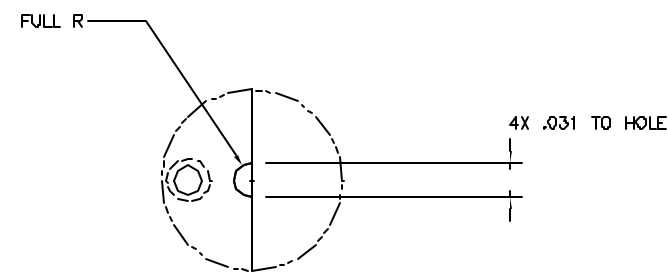
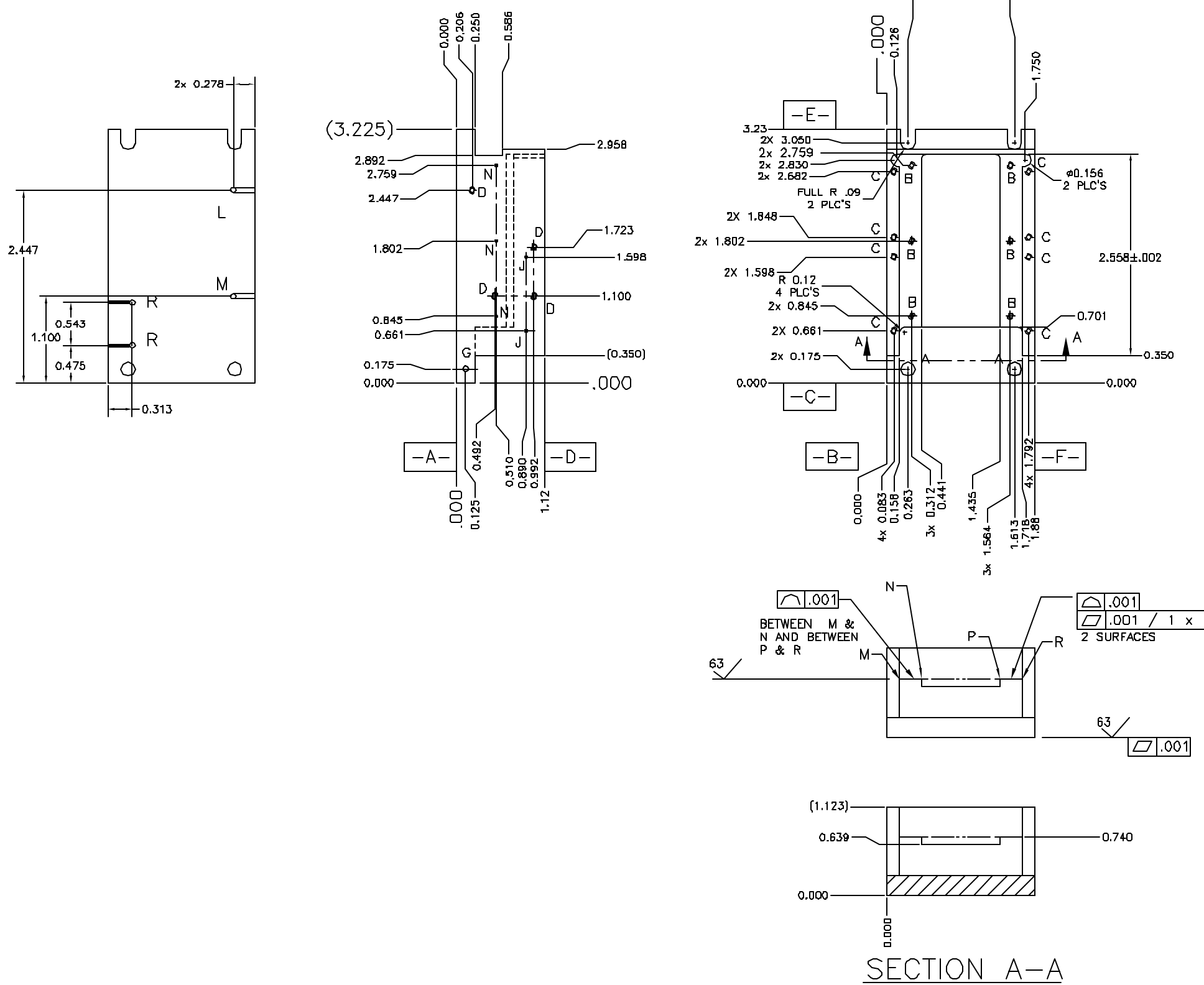


REV.		REVISIONS		
ECD NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A 30-006	INITIAL RELEASE	EAB	RF	7/9/02
B 30-013	change relief cut diamter to .156			



VIEW A

HOLE CHART			
HOLE	QTY	TOLERANCE	DESCRIPTION
A	2	$\Phi \pm 0.010 \text{ (M) A B C}$	$\phi .180 \begin{smallmatrix} +.003 \\ -.002 \end{smallmatrix}$ THRU
B	6	$\Phi \pm 0.010 \text{ (M) D B C}$	$\phi .094 \begin{smallmatrix} +.003 \\ -.002 \end{smallmatrix}$ $\nabla .236-.286$ , $\sphericalangle \phi .100 \pm .010 \times 120^\circ \pm 5^\circ$ , TAP $\nabla .100$ MINIMUM FOR No. 2-56 UNC HELICAL STI. HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
C	8	$\Phi \pm 0.010 \text{ (M) D B C}$	$\phi .094 \begin{smallmatrix} +.003 \\ -.002 \end{smallmatrix}$ $\nabla .236-.286$ , $\sphericalangle \phi .100 \pm .010 \times 120^\circ \pm 5^\circ$ , TAP $\nabla .100$ MINIMUM FOR No. 2-56 UNC HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
D	4	$\Phi \pm 0.010 \text{ (M) B A C}$	$\phi .094 \begin{smallmatrix} +.003 \\ -.002 \end{smallmatrix}$ $\nabla .236-.286$ , $\sphericalangle \phi .100 \pm .010 \times 120^\circ \pm 5^\circ$ , TAP $\nabla .100$ MINIMUM FOR No. 2-56 UNC HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
E		NOT USED	
F	2	$\Phi \pm 0.010 \text{ (M) F A C}$	$\phi .120 \begin{smallmatrix} +.003 \\ -.002 \end{smallmatrix}$ $\nabla .318-.368$ , $\sphericalangle \phi .155 \pm .015 \times 120^\circ \pm 5^\circ$ , TAP $\nabla .140$ MINIMUM FOR No. 4-40 UNC HELICAL STI. INSTALL INSERT (FN 2) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
G	1	$\Phi \pm 0.010 \text{ (M) B A C}$	$\phi .070 \nabla .220$ (THRU TO HOLE)
H	1	$\Phi \pm 0.010 \text{ (M) F A C}$	$\phi .070 \nabla .220$ (THRU TO HOLE)
J	2	$\Phi \pm 0.010 \text{ (M) B A C}$	$\phi .031 \nabla .100$ (THRU TO HOLE)
K	2	$\Phi \pm 0.010 \text{ (M) F A C}$	$\phi .031 \nabla .100$ (THRU TO HOLE)
L	1	$\Phi \pm 0.010 \text{ (M) A B C}$	$\phi .070 .20$ (THRU TO HOLE)
M	1	$\Phi \pm 0.010 \text{ (M) A B C}$	$\phi .070 .50$ (THRU TO HOLE)
N	3	$\Phi \pm 0.010 \text{ (M) B A C}$	$\phi .031 \nabla .263$ (THRU TO HOLE)
P	3	$\Phi \pm 0.010 \text{ (M) F A C}$	$\phi .031 \nabla .263$ (THRU TO HOLE)
R	2	$\Phi \pm 0.010 \text{ (M) A B C}$	$\phi .070 .12$ (THRU TO HOLE)



SECTION A-A

NOTES:

1. MATERIAL: ALUMINUM ALLOY 6061-T651.
2. REMOVE ALL BURRS AND SHARP EDGES R.010 MAXIMUM.
3. UNTOLERANCED DIMENSIONS LOCATING TRUE POSITION ARE BASIC.
4. FINISH: ELECTROLESS NICKEL PLATE PER ASTM B 733-TBD, SC1, TYPE I, CLASS 4,  $AlMg_1Si_0.6/NiP_5$ ,  $200 \pm 50$  MICRO INCHES THICK. MAXIMUM PHOSPHORUS CONTENT OF THE NICKEL DEPOSIT SHALL BE 8% BY MASS.

NAME	DATE
DRAWN M. SMITH	6/22/02
CHECKED ED. B.	7/1/02
APPROVED RICK F.	7/9/02
RELEASED DEB. C.	7/10/02

UNLESS OTHERWISE SPECIFIED:  
 DIMENSIONS SHALL BE INTERPRETED IAW ANSI Y14.5 - 1982  
 DIMENSIONS ARE IN INCHES  
 TOLERANCE: ANGLES  $\pm 1^\circ$   
 3 PLACE DECIMALS  $\pm .005$   
 2 PLACE DECIMALS  $\pm .01$   
 THIRD ANGLE PROJECTION

MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
 CENTER FOR SPACE RESEARCH  
 CAMBRIDGE, MA 02139

**HOUSING, CCD TEST FIXTURE, ASTRO-E2**

SIZE: D 80230  
 DWG. NO.: 30-50114.01  
 REV. B

SCALE: 1:1  
 SHEET: 1 OF 1