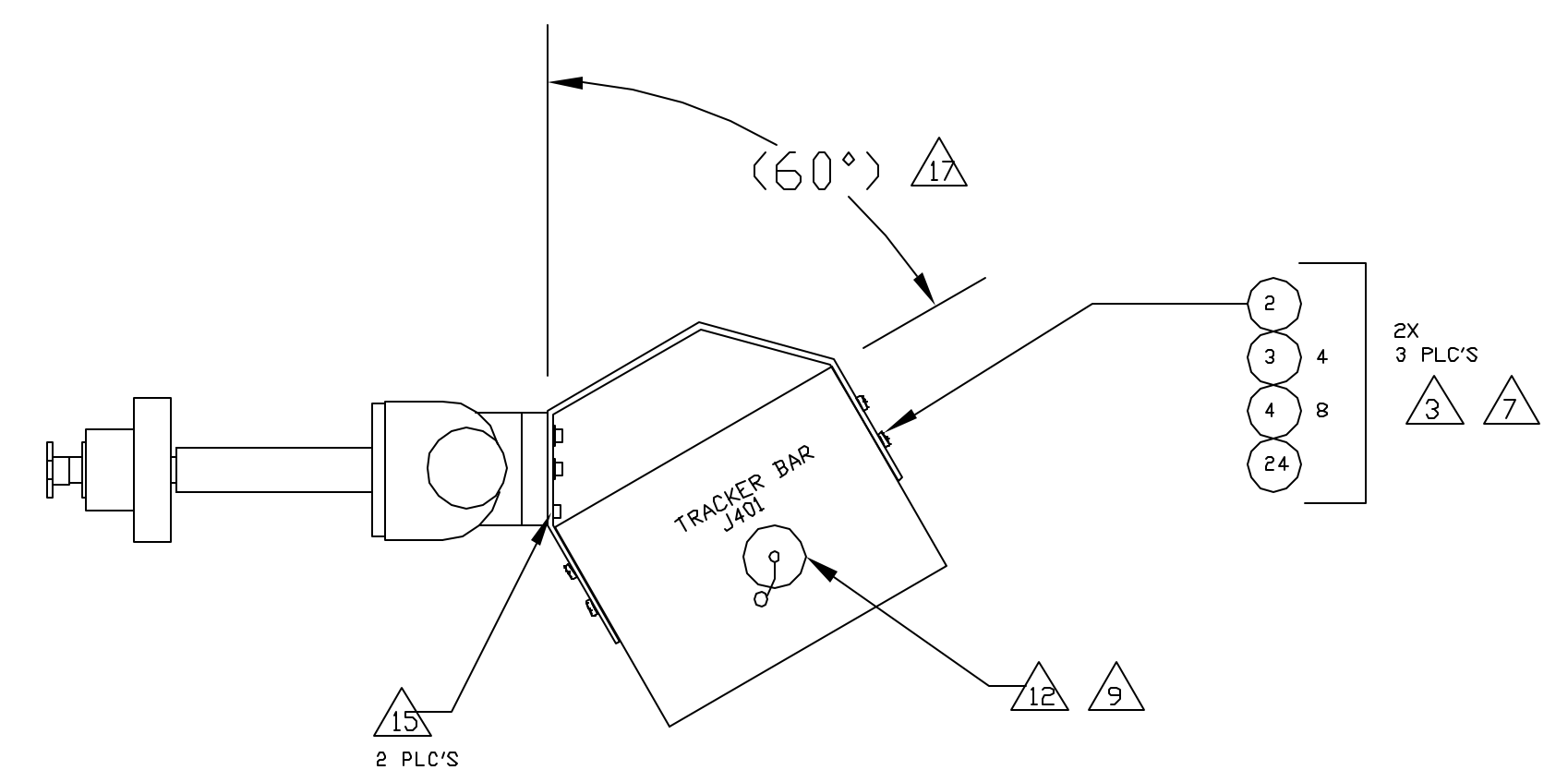
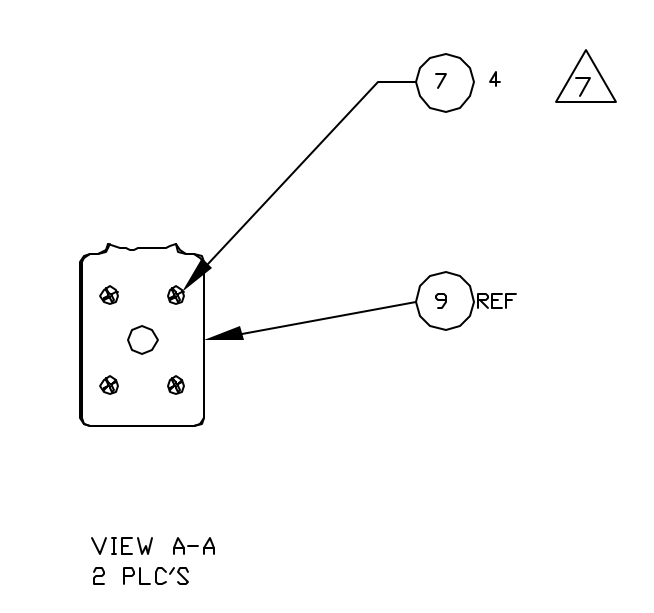
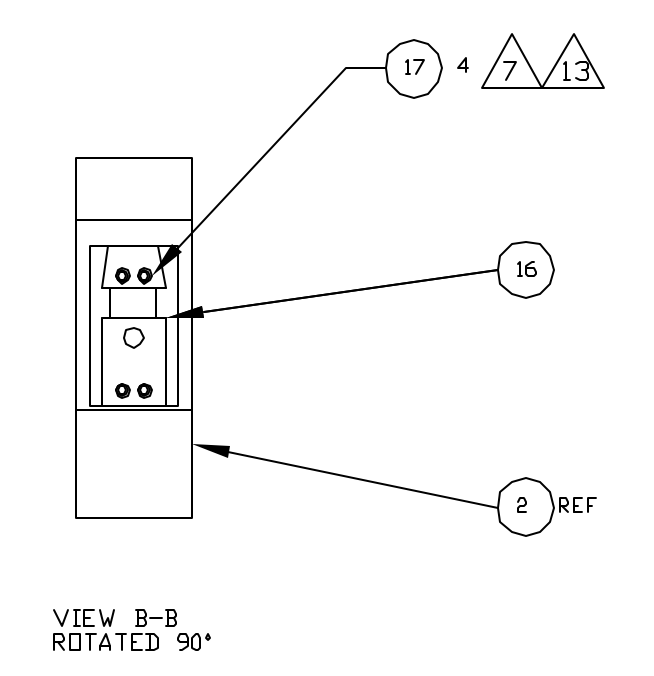
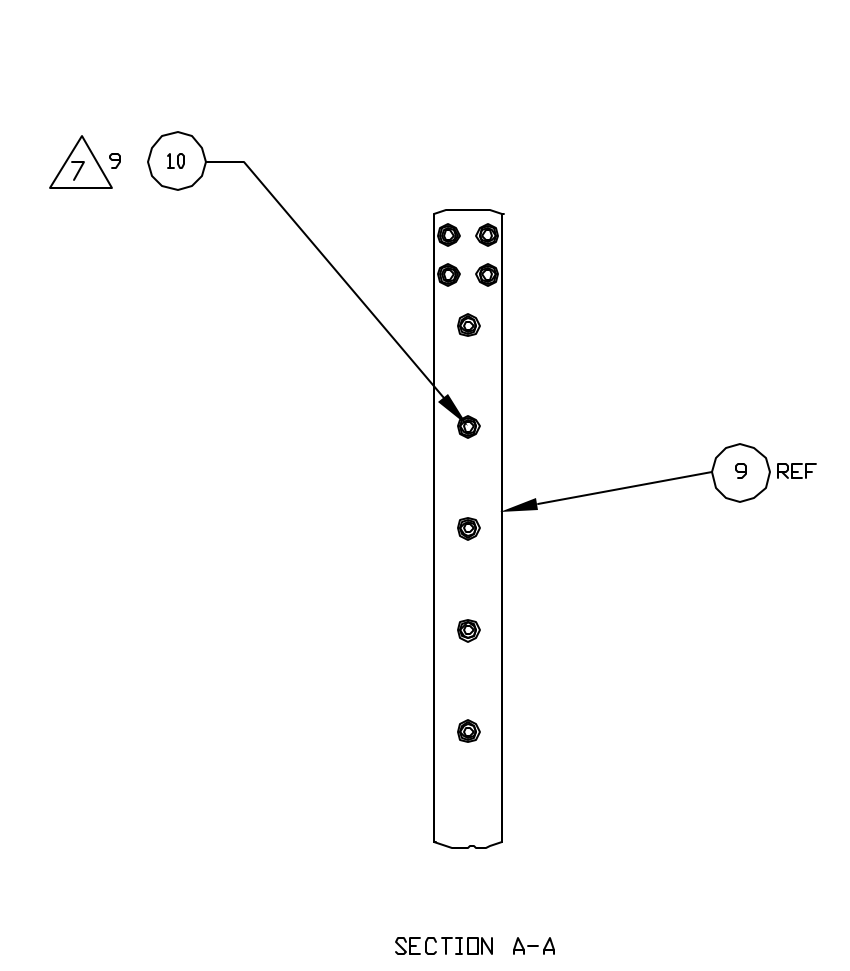
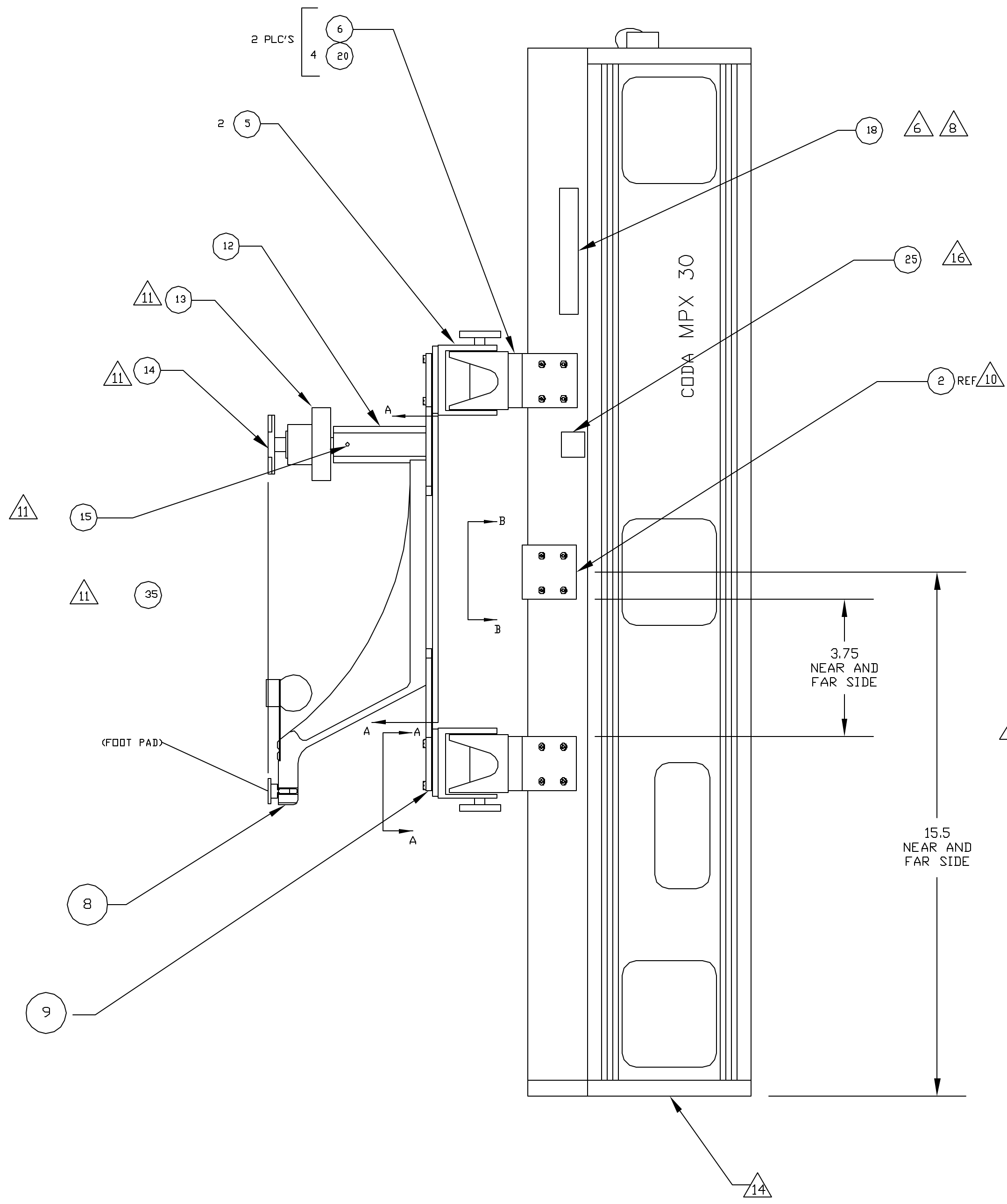


REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-94	01	INITIAL RELEASE			
85-147	A	RELEASE FOR BUILD			
85-152	B	SEE ECO			



- CLEANLINESS REQUIREMENTS PER SN-C-0005 LEVEL VC-SENSITIVE.
- SERIALIZE TRAINING UNIT STARTING WITH "10x" AND FLIGHT UNIT STARTING WITH "30x".
- AFTER NOTE 11 IS COMPLETE, INSTALL F/N 4 TO F/N 9, INSTALL F/N 6 TO F/N 2 ORIENTATING F/N 2 IDENTICALLY IN BOTH PLACES, INSTALL F/N 5 TO F/N 6 USING HARDWARE SUPPLIED WITH F/N 5. LEAVE HARDWARE LOOSE. REMOVE ENDCAP ON F/N 1. SLIDE A QTY OF 3 EACH OF F/N 3 INTO SLOTS. SECURE F/N 2 TO F/N 3 USING F/N 4 (SEE NOTE 10 FOR CENTER BRACKET ASSEMBLY). POSITION ASSEMBLY SO THAT IT IS CENTERED ALONG THE LENGTH OF F/N 1. TORQUE ALL HARWARE AFTER ALIGNMENT.
- WEIGH ASSEMBLY AFTER FINAL FABRICATION. RECORD IN A.W.D.
- RECORD EPOXIES USED, MIX RATIOS AND EXPIRATION DATES ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF A.W.D.

- △ 6 APPLY IMS LABEL (ITEM 18) APPROXIMATELY WHERE SHOWN. PLACE SO TEXT IS READING IN THE SAME DIRECTION AS MIT LABEL.
- △ 7 TORQUE M2.5 HARDWARE TO 60 IN-OZ.  
TORQUE 4-40 HARDWARE TO 5 IN-LBS.  
TORQUE 6-32 HARDWARE TO 8 IN-LBS.
- △ 8 MARK MIT ASSY NUMBER, REV AND SERIAL NUMBER IN .1 HIGH CHARACTERS. SERIALIZE PER NOTE 2.
- △ 9 MARK THE ORIENTATION OF CONNECTOR MAIN KEY WAY USING MARKING INK (ITEM 19).
- △ 10 LOCATE F/N 2 AT THE CENTER OF GRAVITY OF COMPLETED ASSEMBLY, AND TORQUE PER NOTE 7.
- △ 11 INSTALL F/N 8 AND 12 TO F/N 9. TORQUE HARDWARE. INSTALL F/N 13 ALL THE WAY DOWN F/N 14 (DO NOT TIGHTEN). INSTALL F/N 14 INTO F/N 12. ADJUST HEIGHT SO THE SEAT TRACK STUD BASE IS PARALLEL AND COLLINEAR WITHIN .002 OF THE FOOT PAD ON F/N 3. FIT CHECK ON SEAT TRACK FIXTURE. DRILL AND PIN F/N 12 AND 14 AND INSTALL F/N 15. FILE F/N 15 FLUSH. PERFORM THIS OPERATION PRIOR TO INSTALLING TO F/N 5.
- △ 12 MARK CONNECTOR REF. DES. AS SHOWN USING .125 HIGH CHARCTERS.
- △ 14 REMOVE AND RETAIN END CAP. REINSTALL AFTER F/N 2 AND SEAT TRACK ASSEMBLY IS COMPLETED. SPOTBOND WITH F/N 11.
- △ 15 DO NOT INSTALL FLAT WASHER AT THIS LOCATION.
- △ 16 PLACE F/N 25 SO IT PROTECTS THE KNOB F/N 13, FROM THE HOUSING.
- △ 17 MOUNT SEAT TRACK ASSEMBLY PEICES ON THE 60° ANGLE PART OF F/N 2.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE: ANGLES +/- 1° 3 PLACE DECIMALS +/- .005 2 PLACE DECIMALS +/- .01		NAME M. SMITH	DATE 4/7/04	Massachusetts Institute of Technology Center for Space Research VOILA	
MATERIAL N/A		CHECKED		TRACKER BAR	
WEIGHT 15.5-15.0 FINISH LBS		APPROVED			
NEXT ASSEMBLY	USED ON	RELEASED		SIZE D	FSCM NO. 80230
APPLICATION		CAD FILE		DWG NO. 85-20100	REV B
			SCALE 1:1	SHEET 1 OF 1	