NOTES:
1. REFER TO MIT DRAWING 85-0302840 FOR SCHEMATIC.
2. CLEAN ITEM 14W MIT SPECIFICATION 85-xxxxx.
3. WEIGH ASSEMBLY AFTER FINAL FABRICATION.
4. FABRICATE 1AW NASA STD 87394.
5. TORQUE F/N 10 AND 16 TO 5 IN-LEBS. SPOTKOND NUT (CONNS) USING F/N 19.
6. BOND F/N 70, 23 AND 24 TO F/N 3 USING F/N 19.
7. ENSURE NO EPOXY GETS ON THE LED LENSES.
8. APPLY 1" X 1/2" STRIP OF DOUBLE SIDED TAPE, F/N 12 ONTO F/N 13 PRIOR TO INSTALLING INTO F/N 3.
9. CUT A HOLE FOR SCREW ACCESS. SOLDERING USING F/N 61 AROUND PERIMETER AFTER FUNCTIONAL TEST.
10. DO NOT INSTALL CONTACTS IN UNSOLDERED POSITIONS.
11. PERFORM CONTACT RETENTION TEST ON ALL CONTACTS AFTER INSTALLATION.
12. PERFORM CONTINUITY AND DISCONTINUITY TESTS AFTER COMPLETION.
14. MARK CONNECTOR INFORMATION IN 125 HIGH CHARACTERS AS SHOWN USING BRAICY MARKER XC PC PLUS PRINTER ROLL FILM (F/N 277) IN 125 HIGH CHARACTERS.
15. RECORD SPECIES USED, MIX RATIOS AND EXPIRATION DATES ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF A/V.
16. SERIALIZE TRAINING UNIT STARTING WITH "004" AND FLIGHT UNIT STARTING WITH "304".
17. APPLY INS LABEL (ITEM 3B) APPROXIMATELY WHERE SHOWN.
18. MARK THE ORIENTATION OF THE CONNECTOR MAIN KEYWAY ON THE HOUSING F/N 1 USING MARKING INK (ITEM 21).
19. BOND F/N 28 TO F/N 49 USING F/N 19.
20. REMOVE SCREW HOLDING F/N 13 AND DRILL THRU MOUNTING HOLE # 114 PER DRAWING 85-02024.
21. REINSTALL F/N 3 USING HARDWARE SHOWN. SPOTKOND EDGES OF HOUSING ON F/N 13 USING F/N 19.
22. HAND TIGHTEN F/N 6, 30 AND 45 TO HOUSING, F/N 1 SPOTKOND USING F/N 19 ON THE INSIDE ONLY.

Massachusetts Institute of Technology
Center for Space Research
VOILA PROJECT

Chest Pack Assembly

Unless otherwise specified, dimensions are in inches.
Tolerance Angles +/- 1°
3 Place Decimals +/- .005
2 Place Decimals +/- .01