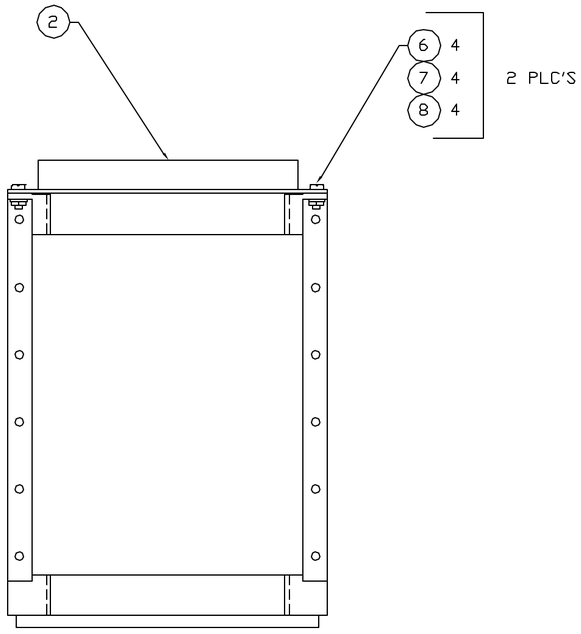
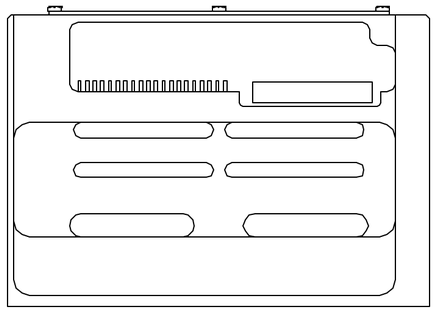
NOTES:

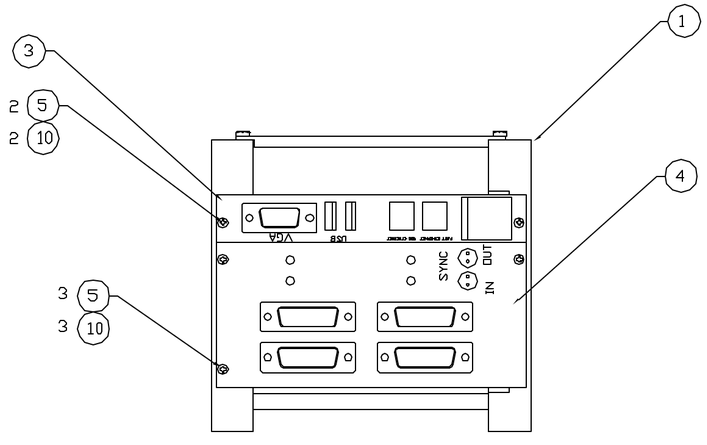
1. TORQUE 2-56 HARDWARE TO 54 IN-OZ.
   TORQUE 4-40 HARDWARE TO 5 IN-LBS.

2. INSTALL F/N 2 ONTO F/N 1. SNUG HARDWARE-DO NOT TIGHTEN UNTIL ALIGNEMENT IS COMPLETE.
   SLIDE F/N 3 INTO TOP SLOT AND F/N 4 INTO BOTTOM SLOT OF F/N 1 AND SEAT INTO CONNECTOR.
   ENSURE PROPER MATING AND THAT THE PWA IS WITHIN THE GROOVES OF F/N 1.
   SECURE BACKPLANE F/N 2 BY TORQUEING F/N 6 TO 5 IN-LBS,
   THEN INSTALL F/N'S 5 AND 10 INOT F/N'S 3 AND 4. TORQUE TO 54 IN-OZS.

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-137	01	INITIAL RELEASE			
85-154	A	REDESIGNED FOR TRAINING UNIT			







		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE: ANGLES +/- 1° 3 PLACE DECIMALS +/- .005 2 PLACE DECIMALS +/- .01	NAME	DATE	Massachusetts Institute ofTechnology Center for Space Research VOILA	
			DRAWN M. SMITH	5/19/04		
			CHECKED			
		MATERIAL	APPROVED		CODA HUB ASSY.	
85-30316	VOILA		RELEASED			
NEXT ASSEMBLY	USED ON	FINISH			SIZE D FSCM NO. 80230 DWG NO. 85-30316 REV A	
APPLICATION			CAD FILE		SCALE 1:1 SHEET 1 OF 1	