REMOVE TOP COVER TO INSTALL F/N 1. PRIOR TO VIB TESTING AND SHIPPING REMOVE TOP COVER USING HARDWARE SHOWN. TORQUE TO 54 IN-OZ. SPOT BOND USING F/N 14 PRIOR TO SHIPPING.


TORQUE TO 48 IN-OZ AND SPOT BOND USING F/N 14.

INSTALL PURGE TUBE ASSEMBLY AFTER F/N 1 IS INSTALLED TO F/N 2, PER THE FOLLOWING SEQUENCE OF STEPS:
1. INSTALL F/N 11 WITH THE LONGER THREADED SECTION INSIDE THE HOUSING.
2. INSTALL NUT (TORQUE TO 75 IN-LBS. SPOT BOND USING F/N 14).
3. INSTALL ITEMS 21 AND 9 USING HARDWARE SHOWN. ALIGN SO THAT THE ALUMINUM BLOCK AND TIE WRAP BLOCK ARE VERTICAL. TORQUE HARDWARE TO 5 IN-LBS AND SPOT BOND USING F/N 14.
4. INSTALL SWAGELOK NUT FROM F/N 12 INTO F/N 11. HAND TIGHTEN THEN TIGHTEN WITH A WRENCH 1/2 TURN. SPOT BOND WITH F/N 14.
5. ROUTE TUBING ONTO CABLE TIE BLOCKS AND SECURE WITH F/N 10, 2 PLACES.
7. ROUTE CABLE FROM F/N 1 TELESCOPE THRU OPENING IN HOUSING AND INSTALL CABLE CLAMP, F/N 13. SECURE F/N 13 WITH HARDWARE SHOWN. TORQUE TO 5 IN-LBS AND SPOT BOND USING F/N 14.
8. GROUNDING LOCATION FOR THERMAL BLANKETS. #4-40 INSERT.
9. GROUNDING LOCATION FOR ESD WRIST STRAP OR BANANA JACK GROUND WIRE.
10. TORQUE F/N 25 USING F/N 24 PER GSFC. MATERIALS PROCESSING DOCUMENT, 1-353-015. LOCATE PER GSFC TEMPLATE OR DRAWING SUPPLIED BY GSFC.
11. ASSEMBLY IS TO BE VISIBLY CLEAN AND VACUUM BAKED AT +40 C, FOR 48 HOURS.
12. ASSEMBLY HARDWARE ON THE TELESCOPE ASSEMBLY PER THE FOLLOWING:
   0-80 HARDWARE TO 1.3 IN-LBS
   2-56 HARDWARE TO 56 IN-OZ
   4-40 HARDWARE TO 8 IN-LBS
   6-32 HARDWARE TO 15 IN-OZ.
   SPOT BOND USING F/N 14.

NOTE:
- SCALE: 1:2
- WEIGHT:
- DIMENSIONS ARE IN INCHES
- TOLERANCES:
  - FRACTIONAL: MACH
  - TWO PLACE DECIMAL
  - THREE PLACE DECIMAL
- APPLICATION USED ON NEXT ASSY
- Q.A.
- MFG APPR.
- ENG APPR.
- CHECKED
- DRAWN
TOP VIEW
TOP COVER REMOVED FOR CLARITY

REAR VIEW
TOP COVER REMOVED FOR CLARITY

MITSUBISHI CRUISER PROJECT
CRUISE ASSEMBLY

SCALE: 1:4 WEIGHT:

REVDWG. NO.

DATE

NAME

COMMENTS:

Q.A.

MFG APPR.

ENG APPR.

CHECKED

DRAWN

CRUISE ASSEMBLY

2 PLC'S

32-10000_rA

12/07

M. SMITH