	SPIRE BSM Declared Process List Procedure ID SPI-BSM-PRJ-708 ITEM #17 Version no 1.0	Ref: SPI-BSM-NOT_0714 Page : Page 1 of 5 Date : Author: IP
----------------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------------	---------------------------------------------------------------------

SPIRE BSM Declared Processes
Procedure ID SPI-BSM-PRJ-708 ITEM 17
Bonding of motor coils into hosing

Author :	Brenda Graham
Date:	02/06/2003
Version:	1.0

DISTRIBUTION LIST :

SPIRE-Project	Doug Griffin	
	Eric Clark	
UK ATC	Colin Cunningham	X
	Gillian Wright	
	Ian Pain	X
	Tom Baillie	
	Tully Peacocke	
	Brian Stobie	
	Ken Wilson	X
	Tom Paul	
	Ian Laidlaw	X
	Gary Rae	
	Derek Ives	
Ian Bryson		

Version Control

Date	Index	Remarks
02/03/2003	1.0	New release

Table of Contents

1	Scope	5
2	Introduction	5
3	Preparation.....	5

Applicable documents

Applicable documents are project specific and may be assumed to apply fully to the BSM, unless stated otherwise

Ref	Title	Author	Reference	Date
AD 1	SPIRE BSM Declared Process List v 1.2	IP	SPI-BSM-PRJ-0708	13/11/02
AD 2	SPIRE ATC QA PLAN v1.2	IP	SPI-BSM-PRJ-0711	15/07/02
AD 3	SPIRE cleaning process	KW	SPI-BSM-NOT-0029	29/11/02
AD 4	SPIRE adhesive bonding process	KW	SPI-BSM-NOT-0027	27/08/02
AD 5	SPIRE Fastener assembly	IP	SPI-BSM-NOT-0018	27/08/02

Reference documents


Reference documents are generic and may only apply in part to the project, or may be for information or reference only.

Ref	Title	Author	Reference	Date
RD 1	SPIRE BSM Declared Materials List v1.2	IP	SPI-BSM-PRJ-0710	21/10/02
RD 2				
RD 3				
RD 4				
RD 5				
RD 6				
RD 7				

Glossary

Abbr	Definition	Abbr	Definition
AD	Applicable Document	LAM	Laboratoire d'Astrophysique de Marseille
ADP	Acceptance Data Package	LAT	Lot Acceptance Tests
ARB	The Acceptance Review Board	MAPTIS	Materials and Processes Technical Information Service
BSM	Beam Steering Mirror	MSFC	Marshall Space Flight Center
BSMe	Beam Steering Mirror electronics	MCU	Mechanism Control Unit
CAE	Computer Aided Engineering	MIP	Mandatory Inspection Point
CDR	Critical Design Review	MGSE	Mechanical Ground Support Equipment
CoG	Centre of Gravity	MPIA	Max Planck Institute for Astronomy

Abbr	Definition	Abbr	Definition
CIL	Critical Items List	MSSL	Mullard Space Science Laboratory
CQM	Cryogenic Qualification Model	NASA	National Aeronautical Space Agency
CTD	Change to Drawing/Document	NA	Not Applicable
DCL	Declared Components List	NCR	Non Conformance Report
DDR	Detailed Design Review	NCRP	Non Conformance Review Panel
DM	Development Model	OGSE	Optical Ground Support Equipment
DML	Declared Materials List	PA	Product Assurance
DPA	Destructive Physical Analysis	PAD	Part Approval Document
ECSS	European Cooperation for Space Standardisation	PFM	Proto Flight Model
EGSE	Electrical Ground Support Equipment	PPARC	Particle Physics and Astronomy Research Council
ESA	European Space Agency	PI	Principal Investigator
FMEA	Failure Modes and Effects Analysis	QA	Quality Assurance
FMECA	Failure Modes, Effects and Criticality Analysis	RAL	Rutherford Appleton Laboratory
FPGA	Field Programmable Gate Array	RAL SSD	RAL Space Science Department
FPU	Focal Plane Unit	RD	Reference Document
FSM	Flight Spare model	SMEC	Spectrometer Mechanism
GSFC	Goddard Space Flight Center	SPIRE	Spectral and Photometric Imaging REceiver
GSE	Ground Support Equipment	TBC	To Be Confirmed
HoS	Head of Specialism	TBD	To Be Defined
Herschel	ESA Mission name (formerly FIRST)	TBW	To Be Written
IBDR	Instrument Baseline Design Review	UK ATC	United Kingdom Astronomy Technology Centre
KIP	Key Inspection Point	UK SPO	UK SPIRE Project Office
		WE	Warm Electronics

	<p align="center">SPIRE BSM Declared Process List</p> <p align="center">Procedure ID SPI-BSM-PRJ-708 ITEM #17</p> <p align="center">Version no 1.0</p>	<p>Ref: SPI-BSM-NOT_0714</p> <p>Page : Page 5 of 5</p> <p>Date :</p> <p>Author: IP</p>
----------------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------	----------------------------------------------------------------------------------------

1 SCOPE

The scope of the procedure is to describe the mounting of the motor coils into their housing.

2 INTRODUCTION

The motor coils are bonded into their housing using Stycast 2850FT with catalyst 11 after the wires have been attached to them. Before bonding the motors into their housings the coils will be test for resistance cold.

3 PROCESS

- Ensure that the motor coils have been tested before starting process.
- Clean the motor housing as per SPI-BSM-NOT-0029 [AD 3].
- Thoroughly Clean the jig as per SPI-BSM-NOT-0029 [AD 3].
- Mix the Stycast as per SPI-BSM-NOT-0027 [AD 4].
- Fit the prime and redundant motor coils into the housing taking care that the wiring is in the correct location as shown on the drawings.
- Fit the top part of the housing.
- Place the jig between the two coils, this will set the gap between them.
- Fasten the screws as per SPI-BSM-NOT-0018 [AD 5].
- Rout the wires in the grooves in the housing, ensuring that they all lie flat and do not come higher than the groove walls.
- Cover the wires with potting compound. Ensure that the compound does not come higher than the groove walls. Do not cover the motor coils.