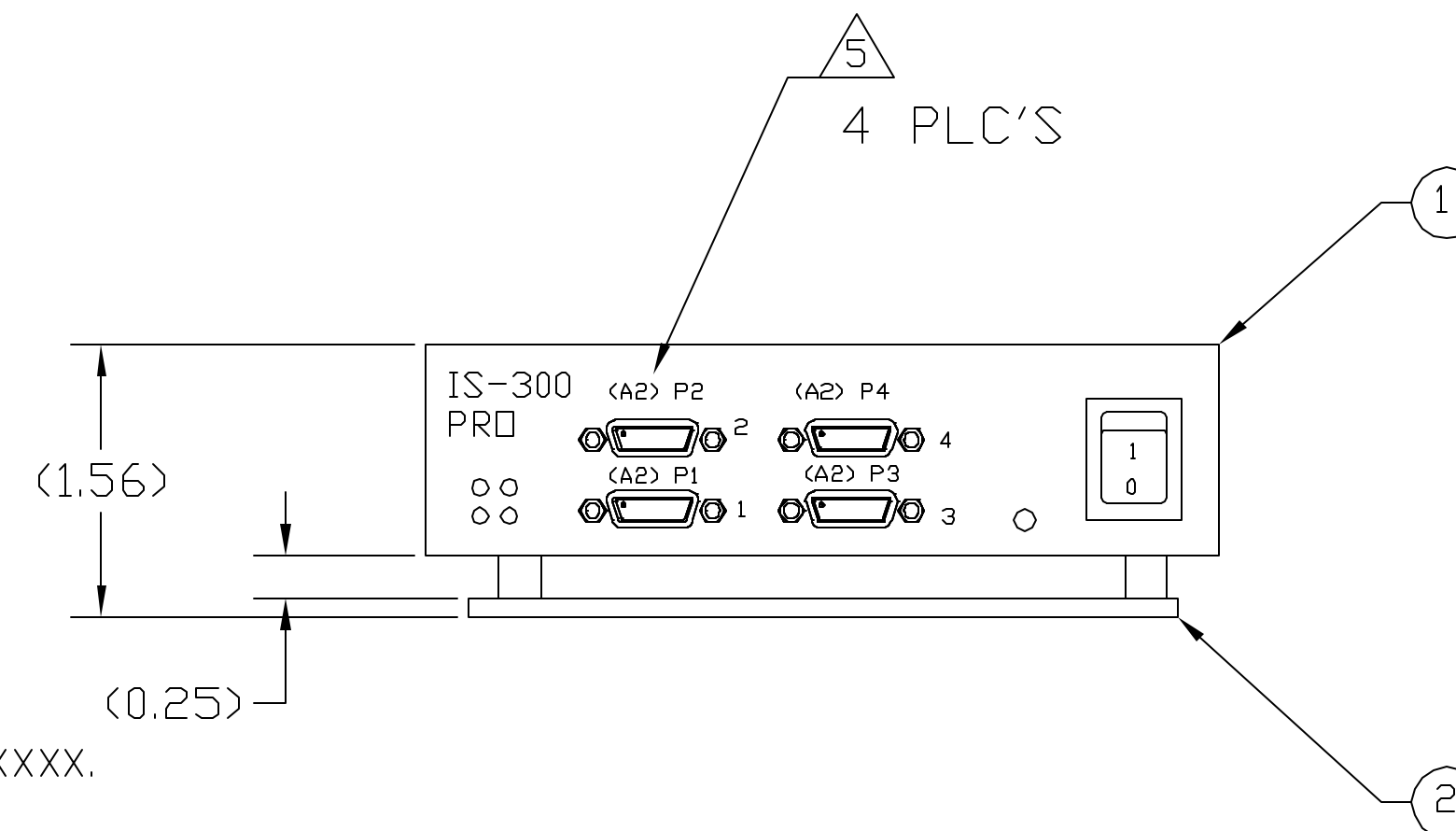
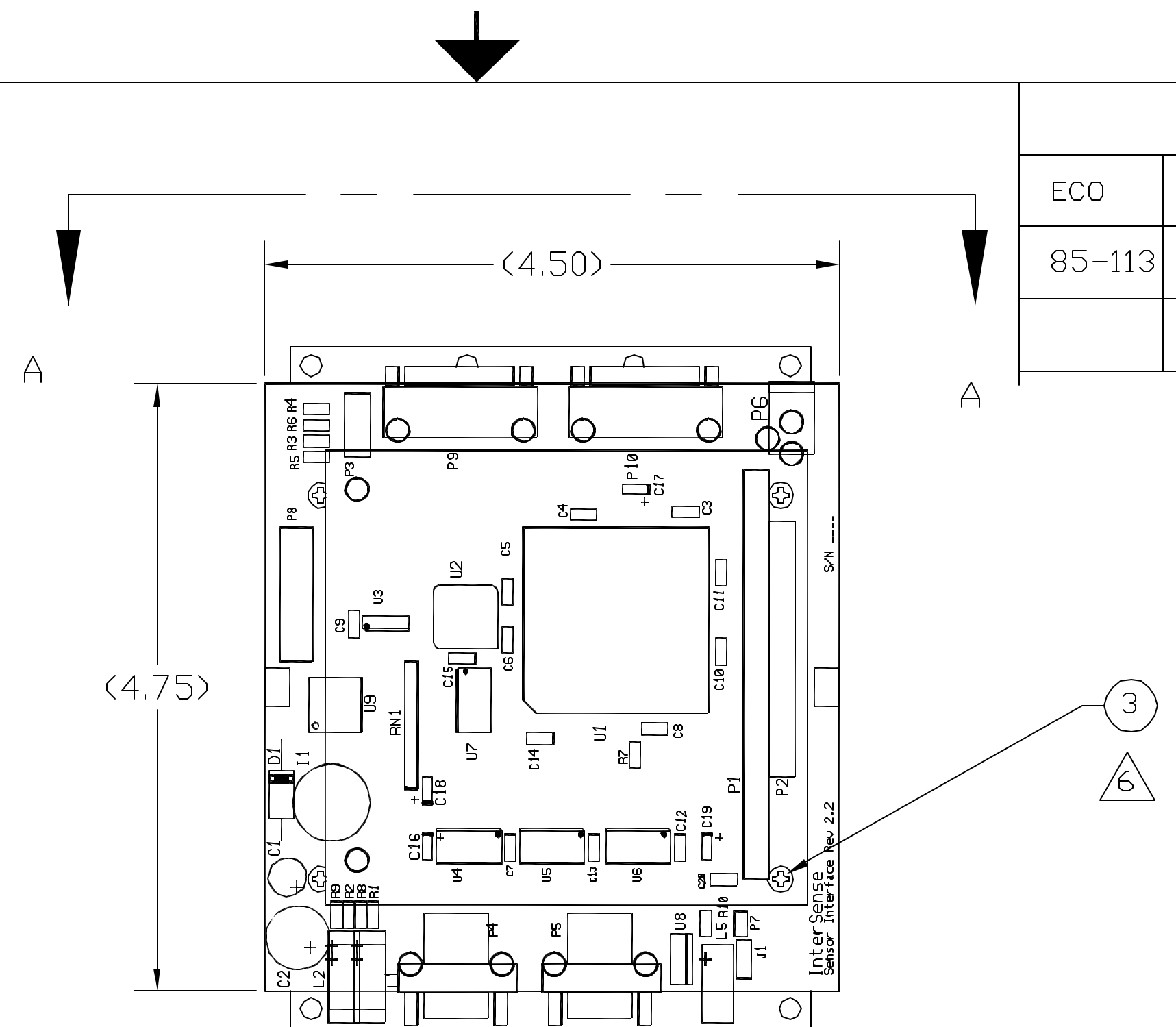
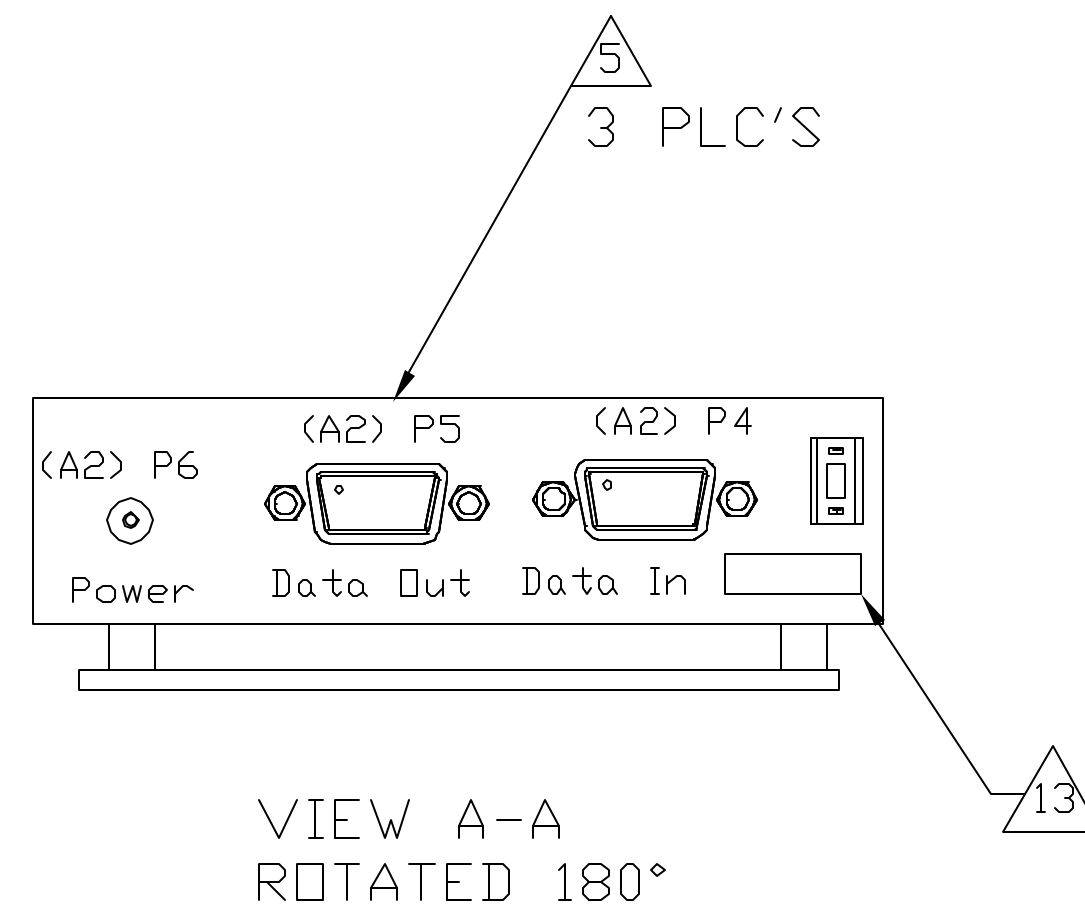


REVISIONS

ECO	REV	DESCRIPTION	DATE	APPROVED
85-113	01	INITIAL RELEASE		



NOTES:

1. REMOVE OUTER CASE FROM F/N1. LEAVE ENDPLATES IN TACT.
2. REMOVE F/N XXXX AND REPLACE WITH YYYY.
3. SOLDER IAW NASA SPECIFICATION NAS-STD-8739.2 AND NAS-STD-8739.3.
4. CUT POWER CONNECTOR AND DISCARD. REWIRE POWER SUPPLY WIRE PER SCHEMATIC 85-XXXXXX.
5. MARK CONNECTOR REFERNECE DESIGNATORS AS SHOWN USING F/N 5.
6. TORQUE HARDWARE TO 5 IN LBS.. SPOTBOND WITH F/N 4.
7. ITEM IS STATIC SENSITIVE. HANDLE IAW MIT PROCEDURE 99-01003.
8. MASK FOR CONFORMAL COAT AS INDICATED. MASK ALL WIRES FROM CONNECTORS.
9. VACUUM BAKE ALL CONNECTORS AT 80C FOR 72 HOURS PRIOR TO KITTING AND INSTALLATION.
10. CONFORMAL COAT USING F/N 16.
 - CURE AT 25C, AMBIENT PRESSURE FOR 8 HOURS.
 - REMOVE MASKING AND MASKING RESIDUE PRIOR TO BAKE.
 - VACCUM BAKE AT 65C, 10⁻⁴ TORR FOR 24 HOURS.
11. WEIGH FINAL ASSEMBLY
12. BAG AND TAG WITH PART NUMBER REVISION AND SERIAL NUMBER.
13. SERIALIZE TRAINING UNITS STARTING WITH 100 AND FLIGHT UNITS WITH 300.

		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	INTERSENSE CONTROLLER ASSEMBLY				
		MATERIAL	CHECKED	APPROVED					SIZE
		voila	RELEASED		B	80230	85-30314	01	
NEXT ASSEMBLY	USED ON	FINISH	CAD FILE		xxxx_rA	SCALE	1:1	SHEET	1 OF 1
APPLICATION									