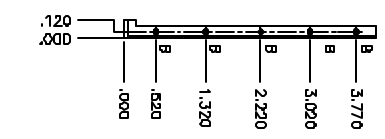
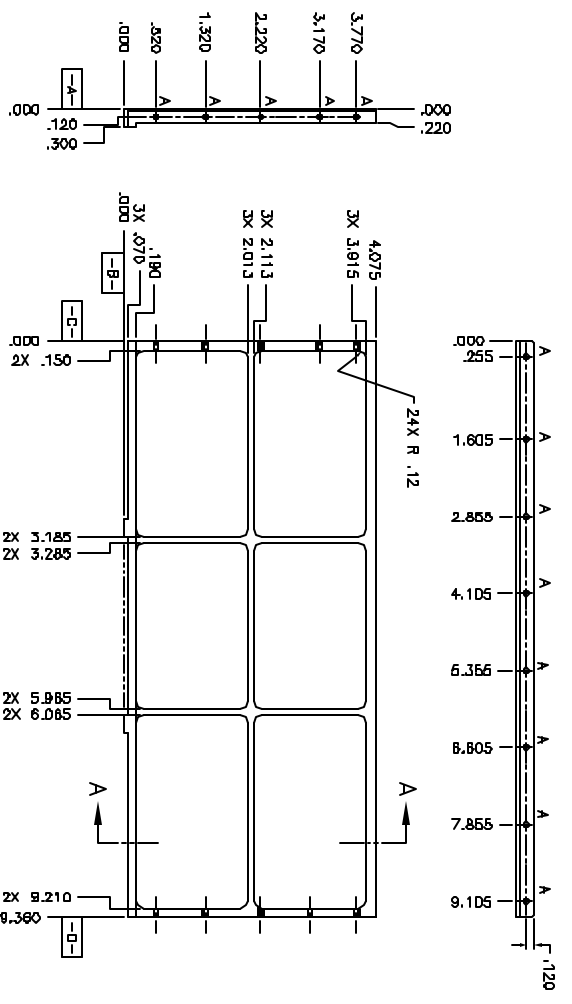


DATE	BY	DESCRIPTION	APPROVED	DATE
A 30-807		INITIAL RELEASE (From 20-201907 04)		



2X ϕ .120 \pm .003 THRU \sphericalangle ϕ .100 \pm .015 X 120' \pm .5'.
 TAP ϕ .170 FOR .112-40 UNC HELICAL STL.
 INSTALL INSERT (FN 2) 3/4 - 1 1/2 PITCH BELOW
 SURFACE. INSTALL INSERT AFTER FINISH.

HOLE	QTY	TOLERANCE	DESCRIPTION
A	13	ϕ .070 \pm .003 C/A/B	ϕ .084 \pm .003 THRU \sphericalangle ϕ .100 \pm .010 X 120' \pm .5'. TAP THRU FOR .088-56 UNC HELICAL STL. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
B	5	ϕ .070 \pm .003 D/A/B	

- NOTES:
1. MATERIAL: 6061-T6S1 AL PER QQ-A-250/11.
 2. REMOVE ALL BURRS AND SHARP EDGES R.010 MAXIMUM.
 3. UNTOLERANCED DIMENSIONS LOCATING TRLE POSITION ARE BASIC.
 4. FINISH: CHEMICAL FILM PER MIL-C-5541, CLASS 3.
 5. HANDLE PART IN ACCORDANCE WITH 28-01303.

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS SHALL BE
 AS NOTED
 DIMENSIONS ARE IN INCHES
 TOLERANCES UNLESS
 OTHERWISE SPECIFIED
 1/2 PLACE DECIMALS \pm .01
 THIRD ANGLE
 PROJECTION

MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 CENTER FOR
 CHEMICAL PROCESSING

SHIELD

DATE: 8/22/30
 DRAWN: 30-20807
 CHECKED: 1 OF 1
 APPROVED: A