

Attachment G
First Article Inspection Results
Lithium Battery Pack



INSPECTION REPORT (SIDE A)

FIRST ARTICLE YES ☒ NO ☐

(Ref. Work Instructions FTL.QUA.310-02 and FTL.QUA.430-10)

Page 1 of 2

Program or Project: SRB-406 Work Order: 5301-70 Contract No: N/A
Part or Assy. Name: BATTERY PACK SRB 406 Part No: P4-03-0001
Serial Number(s): 0201310 Quantity Inspected: 1 Revision Level: A

Inspect/ Test Point No	Inspection/Test Instructions, References, Equipment	Method*			Inspector's Section		
		V	W	I	Acc. Stamp	Inspection Date	Remarks/Recommendations Note: Do not stamp acceptance if item does not meet requirement.
1	NOTE 1. CELL SIZE "1-1/4 C"			✓		2/26/03	
2	NOTE 1 BATTERY CONSTRUCTION			✓		2/26/03	
3	NOTE 1 BATTERY WEIGHT			✓		2/26/03	300 g OR 0.66 lb.
4	NOTE 1 BATTERY VOLTAGE			✓		2/26/03	11.54 V (PARTIALLY DEPLETED DURING QUAL TESTING, BUT MET DGV LOADED VOLTAGE, REF. W. 0.5301-70
5	NOTE 1 BATTERY CAPACITY	✓				2/26/03	
6	NOTE 1 BATTERY CONNECTIONS			✓		2/26/03	
7	NOTE 1, STORAGE, SHIPPING AND DISPOSAL INFORMATION					2/26/03	FOR INFORMATION ONLY
8	NOTE 2. GENERAL PRECAUTIONS					2/26/03	FOR INFORMATION ONLY
9	NOTE 3 PROTECTION FROM ENVIRONMENT					2/26/03	FOR INFORMATION ONLY
10	NOTE 4 COPY OF AI-31-0117-001					2/26/03	LABEL P/N NOT CORRECT, CORRECTED BY HAND. A.M.
11	VERIFY LABEL			✓		2/26/03	LABEL P/N NOT CORRECT, CORRECTED BY HAND
12	VERIFY FOAM PAD			✓		2/26/03	

Verify W - Witness I = Inspect

INSPECTION REPORT (SIDE B)

FIRST ARTICLE YES ☒ NO

(Ref. Work Instructions FTL.QUA.310-02 and FTL.QUA.430-10)

Page 2 of 2

Program or Project: SRB-406

Contract No:

Part or Assy. Name: BATTERY PACK SRB 406

Part No:

Serial Number(s): 0201310 Quantity Inspected:

Revision Level:

A

[illegible]

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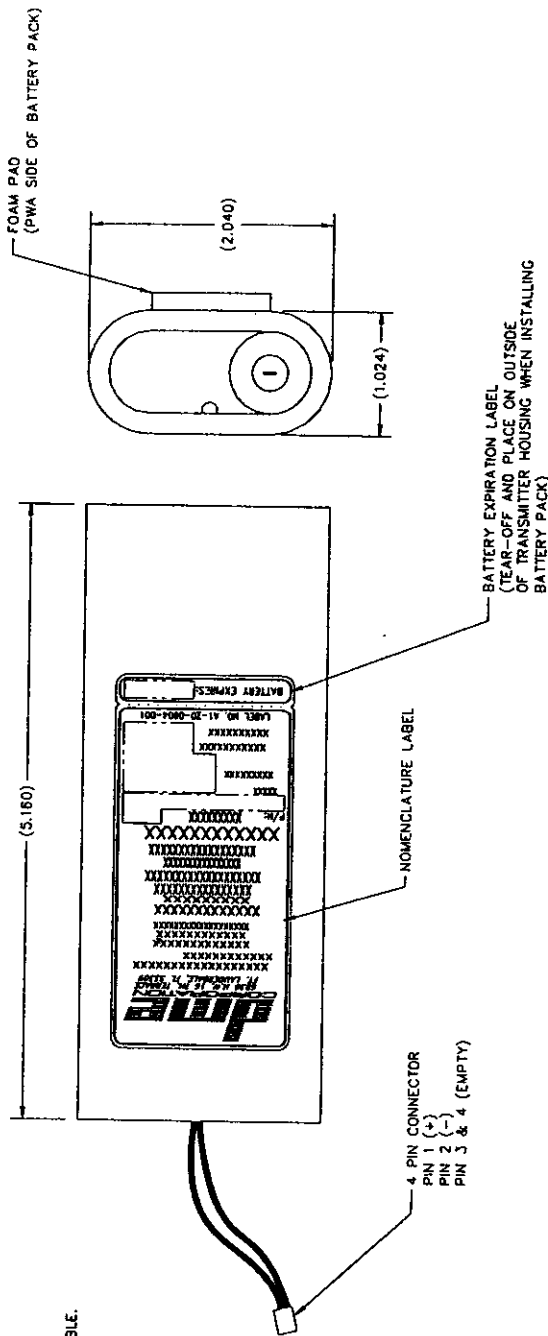
Notes:

1. SPECIFICATIONS:

- CELL SIZE: 1-1/4" C"
- CONSTRUCTION: FOUR EACH SOLID CATHODE LITHIUM MANGANESE DIOXIDE CELLS IN SERIES. EACH CELL IS PROTECTED WITH A POLYETHYLENE SEPARATOR BETWEEN ANODE AND CATHODE AND BY THE PTC.
- WEIGHT: APPROXIMATELY 0.87 LBS.
- VOLTAGE: 12 VDC NOMINAL (OPEN CIRCUIT)
- CAPACITY (FRESH): 5.6 AHRS. NOMINAL (100mA @ 23°C TO 2V CUTOFF)
- PIN CONNECTIONS: PIN 1 (+)
PIN 2 (-)
PIN 3 & 4 NOT USED.
- STORAGE: BATTERY PACK SHOULD BE STORED IN ORIGINAL PACKAGING UNTIL READY FOR INSTALLATION.
- SHIPPING: FOLLOW INTERNATIONAL/NATIONAL/STATE/LOCAL REGULATIONS WHEN SHIPPING BATTERY PACK(S).
- DISPOSAL: FOLLOW INTERNATIONAL/NATIONAL/STATE/LOCAL REGULATIONS WHEN DISPOSING OF BATTERY PACK(S).

2. GENERAL PRECAUTIONS:

- **DO NOT** DISASSEMBLE BATTERY PACK.
- **DO NOT** SHORT CIRCUIT BATTERY PACK.
- **DO NOT** CHARGE BATTERY PACK. BATTERY PACK IS **NOT** RECHARGEABLE.
- **DO NOT** REFURBISH AND/OR RECONDITION BATTERY PACK.
- THIS MAY RESULT IN CATASTROPHIC DAMAGE.
- BATTERY PACK (WITH OR WITHOUT SHIPPING PACKAGING) MUST BE PROTECTED FROM COMPRESSIVE LOADS AND HEATING BY NATURAL OR ARTIFICIAL SOURCES TO TEMPERATURES ABOVE 85°C.
- BATTERY PACK MAY VENT ABOVE 91°C.
- CATASTROPHIC DAMAGE MAY OCCUR TO BATTERY PACK ABOVE 180°C (MELTING POINT OF LITHIUM METAL).
- BATTERY PACK MUST BE PROTECTED FROM FORMATION OF CONDENSATION OR EXPOSURE TO WATER OR OTHER FLUIDS.
- ONE COPY OF AT-31-0177-001 MUST ACCOMPANY EACH BATTERY PACK(S) SHIPPED AS A SPARE OR INSTALLED IN THE ELT (SEE FAA TSO C142).



INTERFACE CONTROL DRAWING

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES		TOLERANCES ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	
FRAC.	DEC.	FRAC.	DEC.
1/16	0.0625	1/16	0.0625
1/8	0.125	1/8	0.125
3/16	0.1875	3/16	0.1875
1/4	0.25	1/4	0.25
5/16	0.3125	5/16	0.3125
3/8	0.375	3/8	0.375
7/16	0.4375	7/16	0.4375
1/2	0.5	1/2	0.5
5/8	0.625	5/8	0.625
3/4	0.75	3/4	0.75
7/8	0.875	7/8	0.875
1	1.0	1	1.0
1 1/8	1.125	1 1/8	1.125
1 1/4	1.25	1 1/4	1.25
1 3/8	1.375	1 3/8	1.375
1 1/2	1.5	1 1/2	1.5
1 5/8	1.625	1 5/8	1.625
1 3/4	1.75	1 3/4	1.75
1 7/8	1.875	1 7/8	1.875
2	2.0	2	2.0
2 1/8	2.125	2 1/8	2.125
2 1/4	2.25	2 1/4	2.25
2 3/8	2.375	2 3/8	2.375
2 1/2	2.5	2 1/2	2.5
2 5/8	2.625	2 5/8	2.625
2 3/4	2.75	2 3/4	2.75
2 7/8	2.875	2 7/8	2.875
3	3.0	3	3.0
3 1/8	3.125	3 1/8	3.125
3 1/4	3.25	3 1/4	3.25
3 3/8	3.375	3 3/8	3.375
3 1/2	3.5	3 1/2	3.5
3 5/8	3.625	3 5/8	3.625
3 3/4	3.75	3 3/4	3.75
3 7/8	3.875	3 7/8	3.875
4	4.0	4	4.0
4 1/8	4.125	4 1/8	4.125
4 1/4	4.25	4 1/4	4.25
4 3/8	4.375	4 3/8	4.375
4 1/2	4.5	4 1/2	4.5
4 5/8	4.625	4 5/8	4.625
4 3/4	4.75	4 3/4	4.75
4 7/8	4.875	4 7/8	4.875
5	5.0	5	5.0
5 1/8	5.125	5 1/8	5.125
5 1/4	5.25	5 1/4	5.25
5 3/8	5.375	5 3/8	5.375
5 1/2	5.5	5 1/2	5.5
5 5/8	5.625	5 5/8	5.625
5 3/4	5.75	5 3/4	5.75
5 7/8	5.875	5 7/8	5.875
6	6.0	6	6.0
6 1/8	6.125	6 1/8	6.125
6 1/4	6.25	6 1/4	6.25
6 3/8	6.375	6 3/8	6.375
6 1/2	6.5	6 1/2	6.5
6 5/8	6.625	6 5/8	6.625
6 3/4	6.75	6 3/4	6.75
6 7/8	6.875	6 7/8	6.875
7	7.0	7	7.0
7 1/8	7.125	7 1/8	7.125
7 1/4	7.25	7 1/4	7.25
7 3/8	7.375	7 3/8	7.375
7 1/2	7.5	7 1/2	7.5
7 5/8	7.625	7 5/8	7.625
7 3/4	7.75	7 3/4	7.75
7 7/8	7.875	7 7/8	7.875
8	8.0	8	8.0
8 1/8	8.125	8 1/8	8.125
8 1/4	8.25	8 1/4	8.25
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9 7/8	9.875	9 7/8	9.875
10	10.0	10	10.0
10 1/8	10.125	10 1/8	10.125
10 1/4	10.25	10 1/4	10.25
10 3/8	10.375	10 3/8	10.375
10 1/2	10.5	10 1/2	10.5
10 5/8	10.625	10 5/8	10.625
10 3/4	10.75	10 3/4	10.75
10 7/8	10.875	10 7/8	10.875
11	11.0	11	11.0
11 1/8	11.125	11 1/8	11.125
11 1/4	11.25	11 1/4	11.25
11 3/8	11.375	11 3/8	11.375
11 1/2	11.5	11 1/2	11.5
11 5/8	11.625	11 5/8	11.625
11 3/4	11.75	11 3/4	11.75
11 7/8	11.875	11 7/8	11.875
12	12.0	12	12.0
12 1/8	12.125	12 1/8	12.125
12 1/4	12.25	12 1/4	12.25
12 3/8	12.375	12 3/8	12.375
12 1/2	12.5	12 1/2	12.5
12 5/8	12.625	12 5/8	12.625
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12 7/8	12.875	12 7/8	12.875
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13 1/4	13.25	13 1/4	13.25
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13 1/2	13.5	13 1/2	13.5
13 5/8	13.625	13 5/8	13.625
13 3/4	13.75	13 3/4	13.75
13 7/8	13.875	13 7/8	13.875
14	14.0	14	14.0
14 1/8	14.125	14 1/8	14.125
14 1/4	14.25	14 1/4	14.25
14 3/8	14.375	14 3/8	14.375
14 1/2	14.5	14 1/2	14.5
14 5/8	14.625	14 5/8	14.625
14 3/4	14.75	14 3/4	14.75
14 7/8	14.875	14 7/8	14.875
15	15.0	15	15.0
15 1/8	15.125	15 1/8	15.125
15 1/4	15.25	15 1/4	15.25
15 3/8	15.375	15 3/8	15.375
15 1/2	15.5	15 1/2	15.5
15 5/8	15.625	15 5/8	15.625
15 3/4	15.75	15 3/4	15.75
15 7/8	15.875	15 7/8	15.875
16	16.0	16	16.0
16 1/8	16.125	16 1/8	16.125
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16 3/8	16.375	16 3/8	16.375
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16 5/8	16.625	16 5/8	16.625
16 3/4	16.75	16 3/4	16.75
16 7/8	16.875	16 7/8	16.875
17	17.0	17	17.0
17 1/8	17.125	17 1/8	17.125
17 1/4	17.25	17 1/4	17.25
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18 5/8	18.625	18 5/8	18.625
18 3/4	18.75	18 3/4	18.75
18 7/8	18.875	18 7/8	18.875
19	19.0	19	19.0
19 1/8	19.125	19 1/8	19.125
19 1/4	19.25	19 1/4	19.25
19 3/8	19.375	19 3/8	19.375
19 1/2	19.5	19 1/2	19.5
19 5/8	19.625	19 5/8	19.625
19 3/4	19.75	19 3/4	19.75
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20	20.0	20	20.0
20 1/8	20.125	20 1/8	20.125
20 1/4	20.25	20 1/4	20.25
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25	25.0	25	25.0
25 1/8	25.125	25 1/8	25.125
25 1/4	25.25	25 1/4	25.25
25 3/8	25.375	25 3/8	25.375
25 1/2	25.5	25 1/2	25.5
25 5/8	25.625	25 5/8	25.625
25 3/4	25.75	25 3/4	25.75
25 7/8	25.875	25 7/8	25.875
26	26.0	26	26.0
26 1/8	26.125	26 1/8	26.125
26 1/4	26.25	26 1/4	26.25
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27	27.0	27	27.0
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27 3/4	27.75	27 3/4	27.75
27 7/8	27.875	27 7/8	27.875
28	28.0	28	28.0
28 1/8	28.125	28 1/8	28.125
28 1/4	28.25	28 1/4	28.25
28 3/8	28.375	28 3/8	28.375
28 1/2	28.5	28 1/2	28.5
28 5/8	28.625	28 5/8	28.625
28 3/4	28.75	28 3/4	28.75
28 7/8	28.875	28 7/8	28.875
29	29.0	29	29.0
29 1/8	29.125	29 1/8	29.125
29 1/4	29.25	29 1/4	29.25

PART NUMBER: P4-03-0001-001 P/N REV: (-)
DESCRIPTION: BATTERY PACK, SRB-406
ROUTING: P4-03-0001-001 RTG REV: 0
WO QUANTITY: 5
WO DUE DATE: 01/02/03
WO COMMENT: PER:DEAN'S EMAIL 12/18/02

D+S W/O#: 5301-70
D+S
S/N:

SEQ#	STEP#	DESCRIPTION	WORK CENTER#	DESCRIPTION	TOTAL STD HRS	SET UP HRS	DATE	EMPLOYEE STAMP/INIT
------	-------	-------------	--------------	-------------	------------------	---------------	------	------------------------

Special Material Handling Requirements

- Care shall be taken to prevent contamination of materials with foreign objects. Foreign objects such as food, beverages, personal effects, production process by products, discarded packaging or any other items which are not part of the required material handling activities are to be immediately removed from the work areas.
- All Electrostatic Discharge Sensitive(ESD) materials must be handled observing the appropriate ESD protection measures, which include: ESD marking and ESD packaging protection, as well as, handling in an ESD protected workstation when not protected by ESD packaging.
- All hazardous materials must be handled using containers and other protection devices in order to prevent any spillage and/or contact with the hazardous characteristics of the materials. This includes following recommendations contained in material safety data sheets.
- Production Control Manager approval is required when more than three splits are needed.
- All operations are to be performed per DME Workmanship Standards and any applicable MPPs or SMPs.
- Nonconforming material shall be handled and dispositioned in accordance with procedure DME.QUA.450-01.

Qty	Split	S/N's	Date & Sign

PART NUMBER: P4-03-0001-001 P/N REV: (-)
DESCRIPTION: BATTERY PACK, SRB-406
ROUTING: P4-03-0001-001 RTG REV: 0
WO QUANTITY: 5
WO DUE DATE: 01/02/03
WO COMMENT: PER:DEAN'S EMAIL 12/18/02

D+S _____ W/O#: 5301-70
D+S _____
S/N: _____

SEQ# STEP# DESCRIPTION

WORK CENTER#
DESCRIPTION

TOTAL SET UP DATE
STD HRS HRS

EMPLOYEE
STAMP/INI

090

GENERAL NOTES

1111

GENERAL NOTES

10 PHANTOMS: A3-03-1006-001

N/A N/A

** CAUTION: LITHIUM MANGANESE DIOXIDE
BATTERIES. DO NOT SHORT CIRCUIT, NOR
EXPOSE TO EXCESSIVE HEAT, NOR HEAT
FOR EXTENDED PERIODS OF TIME.
DO NOT PLUG OR COVER VENT HOLE.
DO NOT CONTACT VENT TANG INSIDE
BATTERY.
DO NOT RECHARGE.

100

CUT AND STRIP WIRES

1 DO THE FOLLOWING PER DWG A3-03-1006-001:
1. CUT WIRES TO LENGTH AND STRIP.

COLOR LENGTH STRIP-A STRIP-B
RED ~~5.00"~~ 0.000" 0.23"
BLK ~~5.00"~~ 0.000" 0.23"

ASSEMBLE CELL STACK

12/12

.0425

5301 FTL COMM BATTERY CELL

12-19-02

ONE PROD

120

1 DO THE FOLLOWING PER DWG A3-03-1006-001:
1. TAPE CELLS TOGETHER PER DWG. CONFIG.
USE FIXTURE #T3-06-1006-001A

WELD CELL STACK ASSY

.3330

5301 FTL COMM BATTERY CELL

12-19-02

ONE PROD

140

1 ** CAUTION: USE SAFETY GLASSES FOR THIS
OPERATION.

** REFER TO SMP #2020

DO THE FOLLOWING PER DWG A3-03-1006-001:
1. PLACE GLASS TAPE ON CELLS IN CENTER
WELD AREA PER DRAWING.
2. WELD CELL STRIPS TO BATTERIES PER
DRAWING.

160

INSPECT WELDS

1260
QUALITY CONTROL MAIN

12-19-02

ONE PROD

PART NUMBER: P4-03-0001-001 P/N REV: (-)
DESCRIPTION: BATTERY PACK, SRB-406
ROUTING: P4-03-0001-001 RTG REV: 0
WO QUANTITY: 5
WO DUE DATE: 01/02/03
WO COMMENT: PER:DEAN'S EMAIL 12/18/02

D+S
D+S
S/N:

W/O#: 5301-70

SEQ# STEP# DESCRIPTION

WORK CENTER#
DESCRIPTION

TOTAL SET UP DATE
STD HRS HRS

EMPLOYEE
STAMP/INIT

10 PERFORM IN-PROCESS INSPECTION IN
ACCORDANCE WITH WI FTL.QUA.430.02,5.3.

180 FINAL ASSEMBLY, SRB-406 BATTERY

1 ** CAUTION: USE SAFETY GLASSES FOR THIS
OPERATION.

**
DO THE FOLLOWING PER DWG A3-03-1006-001:
1. SOLDER WIRES TO WELD TABS.
2. PLACE INSULATOR BETWEEN CELL STACKS.
3. PLACE END INSULATORS ON STACK.
4. ROUTE WIRES THRU HOLE IN TOP
INSULATOR. TIE-WRAP STRAIN RELIEF.

2 DO THE FOLLOWING PER DWG A3-03-1006-001:
1. CUT HEAT SHRINK TUBING TO 6.12" LG.
2. PLACE STACK INTO TUBING AND SHRINK.
NOTE: ENSURE ENDS OF TUBING ARE
FLATTENED AGAINST INSULATOR.

3 DO THE FOLLOWING PER DWG A3-03-1006-001:
1. TRIM WIRES ONE AT A TIME TO 5.25" LG.
2. ONE AT A TIME: STRIP WIRE 0.13" AND
CRIMP TERMINAL TO WIRE. INSERT
TERMINAL INTO CONNECTOR HSG. PER DWG.
** ASSEMBLY NOTES: 1)TERMINATING ONE
WIRE AT A TIME WILL HELP PREVENT
SHORTING WIRES TOGETHER.
2)USE MOLEX CRIMPER #11-01-0208
POSITION "A" (CAL #453).)
3)WHEN INSERTING TERMINAL INTO
HOUSING MAKE SURE THE SLIT IN THE
TERMINAL IS TOWARD THE LATCH ON THE
HOUSING. IT ONLY FITS ONE WAY.
4)ENSURE ALL THE TERMINALS LATCH
FULLY INTO THE HOUSING AND CANNOT
BE PULLED OUT OF HOUSING BY HAND.

4 DO THE FOLLOWING PER DWG A3-03-1006-001:
1. MARK LABEL WITH DOM, LOT#, AND EXP.
DATE.
2. APPLY LABEL TO BATTERY ASSEMBLY.
3. INSTALL FOAM PAD ONTO BATTERY ASSY.

5301 FTL COMM BATTERY CELL

.5000

5 12-20-02



--- DME CORRECTION ---
STANDARD OPERATION SHEET

PART NUMBER: P4-03-0001-001
DESCRIPTION: BATTERY PACK, SRB-406
ROUTING: P4-03-0001-001
WO QUANTITY: 5
WO DUE DATE: 01/02/03
WO COMMENT: PER:DEAN'S EMAIL 12/18/02

D+S _____ W/O#: 5301-70
D+S _____
S/N: _____

SEQ# STEP# DESCRIPTION

WORK CENTER#
DESCRIPTION

TOTAL SET UP DATE
STD HRS HRS

EMPLOYEE
STAMP/IN

5 TEST BATTERY WITH METER.
** NOTE: LOAD 100 OHM, 10 SEC, MINIMUM
12 VDC. **

200 FINAL INSPECTION

10 PERFORM FINAL INSPECTION IN ACCORDANCE
WITH WI FTL.QUA.430.02,5.4.

220 MOVE TO STOCK

1260

QUALITY CONTROL MAIN

.0150

12-10-02

1110

PRODUCTION CONTROL

N/A

N/A



Growd Mer

PCSERGIO.FMDME

Part Number P4-03-0001-001

Revision Level: (-)

Drawing Number:

DME CORPORATION

SINGLE LEVEL ENGINEERING BILL OF MATERIAL AS OF 12/18/02 FOR SELECTED PARTS

BATTERY PACK, SRB-406

Engineering Status:

Comment:

WED, DEC 18, 2002, 2:08 PM

PAGE 1

Level

1

Line Rev

1

Start
Date

10/ 1/02

Stop
Date

Part Number

A3-03-1006-001

Rev Description

(-) POWER UNIT ASSEMBLY, 406 BEACON

Quantity

1

U/M

EA

P
B ht L
S i ao o
C n nm t
M Y

Growth
PCSERGIO.FMDME

12/18/02

INCORPORATION
PICK LIST

SORTED BY STOCK LOCATION

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PAGE 1

WO #: 5301-70

Part Number: P4-03-0001-001

Description: BATTERY PACK, SRB-406

Quantity: 5

Rev. Level: (-)

Comment:

U/M: EA

WO Comment: PER:DEAN'S EMAIL 12/18/02

Eng. Status:

Item Description

U/M SC

Stockroom

Location

Required Part Number

Issued

Short

STRIP,WLD,.880 X.156,.003 THK,S 00/00/00	EA	P	BAT	FS	20 A1-17-0314-005	0	20
INSULATOR,.080 THK,406 BATTERY	00/00/00	EA	P	COMM	B18B	✓	
INSULATOR,.030 THK,406 BATTERY	00/00/00	EA	P	COMM	E17C	✓	
CELL,1-1/4 C SIZE,Li/MnO2,3V,FL 00/00/00	EA	P	COMM	ELEC	20 A1-13-0093-001	✓	
TERMINAL,CRIMP,FEMALE BOX,22-24 00/00/00	EA	P	COMM	F15C	10 A1-03-0199-001	✓	
HOUSING,CRIMP,4 COND,POSITIVE L 00/00/00	EA	P	COMM	F17D	5 A1-03-0197-001	✓	
SPACER,FOAM,1 X 1 X .125	00/00/00	EA	P	COMM	N12B	✓	
LABEL,ID,BATTERY,SRB,MODEL 406	00/00/00	EA	P	COMM	P1F	✓	
WIRE TIE,3.75 LG	00/00/00	EA	P	COMM	T7C	✓	
WASHER,INSULATOR,SRB-406	00/00/00	EA	P	ZZ	20 A1-26-0084-001	0	20
TUBING,HEAT SHRINK,FLAT,72 MM,B 00/00/00	FT	P	ZZ	ZZ	3 A2-20-0079-001	0	3

PICK LIST COMPLETED SUCCESSFULLY