

	CONSERT Declared Process List	Reference : RO-OCN-LI-3003 Issue : 4 Date : 04/08/99 Page : 1 / 8
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DECLARED PROCESS LIST

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Group 1 : Adhesive bonding									
1	2	3	4	5	6	7	8	9	10
Item no	Process	Specification (incl.issue)	Description/identification	Use and location	User code	Associated DML items	Criticality of process	Approval/status	ESA comments
1.1	Araldite AV138M HV998		Mixing ratio 2.5/1	Assembly of tube to hinge		1.1, 15.1, 20.2		NHB 8060-1A & 1B PSS-01-702	

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Group 2 : Composite Manufacture									
1	2	3	4	5	6	7	8	9	10
Item no	Process	Specification (incl.issue)	Description/ identification	Use and location	User code	Associated DML items	Criticality of process	Approval/ status	ESA comments
2.1	CFK Tube manufacturing	TBD	Schuetze, Dorsten (D)	Masts		15.1			

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Group 4 : Painting / Coating									
1	2	3	4	5	6	7	8	9	10
Item no	Process	Specification (incl.issue)	Description/ identification	Use and Location	User code	Associated DML items	Criticality of process	Approval/ status	ESA comments
4.1	Iridite 14-2	Protective chromate conversation film on aluminium	Candorchemie, Bochum (D)	Secondary structure passivation		1.1			
4.2	Placmocer White	PTS, Jena (D)	Al-Alloy relevant chemicals						
4.3	Placmocer Black	PTS, Jena (D)	Al-Alloy relevant chemicals	Dipols					

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Group 5 : Cleaning									
1	2	3	4	5	6	7	8	9	10
Item no	Process	Specification (incl.issue)	Description/identification	Use and location	User code	Associated DML items	Criticality of process	Approval/status	ESA comments
5.1	Cleaning	Isopropanol		Instrument subsystems		All			

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Group 7 : Crimping / Stripping / Wire strapping									
1	2	3	4	5	6	7	8	9	10
Item no	Process	Specification (incl.issue)	Description/ identification	Use and location	User code	Associated DCL items	Criticality of process	Approval/ status	ESA comments
7.1	Crimping	CNES / QFT / SP.0050-6 Issue 2		Connectors		13.2 13.6 13.8			
7.2	Wire strapping	CNES / QFT / SP.0050-5A Issue 1		Switch, PCB assembly		13.9			

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Group 8 : Soldering									
1	2	3	4	5	6	7	8	9	10
Item no	Process	Specification (incl.issue)	Description/identification	Use and location	User code	Associated DCL items	Criticality of process	Approval/status	ESA comments
8.1	Soldering	CNES / QFT / SP.0050-3A Issue 3 Rev 1		PCB Boards Switch		13.1 13.3 13.4 13.9			

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Group 9 : Surface Conversion treatment									
1	2	3	4	5	6	7	8	9	10
Item no	Process	Specification (incl.issue)	Description/identification	Use and location	User code	Associated DML items	Criticality of process	Approval/status	ESA comments
9.1	Placmocer	PTS, Jena (D)		Al-Parts		1.1 1.2		ESA PSS-01-703	