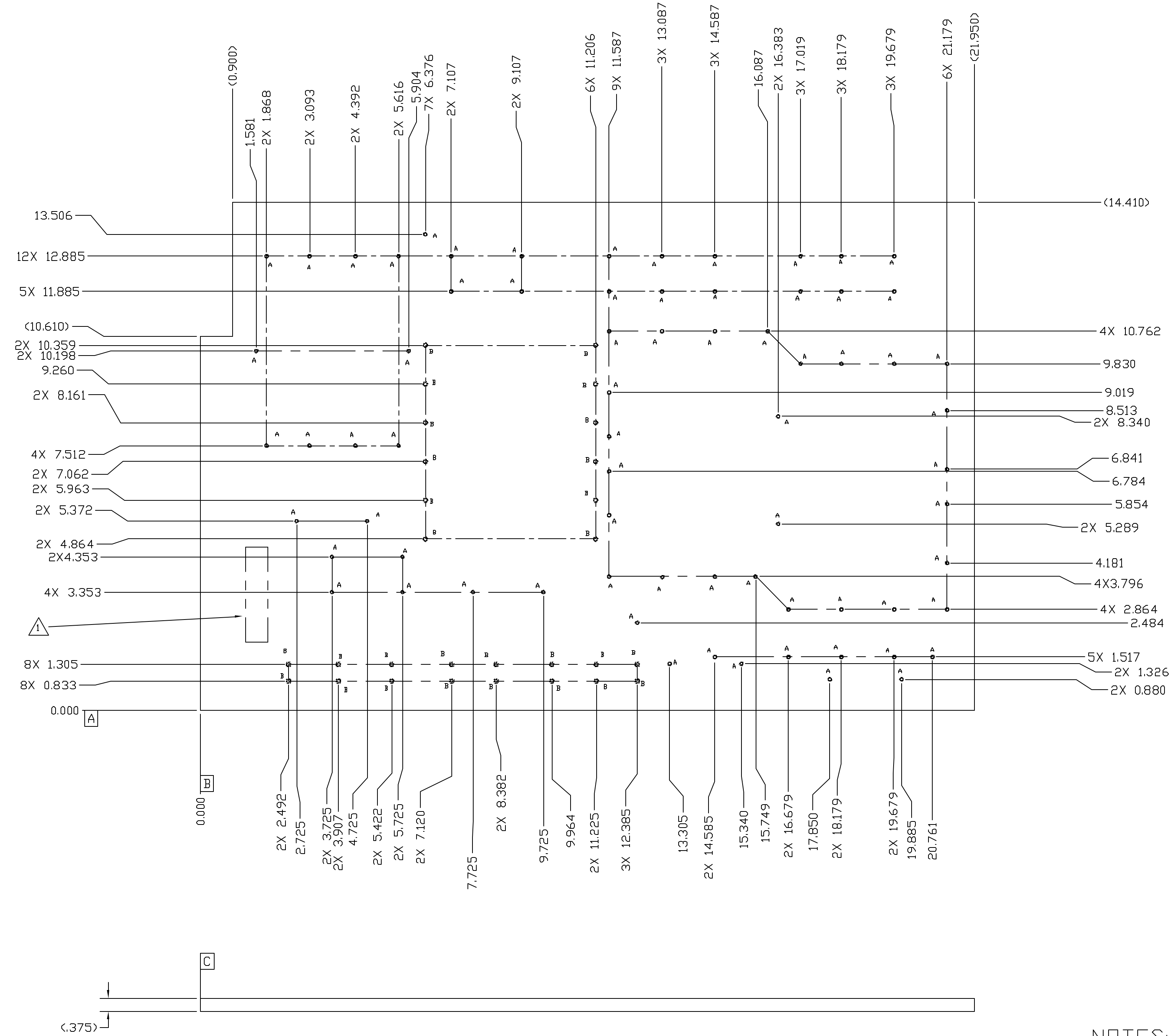


REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-72	01	INITIAL RELEASE		M. SMITH	
85-167	A	RELEASE			



NOTES:

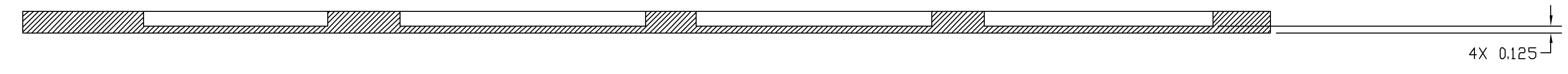
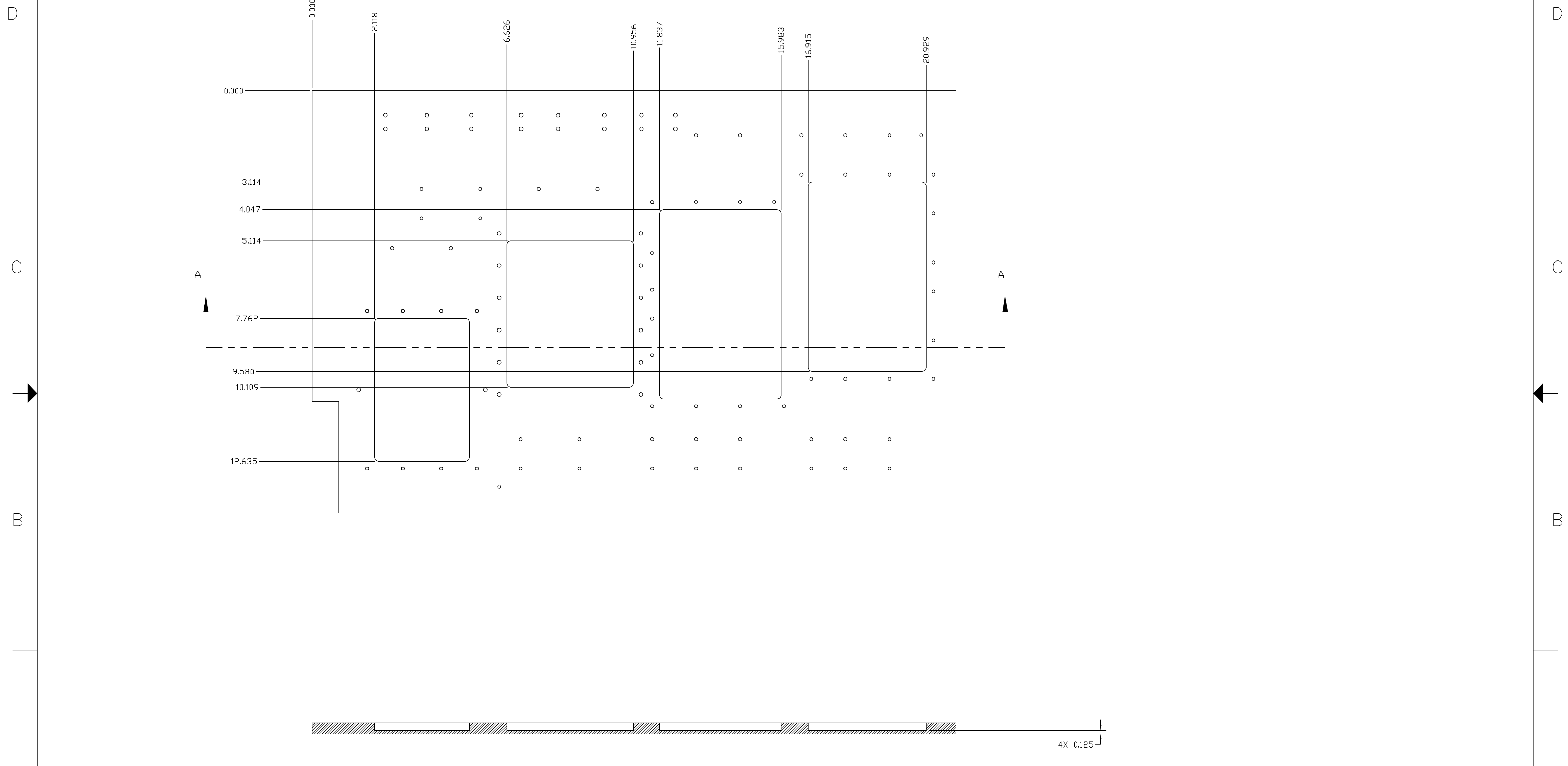
1. ENGRAVE P/N AND REV IN .12 HIGH CHARACTERS APPROX. WHERE SHOWN. SERIALIZE TRAINING UNIT STARTING WITH 30X AND FLIGHT WITH 10X
2. CHEMFILM PER MIL-C5541, CLASS 3
3. INSTALL INSERTS, AFTER FINISH, PER MS33537, REMOVE TANG.

HOLE CHART			
HOLE	QTY	TOLERANCE	DESCRIPTION
A	67	$\pm 0.010$ (M) (C) (A) (B)	$\phi .120$ $^{+0.003}_{-0.002}$ THRU, $\angle \phi .155 \pm 0.015 \times 120^\circ \pm 5^\circ$ , TAP THRU FOR #12-40 UNC HELICAL STI. INSTALL INSERT (FN 3) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
B	28	$\pm 0.010$ (M) (C) (A) (B)	DRILL THRU WITH #26 DRILL, $\angle \phi .195 \pm 0.015 \times 120^\circ \pm 5^\circ$ , TAP THRU FOR #6-32 UNC HELICAL STI. INSTALL INSERT (FN 2) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.

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
85-30300	VOILA	M. SMITH	10/19/04	
MATERIAL N/A		CHECKED		ICD, INTERFACE PLATE VOILA EE, SUB-ASSEMBLY
FINISH N/A		APPROVED		
NEXT ASSEMBLY	USED ON	RELEASED		SIZE D
APPLICATION		CAD FILE		FSQM NO. 80230
				DWG NO. 85-30301
				SCALE 1:1
				SHEET 1 OF 2

8 7 6 5 4 3 2 1

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-167	A	SEE SHEET 1			



SECTION A-A

8 7 6 5 4 3 2 1

NAME		DATE		Massachusetts Institute of Technology Center for Space Research VOILA			
DRAWN		M. SMITH		10/19/04			
CHECKED							
APPROVED							
RELEASED							
		SIZE	FSDM NO.	DWG NO.	85-30301	REV	A
CAD FILE		SCALE	1:1	SHEET		2 OF 2	

A

A