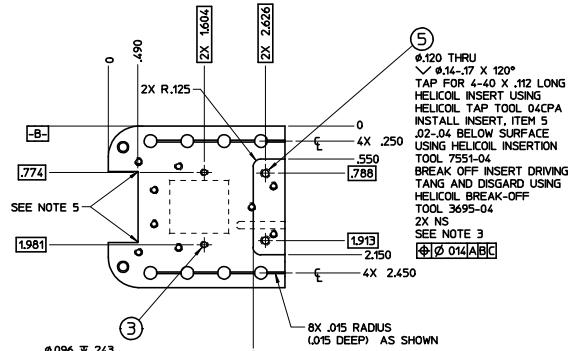
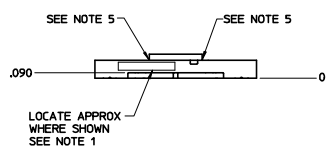
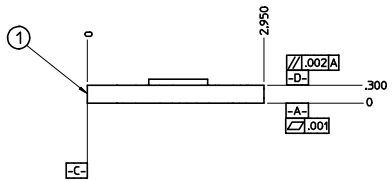
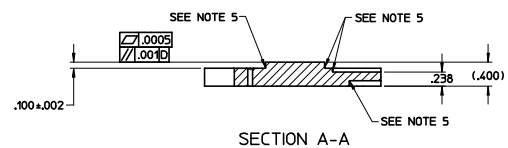
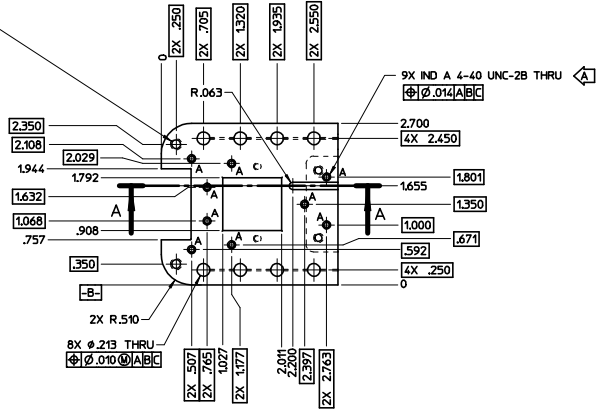


166857-D

DATE	APP'D	QTY	REV	CHG	BY	DATE	DESCRIPTION
							ADD COLLAR MTG HOLES PER DCN H1880, ERA

7
 Ø.147 THRU
 ✓ Ø.18-.21 X 120°
 TAP FOR 6-32 X .207 LONG
 HELICOL INSERT USING
 HELICOL TAP TOOL 06CPA
 INSTALL INSERT, ITEM 7
 .02-.05 BELOW SURFACE
 USING HELICOL INSERTION
 TOOL 7551-06
 BREAK OFF INSERT DRIVING
 TANG AND DISCARD USING
 HELICOL BREAK-OFF
 TOOL 3695-06
 2X NS
 SEE NOTE 3
 Ø.014[A][B][C]



3
 Ø.096 ✓ 243
 ✓ Ø.09-.11 X 120°
 TAP FOR 2-56 X .172 LONG
 HELICOL INSERT USING
 HELICOL TAP TOOL 06CBA
 INSTALL INSERT, ITEM 3
 .01-.03 BELOW SURFACE
 USING HELICOL INSERTION
 TOOL 551-02
 BREAK OFF INSERT DRIVING
 TANG AND DISCARD USING
 HELICOL BREAK-OFF
 TOOL 3695-02
 2X NS
 SEE NOTE 3
 Ø.014[A][B][C]

5
 Ø.120 THRU
 ✓ Ø.14-.17 X 120°
 TAP FOR 4-40 X .112 LONG
 HELICOL INSERT USING
 HELICOL TAP TOOL 04CPA
 INSTALL INSERT, ITEM 5
 .02-.04 BELOW SURFACE
 USING HELICOL INSERTION
 TOOL 7551-04
 BREAK OFF INSERT DRIVING
 TANG AND DISCARD USING
 HELICOL BREAK-OFF
 TOOL 3695-04
 2X NS
 SEE NOTE 3
 Ø.014[A][B][C]

1. MARK PER LL SPEC PS 7-1 CLASS IV (VB PENCIL) IN AREA DESIGNATED.
2. MATERIAL: ELECTROLYTIC TOUGH PITCH COPPER, CDA 110, 1/2 HARD TEMPER.
3. PLATING: ELECTROLESS NICKEL PLATE PER ASTM B 733-90, SC1, TYPE-I, CLASS 3, CU/NP 5, 200 + 50 MICRO INCHES THICK. MINIMUM PHOSPHORUS CONTENT OF THE NICKEL DEPOSIT SHALL BE 8%. OVERPLATE GOLD PER MIL-G-45204 TYPE III, GRADE A, 25-50 MICRO INCHES THICK PRIOR TO INSTALLING ITEMS 3, 5 AND 7.
4. DIMENSIONS APPLY AFTER PLATING.
5. .005/.010 INTERNAL RADII ON ALL INTERNAL CORNERS.

NOTES

ERA NO	MATERIAL	USED ON	DRWN FOR	DATE	LINCOLN LABORATORY MASSACHUSETTS INSTITUTE OF TECHNOLOGY LENOX, MASSACHUSETTS
	SEE NOTE 2	Astro-E2	S. Pillebury	2002/03	
ASSOCIATIVITY ?	FINISH AND/OR HEAT TREATMENT	NEXT APPROVAL	DESIGNED BY	2002/03	HEATSINK FOCAL PLANE ASSY Astro-E2
FILE NAME: 458991	SEE NOTE 3	458991	A. Pillebury	2002/03	
DIRECTORY ? WM		SCALE	1:1		TASK NO 10033-1
USED PARTS ? N/A		CLASSIFICATION			
USED LAYERS ?		ENVIRONMENT USED	ANNOTATOR		DATE NO

