
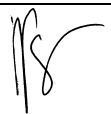
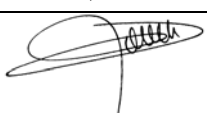


PROJECT : Herschel		NON CONFORMANCE REPORT	
Subsystem : SMEC		Unit : SPIRE	
Model : FM		Identif. Number :	
NCR occurred during : Manufacture [] Inspec [] Test [X] Integ [] Other []			
NCR Title : Discrepancy during the latching operation			
NCR Description : Problem during the Latching operation (See details on page 2)			
Originator Name : D. Pouliquen		Date 12/07/2006	Signature : 
Cause of the NCR : Friction against the stops due to a staking of the stops surface during the vibrations.		Major []	Minor [X]
Disposition/Corrective Action : Remove the rim produced by the staking and modify slightly le shape of the stops.		Corrective action carried out : Name : Date :	
MRB date :		MRB Minute Ref :	
MRB Conclusion :To remove the rims from the stops and to make a slight slope at the entrance of the stop to avoid the rim to be formed again			
Responsible for corrective Actions :		All Corrective Actions Carried Out : Yes [X] No []	
		Date	Signature
RAL Project manager :			
RAL PA/QA			
LAM Project manager		12/07/2006	
LAM PA/QA		12/07/2006	

Non conformance description:

First occurrence: During the 27th - 31st March thermal test The cool down was carried out with the mechanism out of its stops. When at 9K we try to put the carriage in the latching location, the friction prevents the full displacement and the latch, whose functioning is nominal, could not enter in the target hole.

Second occurrence: During the test in cold in CSL (10-17 april 2006). The same effects were found.

Corrective actions: They are the following:

- To identify the stops that are the origin of the friction. This was done during a thermal test at LAM (11-15 may 2006)
- Remove the origin of the frictions (The rims)
- The rims have been removed by hand on every stops in Z and on the rear Y stop
- A slope was done at the entrance of the stop to avoid a rim to be formed again during the vibration.

Following these corrective actions, some functional tests of the latch mechanism were carried out at 300K and at 4K; all were successful.