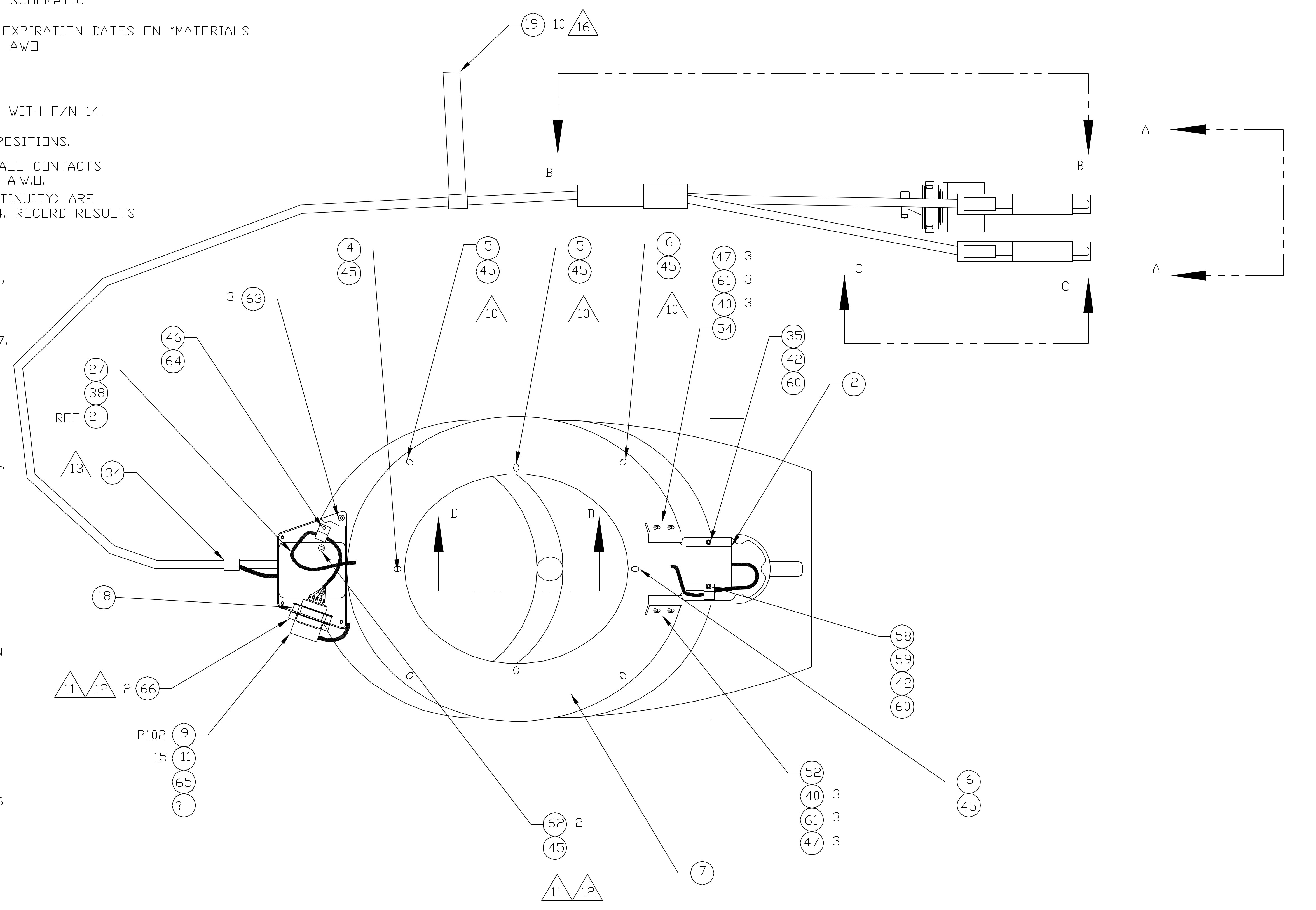


NOTES:

1. REFER TO MIT DRAWING 85-03020.07 FOR SCHEMATIC CONNECTION AND WIRE ASSIGNMENTS.
2. RECORD EPOXIES USED, MIX RATIOS AND EXPIRATION DATES ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF A.W.D.
3. CLEAN ITEM IAW MIT SPECIFICATION .
4. FABRICATE IAW NASA STD-8739.4.
5. SECURELY HAND TIGHTEN AND SPOTBOND WITH F/N 14.
6. DO NOT INSTALL CONTACTS IN UNUSED POSITIONS.
7. PERFORM CONTACT RETENTION TEST ON ALL CONTACTS PER MSFC-STD-781. RECORD RESULTS IN A.W.D.
8. ELECTRICAL TESTS (CONTINUITY, DISCONTINUITY) ARE TO BE PERFORMED IAW NASA-STD-8739.4. RECORD RESULTS IN A.W.D.
9. LABEL AS SHOWN USING F/N 15.
10. BOND F/N'S 4,5 AND 6 TO F/N 7 USING F/N 45, BY APPLYING A THIN LAYER TO THE MATING SURFACES OF 4,5,6 AND 7. AFTER CURE, APPLY A FILLET AROUND THE PERIMETER OF THE LED CASE TO F/N 7. ORIENT ATE LED'S SO THAT THE LED WIRES RUN PERPENDICULAR TO THE EDGES OF F/N 7. FROM THE TOP AND BOTTOM. ENSURE EPOXY DOES NOT TOUCH LENSES.
11. SPOTBOND USING F/N 45 AFTER TORQUING.
12. TORQUE TO 48 IN OZ.. SPOTBOND USING F/N 24.
13. TORQUE TO 5 IN LBS. SPOTBOND USING F/N 24.
14. TORQUE TO 8 IN LBS. SPOTBOND USING F/N 24.
15. FEED WIRES FROM P102 THRU THE SLEEVING ON VENDOR SUPPLIED CABLE. BREAK OUT WIRE AT THE CONNECTOR END (REMOVE VENDOR APPLIED BLACK ELECTRICAL TAPE AT CONNECTOR/SLEEVING END). RESECURE VENDOR CABLE WITH P102 WIRES USING F/N 36, AT LOCATION SHOWN.
16. APPLY F/N 19 EVERY 19 INCHES STARTING FROM CONNECTOR END.
17. (MARKER NOTE HERE)
18. MAKE LENGTH OF MIT CABLE 2"±.5 FROM THE VENDOR CONNECTORS TO ALLOW FOR PROPER STRAIN RELIEF AT NHA.
19. REMOVE AND DISCARD HARDWARE HOLDING HEAD STRAP TO HMD SHELL. ENLARGE THRU MOUNTING HOLE TO Ø.25 AND INSTALL F/N'S 12 AND 13 AS SHOWN AND RESECURE HEAD STRAP WITH BRACKETS(F/N'S 12 AND 13) WITH NEW SCREW, F/N XX.
20. CUT F/N 68 IN SMALL SECTIONS TO FIT ALONG INSIDE OF HMD CROWN F/N 7. CUT OPENINGS IN F/N 68 TO FEED WIRES FROM LEDS F/N 4, 5 AND 6 INTO NEAREST PIECE. (CUT DOWN THE MIDDLE OF THE ADHESIVE SIDE AND LEAVE ONE STRIP ON WHILE REMOVING THE OTHER STRIP. PRESS ADHESIVE SIDE DOWN ONTO F/N 7. ONCE THE WIRES ARE LAID INTO THE GASKET PEEL OFF REMAINING STRIP AND PRESS TO SECURE.

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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	
MATERIAL N/A		DRAWN M. SMITH	DATE	HEAD DISPLAY ASSEMBLY	
ASTRO-E2		CHECKED		SIZE D	FSCM NO. 80230
NEXT ASSEMBLY		APPROVED		DWG NO. 85-40100	REV A
USED ON		RELEASED		SCALE 1:1	SHEET 1 OF 4
APPLICATION		CAD FILE			

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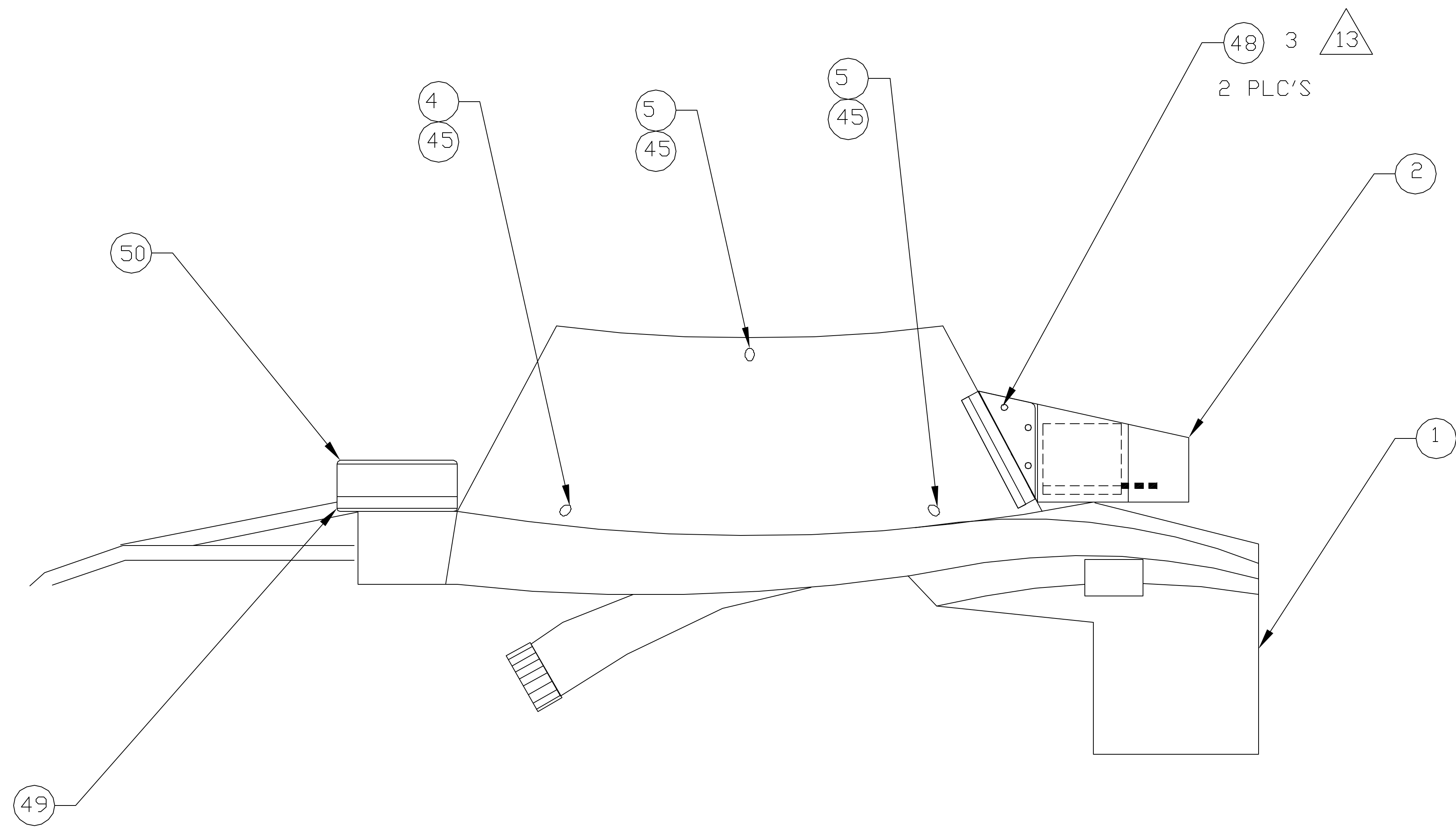
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3

2

1

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-164	A	INITIAL RELEASE			



NAME		DATE		Massachusetts Institute of Technology Center for Space Research VOILA			
DRAWN M. SMITH		DATE		HEAD DISPLAY ASSEMBLY			
CHECKED							
APPROVED							
RELEASED							
		SIZE D	FSCM NO. 80230	DWG NO. 85-40100	REV A		
CAD FILE		SCALE 1:1	SHEET 2 OF 4				

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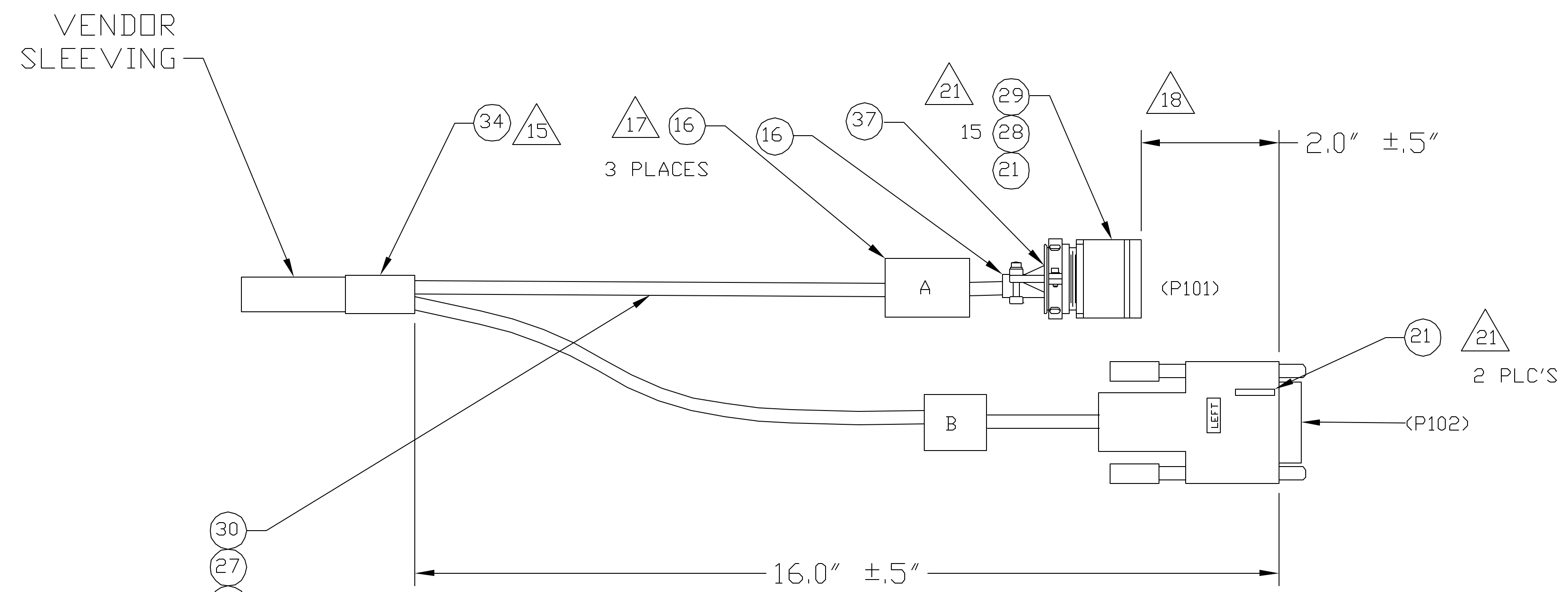
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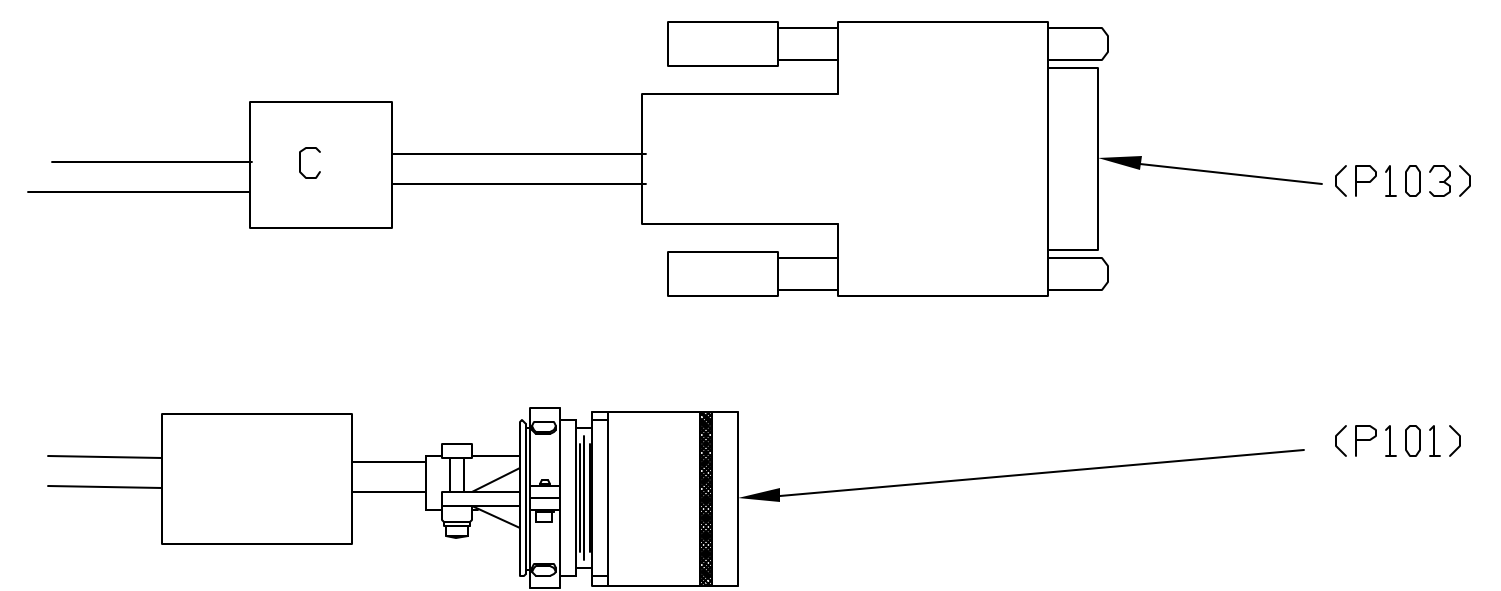
TABLE A

REF	TEXT	QTY
A	P101 To VOILA EE HEAD DISPLAY SENSORS J101	1
B	P102 To VOILA EE HEAD DISPLAY LEFT J102	1
C	P103 To VOILA EE HEAD DISPLAY RIGHT J103	1

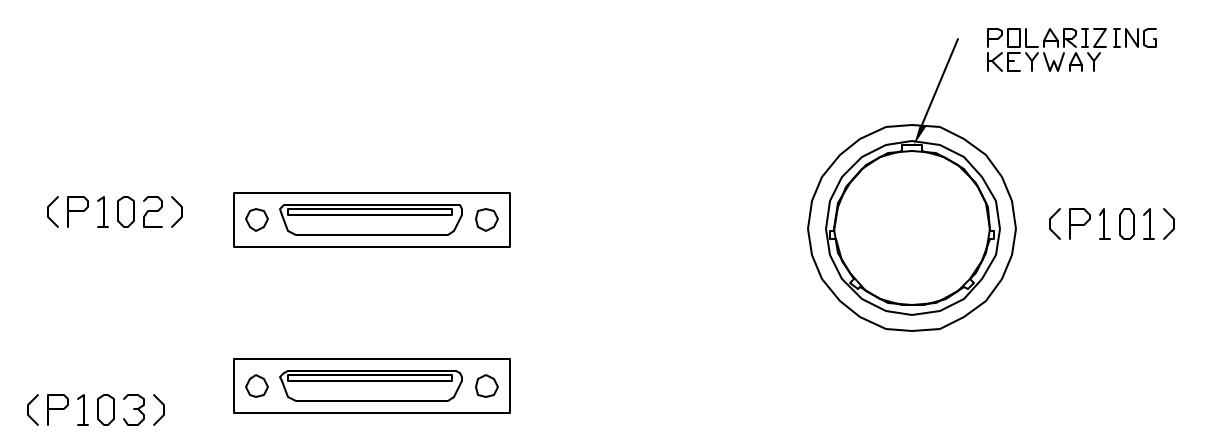


- 30
 - 27
 - 38
 - 55
 - 15
- 9

VIEW B-B



VIEW C-C

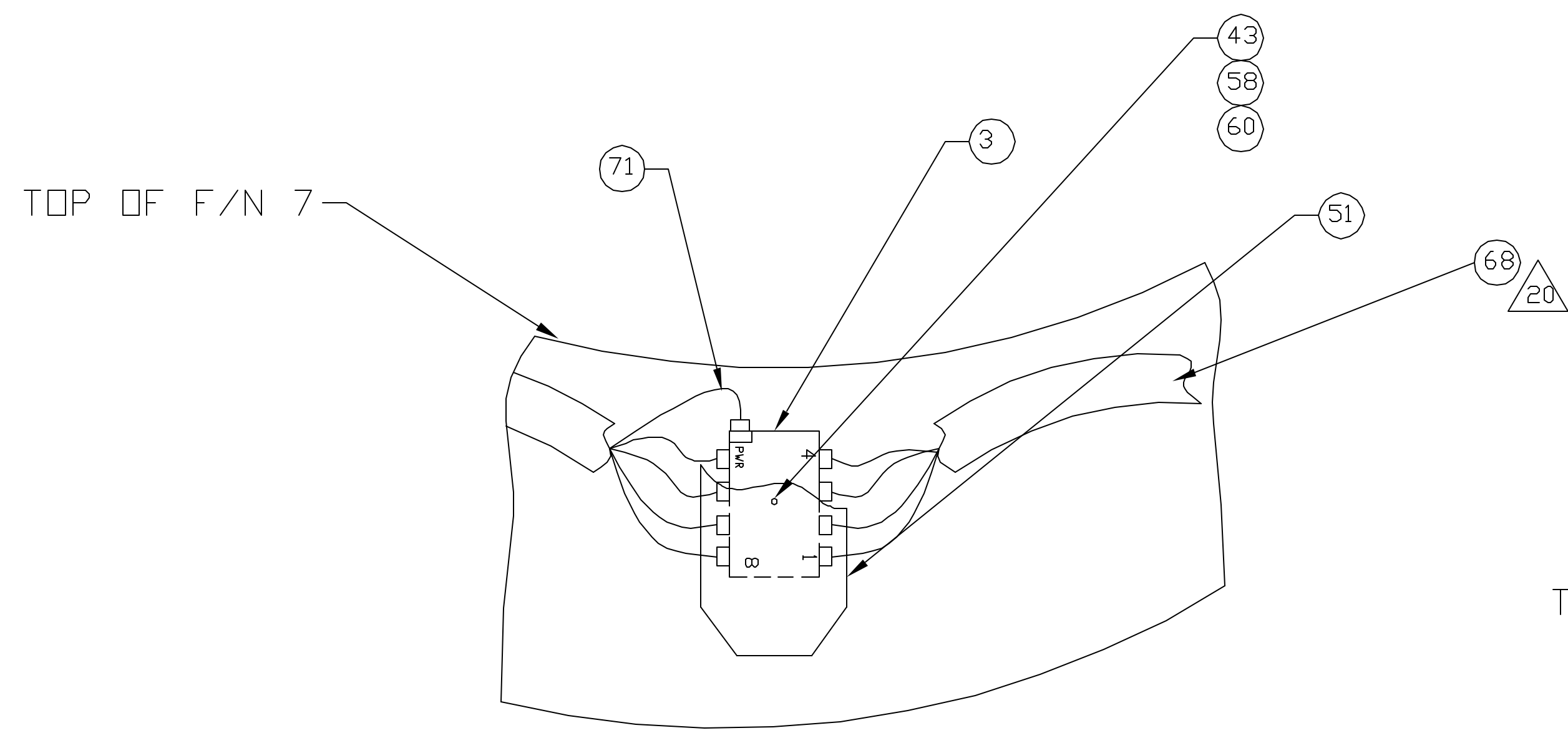


VIEW A-A

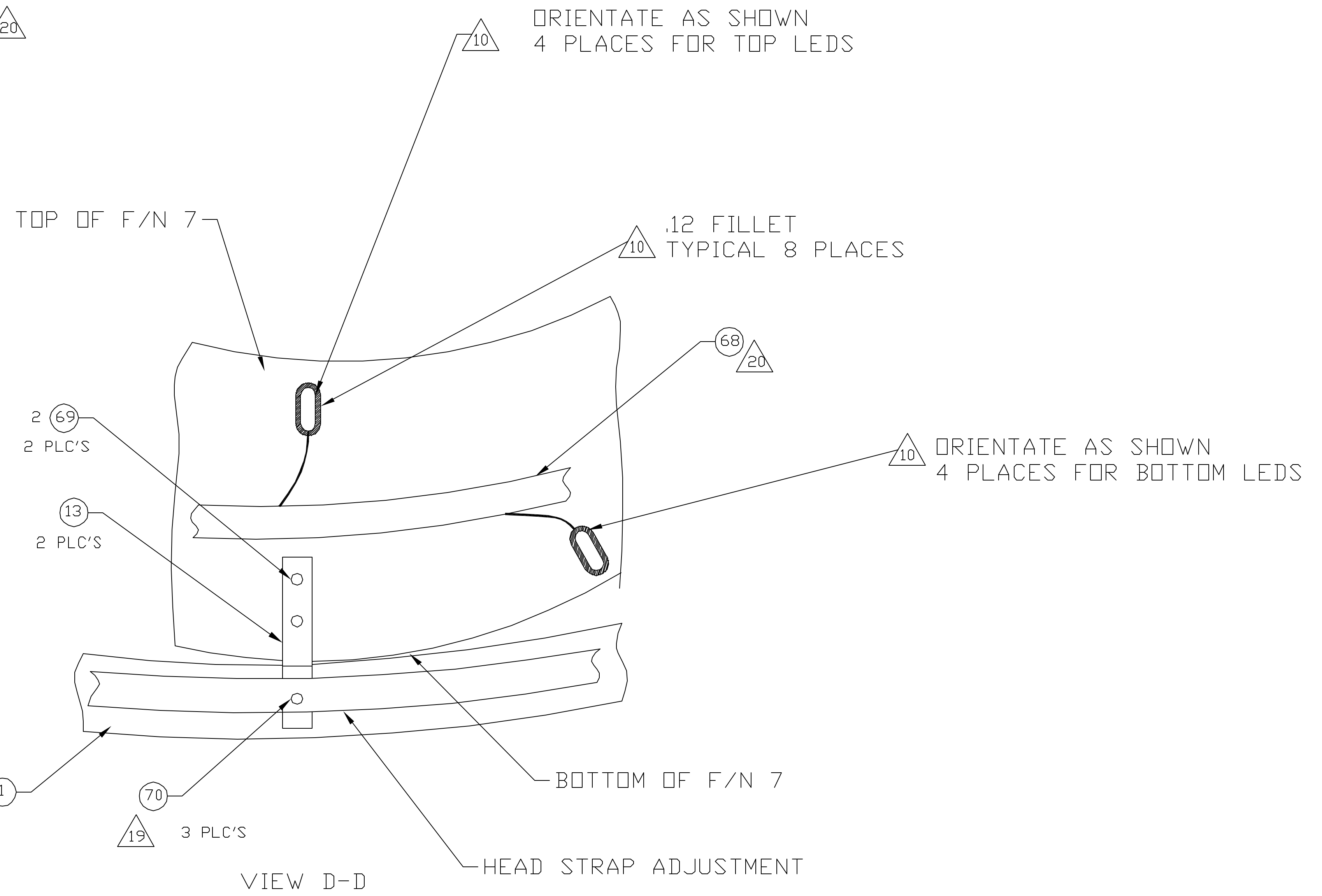
NAME	DATE	Massachusetts Institute of Technology Center for Space Research VOILA		
DRAWN M. SMITH	DATE	HEAD DISPLAY ASSEMBLY		
CHECKED		SIZE D	FSCM NO. 80230	DWG NO. 85-40100
APPROVED		SCALE 1:1	SHEET 3 OF 4	REV A
RELEASED				
CAD FILE				

8 7 6 5 4 3 2 1

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-164	A	INITIAL RELEASE			



VIEW E-E



VIEW D-D

NAME	DATE	Massachusetts Institute of Technology Center for Space Research VOILA			
DRAWN M. SMITH	DATE	HEAD DISPLAY ASSEMBLY			
CHECKED					
APPROVED					
RELEASED					
	SIZE D	FSCM NO. 80230	DWG NO. 85-40100	REV A	
CAD FILE	SCALE 1:1	SHEET 4 OF 4			