## Change Notice (DCN)

### Change Description

<table>
<thead>
<tr>
<th>Document Change Notice (DCN)</th>
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<tr>
<td><strong>DCN HEPI Quiet Hydraulic Actuator Assembly</strong></td>
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</tbody>
</table>

**CHANGE DESCRIPTION (FROM/TO):**

- **D020367-B Manifold Large Plug**
  - Added broach for Standard 5/16 Allen Wrench Hex; Original size 16 O-ring

- **D020367-B Part 2A Large Plug**
  - Resized clearance hole from 1/4” to 3/8” to clear 5/16 Allen Wrench Hex

- **D020285-B Actuation Plate**
  - Raised position of pin valve from .537 to .57 to avoid interference with inside edge; Added weld insert for bleed tube; Reduced diameter from .453 to .32 to fit 5/16 bolt.

- **D020300-B Manifold**
  - Added weld insert for actuator bleed tube.

- **D020369-B Attachment Plate**
  - Suppressed inner-hole pattern for Stanford test mounting as discussed with Kern and Hammond.

- **D020371-B Tripod Base**
  - Reduced hole diameter from .453 to .32 to fit 5/16 bolt.

- **D020371-B Tripod Vertical Post**
  - Tapered upper end for easy installation into tripod base; Reduced bolt diameter from 7/16 to 5/16 as suggested by Kern.

- **D020359-B Small Pin Valve**
  - Extended length of pin valve from .826 to .854 to ensure sufficient seal. Added maximum broach depth to .150 as suggested by Kern. Changed material to 17-4 PH from Brass.

**ACTION:**

- Incorporate Change
- Attach DCN to Drawings
- Other Action (specify):

**Disposition of Hardware (Identify Serial Numbers):**

- No hardware was affected (record change only):
- List S/Ns which comply already:
- List S/Ns to be reworked/scraped:
- List S/N’s to be built with this change: - all production units for LLO
- List S/Ns to be retested per this change:

**DCN Distribution:**

- Barish
- Zucker
- Coyne
- Lazzarini
- Lindquist
- Sanders
- Shoemaker
- Tyler
- Weiss
- Whitcomb
- Matherny
- Raab
- Lantz
- Kern

**Safety, Cost, Schedule, Requirements Impact:**

- No

**Approvals:**

<table>
<thead>
<tr>
<th>Approvals</th>
<th>Date</th>
<th>Other Approvals (Specify)</th>
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<tbody>
<tr>
<td>ORIGINATOR: Hammond / Spjeld</td>
<td>8/12/03</td>
<td>Coyne</td>
</tr>
<tr>
<td>TASK LEADER: Kern</td>
<td></td>
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<td>GROUP LEADER: Lantz</td>
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**DCC Release:**

| TASK LEADER: Kern | | |
| GROUP LEADER: Lantz | | |

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This document contains information about changes to a hydraulic actuator assembly. Each change is detailed with the part number and a description of the changes made. The action to be taken is specified as incorporating the changes into the design. The disposition of hardware is tracked to ensure that all changes are properly accounted for in the production process.
D020359-B Actuator Plate Plug  Added broach for Standard 3/16 Allen Wrench Hex; Original size 12 O-ring

D020359-B Part 2A Actuator Plate Plug  Resized through hole from 7/32” to 1/4” to clear 3/16 Allen Hex

**Drawings Only**

D020286-B Actuator Diaphragm  Removed flatness callout according to R/L by Kern.

D020291-B Top Bellow Slug & Cap  Added missing dimension for thickness .250 for Cap.

D020293-B Bottom Bellow Slug & Cap  Added missing dimension for thickness .250 for Cap.

D020300-D Manifold  Added surface finish symbol and machining area for valve mount.

D020301-B Manifold Weld Caps  Reduced dimensions from .XXX to .XX according to R/L by Kern.

D020302-B Bellows Shield  Changed slit dimension from 0.005 to 0.015, optional wire EDM or slitting saw according to R/L suggestion by Kern.

D020303-B Oil Catch  Reduced dimensions from .XXX to .XX according to R/L by Kern.

D020284-B Actuator General View  Updated list of drawings and referring sheet numbers.

D020373-00 Actuator Bleed Tube Insert Sleeve  New drawing for dimensioning an insert sleeve for the actuator bleed tube.

D020374-00 Actuator Bleed Tube Assembly  New drawing for the actuator bleed tube assembly.

**For All Assembly Drawings:**

Replaced callouts with part no., description and sheet no. with item no. balloons and bill of materials list.

D020286-B Actuator Exploded Assembly; D020360-B Bellows Sub-Assembly;
D020361-B Top Foundation Plate Assembly; D020362-B Bottom Foundation Plate Assembly;
D020363-B Side Foundation Plate Assembly; D020364-B Back Foundation Plate Assembly;
D020365-B Manifold Assembly; D020368-B Tripod Assembly.