



GCS

PROCESS SPECIFICATION: L3 GCS RAINPROOF APPLICATION

1.0 SCOPE:

This specification details the requirements and expectations for the material intended to be used in a rainproof application.

2.0 ORDER OF PRECEDENCE:

In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3.0 RAINPROOF WELD(S):

If weld(s) are present on the document that referenced this specification:

3.1 Follow L3 GCS Welding Standards (P/N: 1000-0201-01).

3.2 Boxes must be able to seal except for top/bottom openings (if present) and cutouts (if present).

3.3 All welds to be of uniform quality and condition and free of cracks and porosity.

3.4 Vendor shall perform first article testing using a statistically significant sample size to verify welding process per MIL-I-25135, Type II (visible dye penetrant inspection). Testing to be approved in writing by L3 GCS Engineering and Quality Control Departments.

3.5 Vendor shall verify process control and weld integrity of each successive purchase order on a minimum quantity of one (1) component, per MIL-I-25135, Type II (visible dye penetrant inspection). Vendor to maintain record of testing per purchase order for a minimum of six (6) months.

4.0 RAINPROOF PEM(S):

If PEM(s) are present on the document that referenced this specification:

4.1 Install all PEM(S) per manufacturer recommended installation procedures.

4.2 Apply Loctite HYSOL-E-120HP epoxy or equivalent to all PEM(s) on inside of chassis after finish to ensure there is no leakage. Alternatively, Loctite Threadlocker Green 290 can be used. To fully cure, a minimum of 24 hours must be allowed before applying any pre-treatment or finish.

5.0 PRESSURE TESTING(S)

The following procedures are to be implemented after the full assembly of the document that referenced this specification is assembled:

5.1 A Pressure Test will be completed internal to L3 GCS to ensure rain proofing of specific L3 GCS products. This quality check will be used to verify that each product meets L3 GCS's internal and external requirements as defined by MIL-STD-810G; METHOD 506.5.

- 5.2** All compartments, required to be rain proof and/or splash proof, shall be free of cracks and uniformly pressure tested to L3 GCS standards. Blowing rain standard MIL-STD-810G, METHOD 506.5
- 5.3** For internal pressure tests, all specified products must pass L3 GCS pressure test PD, specified by Document Management number 1631. Confirmation of test must be from an approved test fixture outlined in Document Management Number 1631.
- 5.4** For external pressure integrity verification done by suppliers or a third party, a standard pressure integrity of walls and joints will be met to ensure that any alteration will result in a continued closed system verified by a pressure test agreed upon by L3 GCS Engineering department.