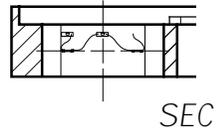


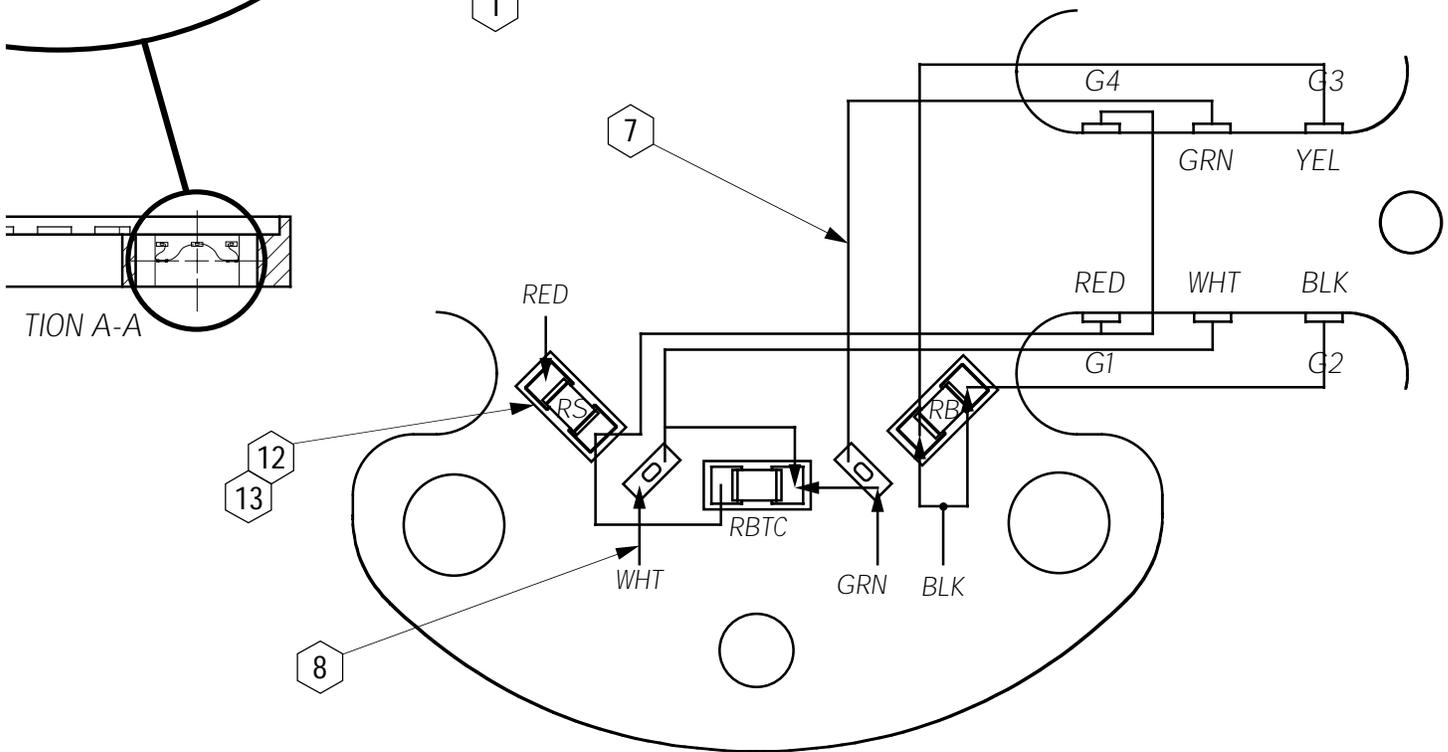
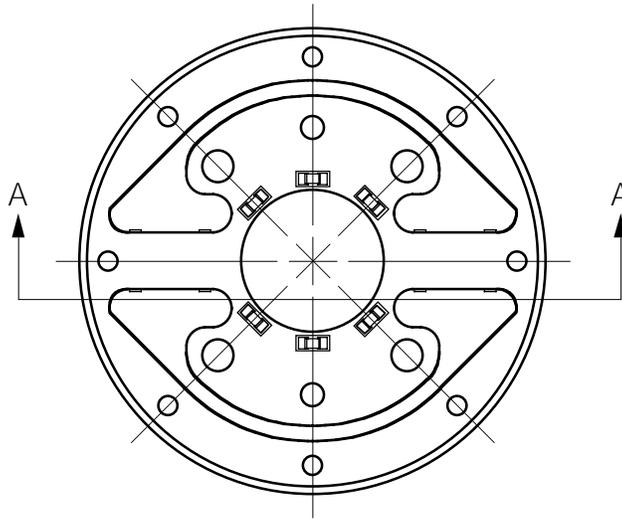
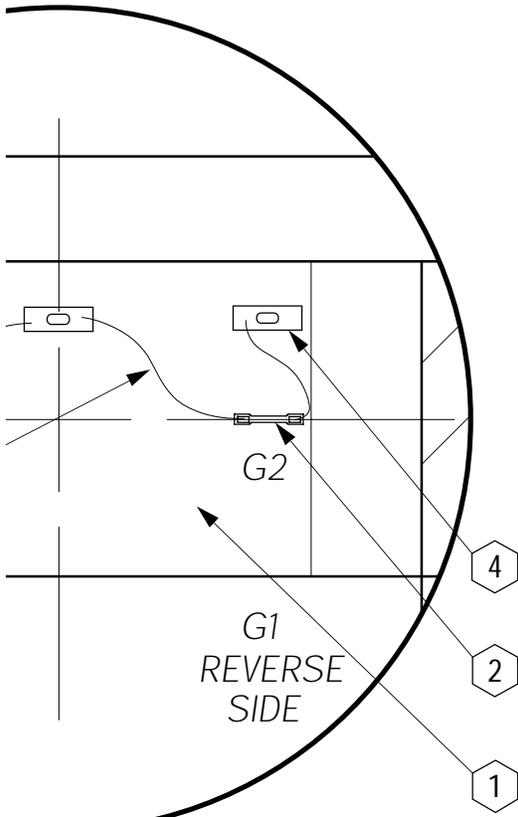
**NOTES:**

1. PREPARE SURFACES TO BE GAGED PER 480135 AS SHOWN.
2. PREPARE AND PLACE STRAIN GAGES PER 280125 AS SHOWN. GAGES ARE PLACED ON BOTH SIDES OF BEAM
3. CURE GAGES IN VACUUM USING CURE SCHEDULE 1 PER 280107.
4. PREPARE AND PLACE SOLDER TABS PER 240330 AS SHOWN.
5. CURE SOLDER TABS AT 240°F FOR ONE (1) HOUR.
6. ATTACH GAGE LEADS TO SOLDER TABS PER 240331 AS SHOWN.
7. ATTACH JUMPER WIRES TO SOLDER TABS PER 240331 TO COMPLETE CIRCUIT AS SHOWN.
8. PREPARE 10' OF 28 AWG HOOK-UP WIRES PER 480065 AND ATTACH TO SOLDER TABS PER 480066 TO COMPLETE CIRCUIT AS SHOWN.
9. CHECK GAGE CONTINUITY AND ISOLATION PER 490013. MINIMUM RESISTANCE TO CASE,  $50M\Omega @ 50 VDC$ .
10. COVER GAGES, GAGE LEADS, AND SOLDER TABS WITH DOW-CORNING 3140 RTV SILICONE COATING AND CURE PER MANUFACTURER'S INSTRUCTIONS.
11. PERFORM TEMPERATURE COMPENSATION PER 480131. TEMPERATURES ARE 30°F, 70°F, AND 130°F. BALANCE OUTPUT AT AMBIENT MUST BE  $\pm 5mV$  WITH 5VDC BRIDGE EXCITATION. BALANCE OUTPUT MAY VARY FROM AMBIENT OUTPUT BY NO MORE THAN  $\pm 5mV$  OVER TEMPERATURE RANGE OF 30°F TO 130°F.
12. PLACE BRIDGE BALANCE/TEMP COMP RESISTOR SOLDER TABS AS SHOWN PER 240330. ALLOW SOLDER T CURE FOR 1 HOUR AT 240°F.
13. INSTALL BRIDGE COMPLETION /TEMP COMP RESISTORS AS SHOWN AND MODIFY WIRING TO INCLUDE RESIST CIRCUIT AS SHOWN.
14. INSPECTION: VERIFY THAT ALL MANUFACTURING STEPS NOTED ABOVE HAVE BEEN COMPLETED. DATA PRO BALANCE (NO LOAD) OUTPUT OF SENSOR AT EACH TEMPERATURE. PACKAGE EACH BEAM IN INDIVIDUAL PA BAG.



**REVISIONS**

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NEXT ASSEMBLY		USED ON		ITEM NO.	REQ'D	PART NO.	DESCRIPTION	SPEC., MATERIAL OR SOURCE
<b>APPLICATION</b>								
PRODUCT: NASA				DR. BY: DAN EVANS		7/23/04		 <b>4509 Runway Street</b> <b>Simi Valley, CA 93063</b> (805) 522-4676 FAX: (805) 522-4982
<b>UNLESS OTHERWISE NOTED:</b> ALL DIMENSIONS ARE IN INCHES .X = ± .030 • .XX = ± .010 • .XXX = ± .005 ANGULAR = ± 0° 30' • DIA Ⓞ .005 TIR FILLET RADII .005 MAX • SURFACE $\sqrt{3}$				CHK:		MATERIAL		
THIS DRAWING CONTAINS INFORMATION PROPRIETARY TO MICRON INSTRUMENTS INC. DO NOT USE, REPRODUCE, OR DISCLOSE TO ANYONE WITHOUT WRITTEN PERMISSION.				FINISH		TITLE		REV.
DO NOT SCALE DRAWING				SCALE: NONE		WT:		SHEET 1 OF 1
				SIZE <b>B</b>		CODE IDENT. NO. <b>1CWQ4</b>		DWG. NO. <b>150862</b>