



National Aeronautics and
Space Administration

<p>MEASUREMENT SYSTEM IDENTIFICATION</p>

MSFC-STD-372

REVISION B

EFFECTIVE DATE: August 4, 2005

George C. Marshall Space Flight Center
Marshall Space Flight Center, Alabama 35812

EI42

**MULTIPROGRAM/PROJECT COMMON-USE
DOCUMENT**

**SILK SCREENING OF ELECTRICAL
EQUIPMENT**

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Multiprogram/Project Common-Use Document EI42		
Title: SILK SCREENING OF ELECTRICAL EQUIPMENT	Document No.: MSFC-STD-372	Revision: B
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DOCUMENT HISTORY LOG

Status (Baseline/ Revision/ Canceled)	Document Revision	Effective Date	Description
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1. SCOPE

1.1 Scope. This document establishes the requirements for silk screening of electrical equipment.

2. APPLICABLE DOCUMENTS

2.1 The following documents format part of this standard to the extent specified herein. Unless otherwise indicated, the issue in effect on the date of invitation for bids or request for proposals shall apply.

2.1.1

SPECIFICATION

SAE-AMS-T-21595 Tape, Pressure Sensitive Adhesive, Paper, Masking, Non-Staining

2.1.2

STANDARD

George C. Marshall Space Flight Center

MSFC-STD-373 Lettering of Electrical Equipment

3. DEFINITIONS

Not applicable

4. GENERAL REQUIREMENTS

4.1 Silk screening process. – The silk screening process shall be in accordance with the contractor's normal silk screening methods, provided the methods used are approved by the procuring activity. The silk screening materials shall be compatible with the surface to which the materials are applied. The materials used shall be prepared so that legibility will be retained under normal conditions. Epoxy base materials shall be applied on epoxy base surfaces. Thoroughly cured markings shall not be removed by the application and stripping of masking tape conforming to Specification MIL-T-21595.

4.2 Letter style. – The Gothic letter style (upper case preferred) to be used when silk screening electrical equipment shall be as specified in Standard MSFC-STD-373.

4.3 Location of information. – The size and location of screened markings on electrical equipment shall be as shown on the applicable engineering drawing.

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4.4 Workmanship. – The completed markings shall be free from ragged edges, smearing, scratches, imperfect or misaligned characters, and excess marking material. Lines and characters shall be acceptable when the deviation from smooth edges does not exceed 0.004 inch (peaks plus crevices). The first squeegee sweep shall give complete coverage, with no mesh markings, nor entrapment of air bubbles.

5. DETAILED REQUIREMENTS

5.1 Instrument module marking. – The letter size to be used on instrument modules (welded modules) shall be as specified on the applicable engineering drawing. For the purposes of marking instrument modules, the minimum letter sizes illustrated on figure 1 of Standard MSFC-STD-373 shall not be considered restrictive, provided legibility is maintained.

5.2 Paint. – The paint used in silk screening shall be nonconductive, fungus-resistant type that is approved by the procuring activity and compatible with the surfaces and environment where used.

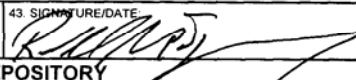
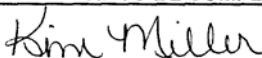
5.3 Color. – The color of the characters shall provide adequate contrast with the surface color of the part; if other than black, color shall be specified by the applicable drawing.

5.4 Changes, deviations, or waivers. – No technical changes, deviations, or waivers will be made to the requirements of this document without the approval of the cognizant design engineering activity of MSFC. All changes, deviations, or waivers will be submitted to the Engineering Specifications and Standards Section, Propulsion and Vehicle Engineering Laboratory (R-P&VE-VNR), Huntsville, Alabama for coordination with the cognizant activity.

6. NOTES

When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

Copies of specifications, standards, drawings, and publications required by contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.

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