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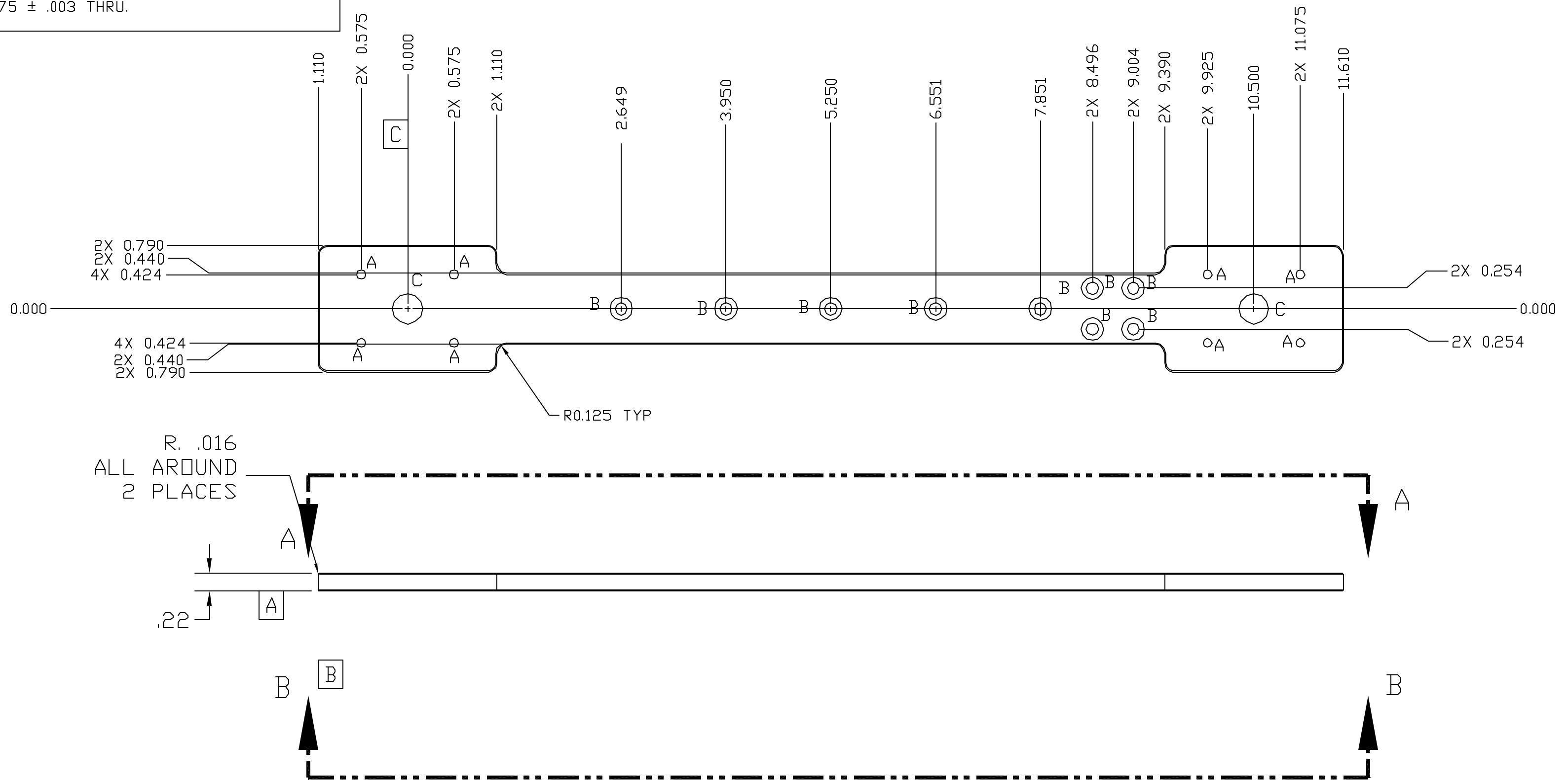
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HOLE CHART			
HOLE	QTY	TOLERANCE	DESCRIPTION
A	8	± 0.010 (M) (A) (B) (C)	$\phi .120^{+.003}_{-.002}$ THRU, $\angle \phi .155 \pm .010 \times 120^\circ \pm 5^\circ$, TAP THRU FOR .112-40 (.168L) UNC HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
B	9	± 0.010 (M) (A) (B) (C)	DRILL $\phi .154 \pm .003$ THRU. C'BORE $\phi .281$, .105 DP NEAR SIDE.
C	2	± 0.010 (M) (A) (B) (C)	DRILL $\phi .375 \pm .003$ THRU.

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-84	01	INITIAL RELEASE			
85-116	02	ADD 4 B HOLES. ADD C'BORES. CHG THICKNESS.			
85-163	A	CHG OUTLINE AND RELEASE	R. GOEKE	R. FOSTER	
85-182	B	CHG B HOLES.			



NOTES:

1. MASK FROM BLACK ANODIZE. CHEM FILM PER MIL-C-5541, CLASS 3.
2. CLEANLINESS REQUIREMENTS PER SN-C-0005 LEVEL VC-SENSITIVE.
3. BAG AND TAG WITH PART NUMBER AND REVISION.
4. ANODIZE PER NASA/JSC PRD-5006, CLASS 2, TYPE II, COLOR BLACK
5. DEBUR AND BREAK SHARP EDGES. CORNER RADIUS .01 MAX

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE: ANGLES +/- 1' 3 PLACE DECIMALS +/- .005 2 PLACE DECIMALS +/- .01	NAME	DATE	Massachusetts Institute of Technology Center for Space Research VOILA			
			DRAWN	M. SMITH		SUPPORT BRACE, CROSS TRACKER BAR		
		CHECKED	R. GOEKE		SIZE			
		MATERIAL	APPROVED	R. FOSTER	C	80230	85-20109	B
85-20100	VOILA	6061-T6	RELEASED	D. GAGE	SCALE	1:1	SHEET	1 OF 2
NEXT ASSEMBLY	USED ON	NOTE 4 FINISH	CAD FILE					
APPLICATION								

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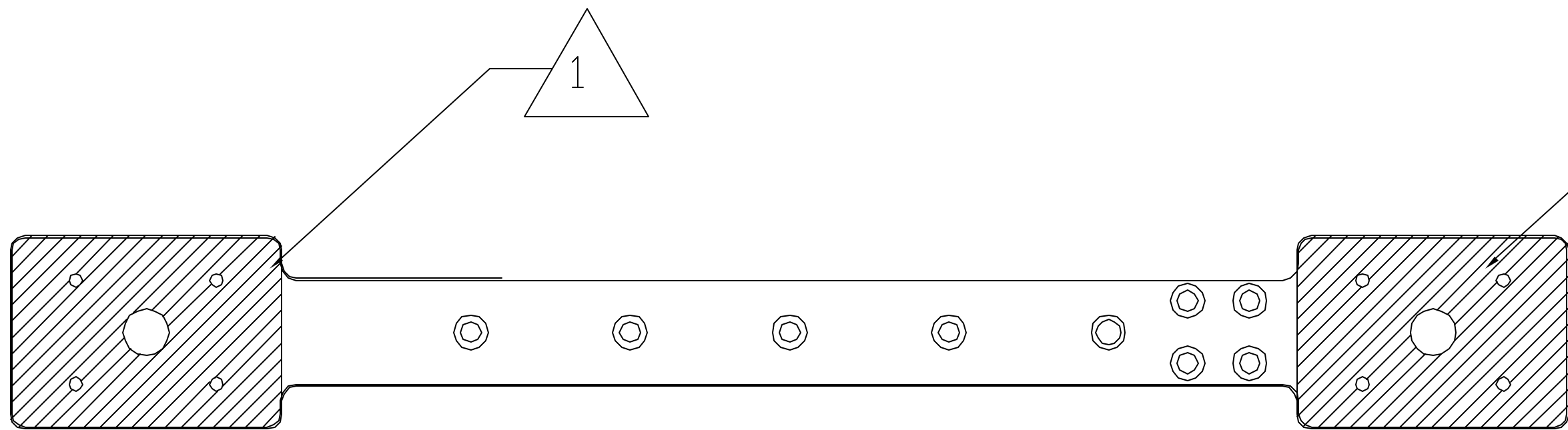
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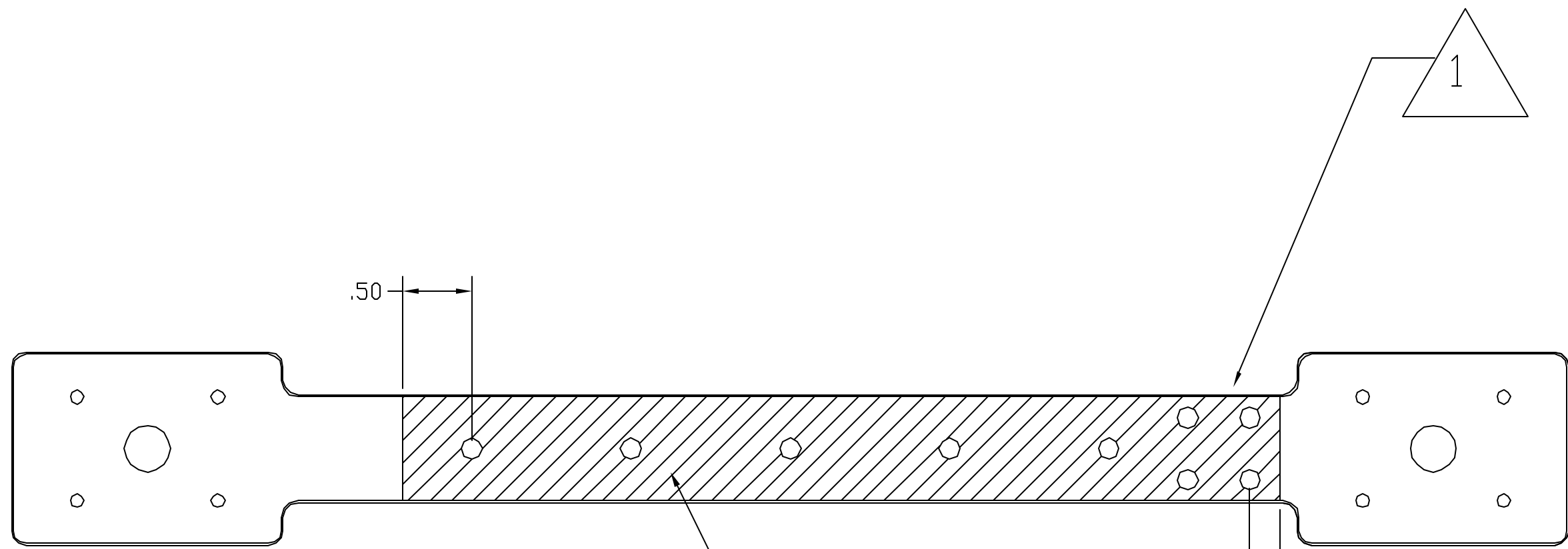
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REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-84	01	INITIAL RELEASE			
85-116	02	SEE SHEET 1			
85-163	A	SEE SHEET 1			
85-182	B	SEE SHEET 1			



VIEW A-A



VIEW B-B

NAME	DATE	Massachusetts Institute of Technology Center for Space Research VOILA			
DRAWN	M. SMITH	SUPPORT BRACE, CROSS			
CHECKED					
APPROVED					
RELEASED					
	SIZE C	FSCM NO. 80230	DWG NO. 85-20109	REV B	
CAD FILE	SCALE 1:1		SHEET 2 OF 2		

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