



GCS

PROCESS SPECIFICATION
L-3 GCS RAINPROOF APPLICATION
1000-0202-01 REV C
JULY 20, 2015

PROCESS SPECIFICATION: L-3 GCS RAINPROOF APPLICATION

1.0 SCOPE:

This specification details the specifications 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 L-3 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 L-3 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) chassis, 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.