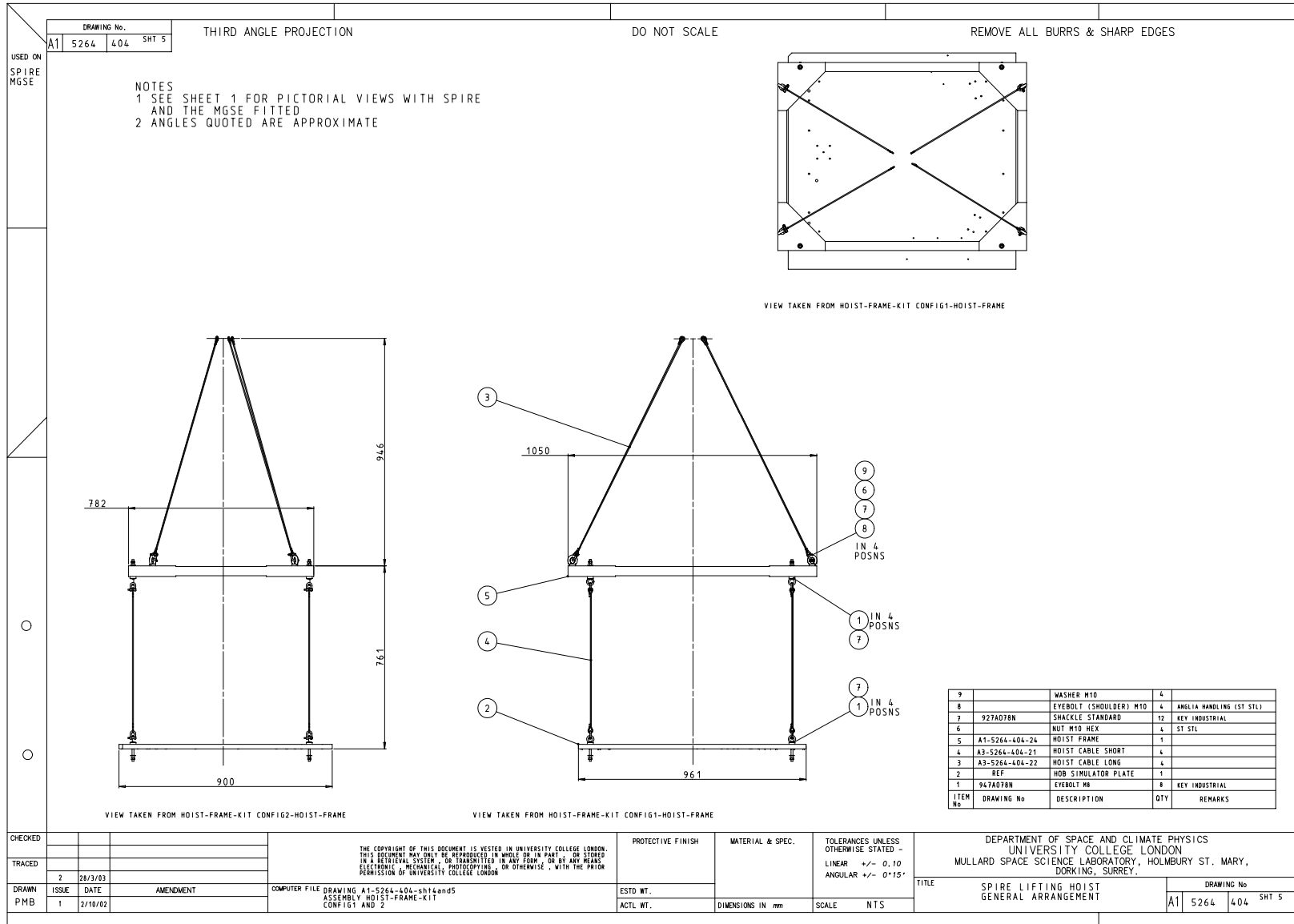
**Page:** 31 of 38

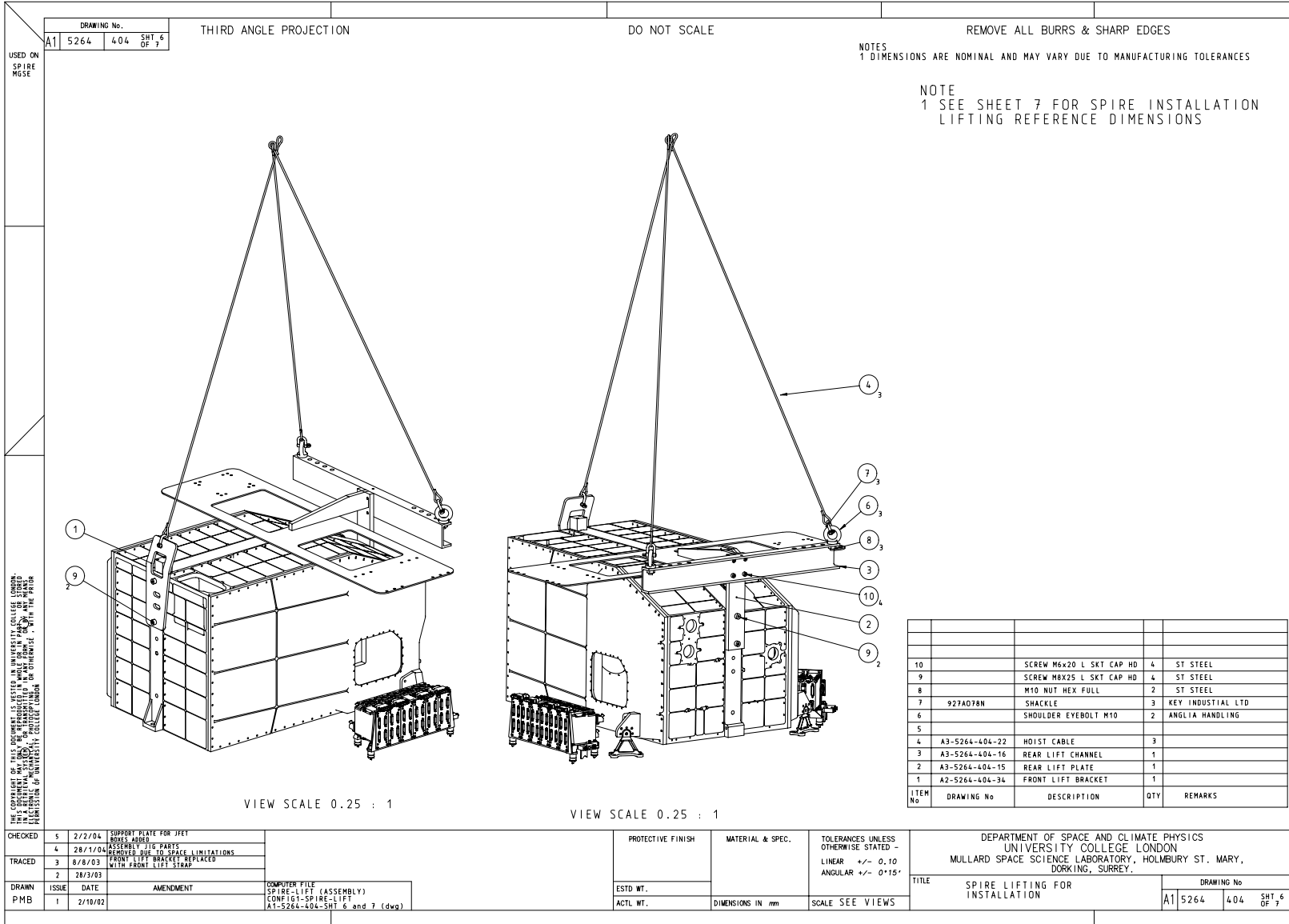
**ANNEX A - DRAWINGS OF SPIRE FPU MGSE**



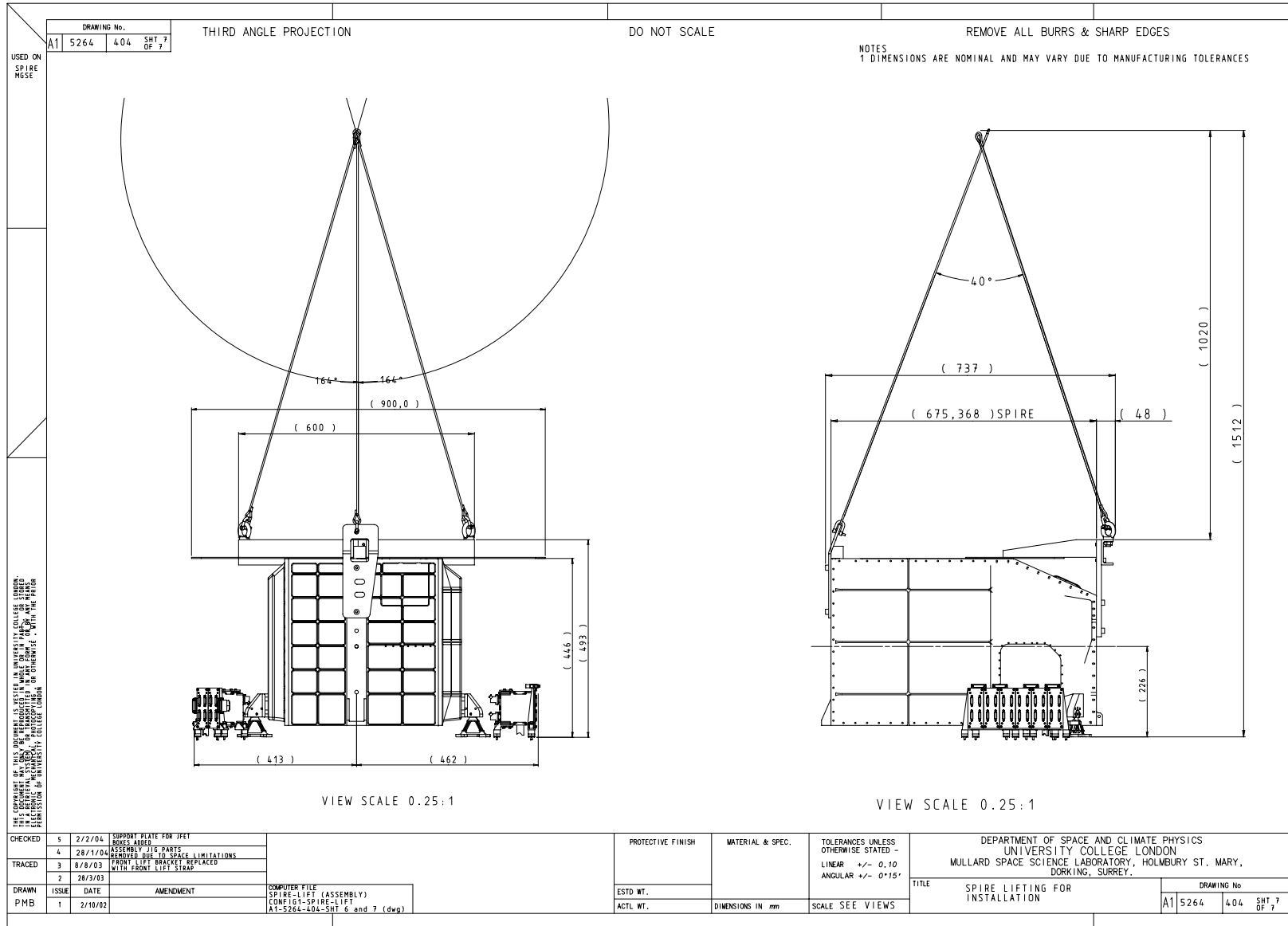
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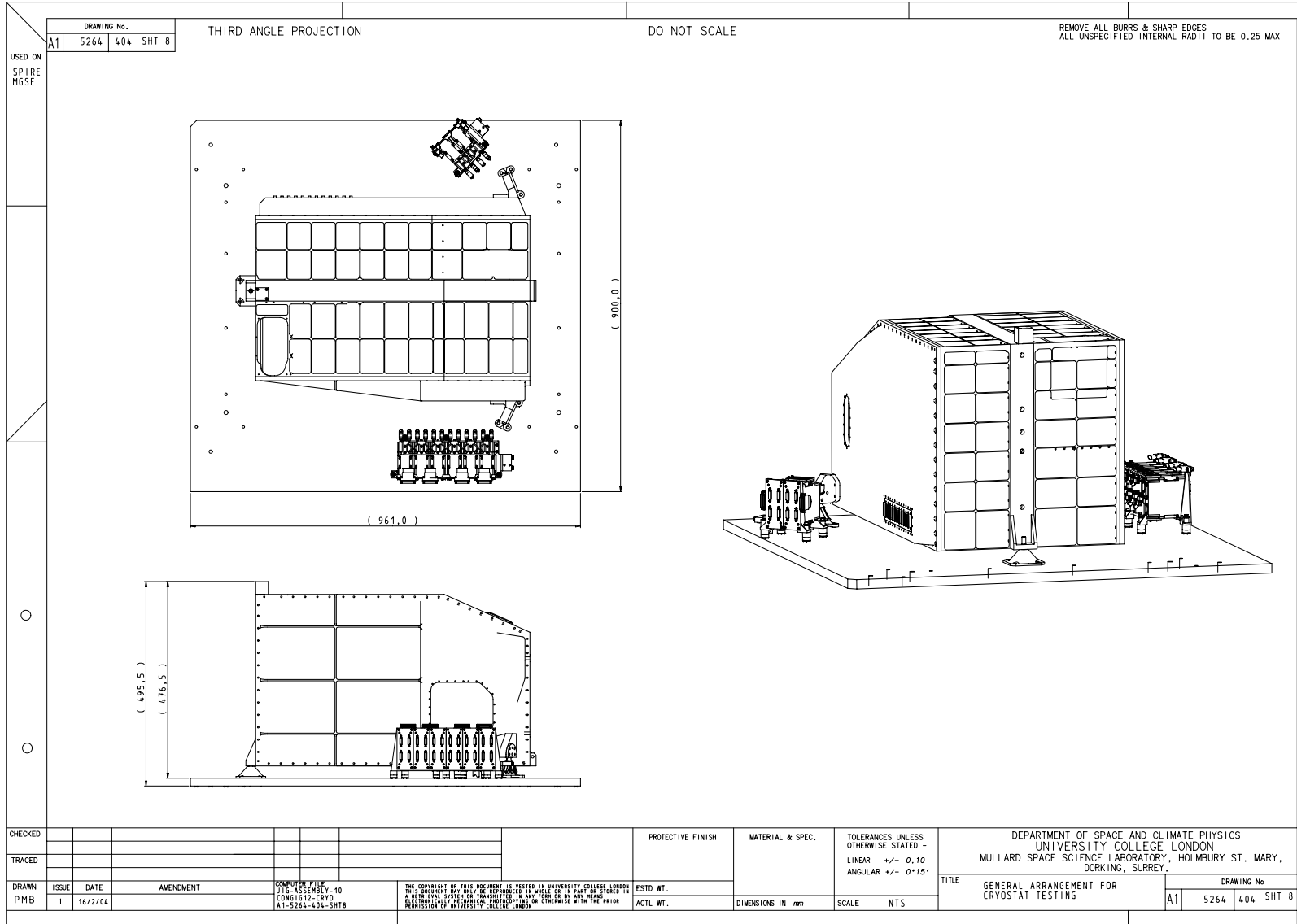


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|         |        |         |  |                   |                  |  |  |
|---------|--------|---------|--|-------------------|------------------|--|--|
| CHECKED | 5      | 2/2/04  | SUPPORT PLATE FOR JFEY BOXES ADDED   | PROTECTIVE FINISH | MATERIAL & SPEC. | TOLERANCES UNLESS OTHERWISE STATED -<br>LINEAR +/- 0.10<br>ANGULAR +/- 0°15' | DEPARTMENT OF SPACE AND CLIMATE PHYSICS<br>UNIVERSITY COLLEGE LONDON<br>MULLARD SPACE SCIENCE LABORATORY, HOLMBURY ST. MARY,<br>DORKING, SURREY. |
|         | TRACED | 4       | 28/1/04  |                   |                  |  |  |
|         | 3      | 8/8/03  | FRONT LIFT BRACKET REPLACED WITH FRONT LIFT STRAP                                    |                   |                  |  | TITLE<br>SPIRE LIFTING FOR INSTALLATION  |
|         | 2      | 28/3/03 |  |                   |                  |  |  |
| DRAWN   | ISSUE  | DATE    | AMENDMENT  | ESTD WT.          | DIMENSIONS IN mm | SCALE SEE VIEWS  | DRAWING No.  |
| PMB     | 1      | 2/10/02 | COMPUTER FILE SPIRE-LIFT (ASSEMBLY) CONFIG1-SPIRE-LIFT A1-5264-404-SHT 6 and 7 (deg) | ACTL WT.          |                  |  | A1 5264 404 SHT 7 OF 7   |



**SPIRE**

**Project Document**

SPIRE FPU Handling and Integration  
Procedure

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**ANNEX B - L0 THERMAL STRAP ASSEMBLY**

# SPIRE

## Project Document

### SPIRE FPU Handling and Integration Procedure

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USED ON SPIRE

DRAWING No. 5264 309A

THIRD ANGLE PROJECTION

DO NOT SCALE

REMOVE ALL BURRS & SHARP EDGES / ALL UNSPECIFIED INTERNAL RADII TO BE 0.25 MAX

DETAIL A  
EVAPORATOR UPPER STRAP JUNCTION

DETAIL B  
TYPICAL FOR SPECTROMETER AND PUMP UPPER STRAP JUNCTION

TOP VIEW  
MAIN COVERS AND FLEXIBLE STRAPS ARE NOT SHOWN

SECTION A-A SPEC STRAP  
TYPICAL FOR PUMP LOWER FIXINGS EXCEPT ITEM 34 MOUNTING BLOCK AND FIXINGS ARE NOT REQUIRED

SECTION B-B EVAPORATOR STRAP ONLY

NOTES  
1 MAIN PHOT AND SPEC COVERS HAVE BEEN REMOVED FROM ALL VIEWS  
2 FINAL ASSEMBLY OF ALL PARTS WILL TAKE PLACE AFTER COMPRESSION AND EB WELDING OF FLEXIBLE STRAPS HAS BEEN COMPLETED  
3 USE THIS DRAWING IN CONJUNCTION WITH THE EB WELDING FIXTURE A1-5264-951 TO FORM FLEXIBLE STRAPS INTO SHAPES SHOWN  
4 ONLY THE OUTER FLEXIBLE STRAP HAS BEEN SHOWN AT THE LOWER POSITION OF THE SPEC/PUMP/LEAP STRAPS THIS ASSEMBLY REQUIRES BOTH AN INNER AND OUTER LOWER FLEXIBLE STRAP  
5 ASTRIUM INTERFACE PARTS ARE SHOWN FOR REFERENCE ONLY

BAFFLE ASSY 4K  
TYPICAL IN 3 POSNS EXCEPT FOR ITEMS 6 & 7 AND ITEMS 42/43/44

|    |  |     |
|----|--|-----|
| 48 | washer-M4-oversize                         | 10  |
| 47 | Washer-40-oversize                         | 24  |
| 46 | Washer-0-80-small                          | 12  |
| 45 | Washer-4-40 plain                          | 24  |
| 44 | Vessel bush                                | 15  |
| 43 | upper-flex-spec-pmb                        | 1   |
| 42 | upper-flex-pump-pmb                        | 1   |
| 41 | upper-flex-evaporator-pmb                  | 1   |
| 40 | Stud                                       | 6   |
| 39 | A3-5264-309-6 special washer               | 12  |
| 38 | SCR-4420L-SKT-C50-40                       | 1   |
| 37 | SCR-4420L-SKT-BUTT-40                      | 4   |
| 36 | REFERENCE Pressure-plate-Astrium           | 3   |
| 35 | A3-5264-309-1A Outer-baffle-com            | 3   |
| 34 | Nut 4-40 keylock                           | 30  |
| 33 | Mounting-block                             | 1   |
| 32 | M4-B-32 Keylock nut                        | 10  |
| 31 | M4 washer                                  | 14  |
| 30 | M4 Skt Hd bolt 20Lg                        | 10  |
| 29 | lower-flex-spec-outer-pmb                  | 1   |
| 28 | lower-flex-pump-outer-pmb                  | 1   |
| 27 | lower-flex-evaporator-outer-pmb            | 1   |
| 26 | level-0-coldtrap-spec-pmb2                 | 3   |
| 25 | level-0-coldtrap-pump-pmb                  | 3   |
| 24 | level-0-coldtrap-evaporator-outer          | 1   |
| 23 | level-0-coldtrap-evaporator-inner          | 2   |
| 22 | joining-plate-pump-assy                    | 4   |
| 21 | joining-plate-evaporator-outer             | 1   |
| 20 | joining-plate-evaporator-inner             | 1   |
| 19 | DOWEL-16Lx140                              | 4   |
| 18 | ColdStrapSupport-diagonal-leg              | 2   |
| 17 | ColdStrapSupport-diagonal-leg              | 1   |
| 16 | Cold-Strap-Support-upper                   | 3   |
| 15 | Cold-Strap-Support-diagonal                | 3   |
| 14 | Cold-Strap-Support-Leg                     | 12  |
| 13 | Crimp                                      | 4   |
| 12 | A3-5264-309-2C Contrn-baffle-4k            | 3   |
| 11 | Cap-screw-0-80unc x 6.35 lg                | 12  |
| 10 | Cap screw 4-40unc x 12.7                   | 40  |
| 9  | Bellville washer 0.7 x 0.53 Do 9.53 I 0.44 | 15  |
| 8  | Bellville washer B0250-009-S               | 70  |
| 7  | Baffle-outer-solid-core-SPECT              | 1   |
| 6  | Baffle-outer-solid-core                    | 6   |
| 5  | REFERENCE Astrium-thermal-sensor           | 3   |
| 4  | REFERENCE Astrium-pressure-plate-opod      | 1   |
| 3  | 4-40 unc x 8 ssk hd                        | 10  |
| 2  | 4-40 unc x 10 ssk hd                       | 10  |
| 1  | NOT REQ 4-40 UNC Nut                       | 4   |
|    | Item/Part #                                | Qty |

CHECKED

TRACED

DRAWN  
PMB

ISSUE 1 DATE 22/1/04 AMENDMENT

29/1/04 BRG No ADDED TO ITER 39

COMPUTER FILE  
COLD-STRAPS-FM (ASSY)  
COLD-STRAPS-FM-4551-BRG (CONF1)  
A3-5264-309A (DRG)

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ESTD WT.  
ACTL WT.

MATERIAL & SPEC.

TOLERANCES UNLESS OTHERWISE STATED -  
LINEAR +/- 0.10  
ANGULAR +/- 0°15'

DIMENSIONS IN mm

SCALE NTS

DEPARTMENT OF SPACE AND CLIMATE PHYSICS  
UNIVERSITY COLLEGE LONDON  
MULLARD SPACE SCIENCE LABORATORY, HOLMBURY ST. MARY,  
DORKING, SURREY.

TITLE LEVEL 0 COLD STRAP ASSEMBLY

DRAWING No  
5264 309A