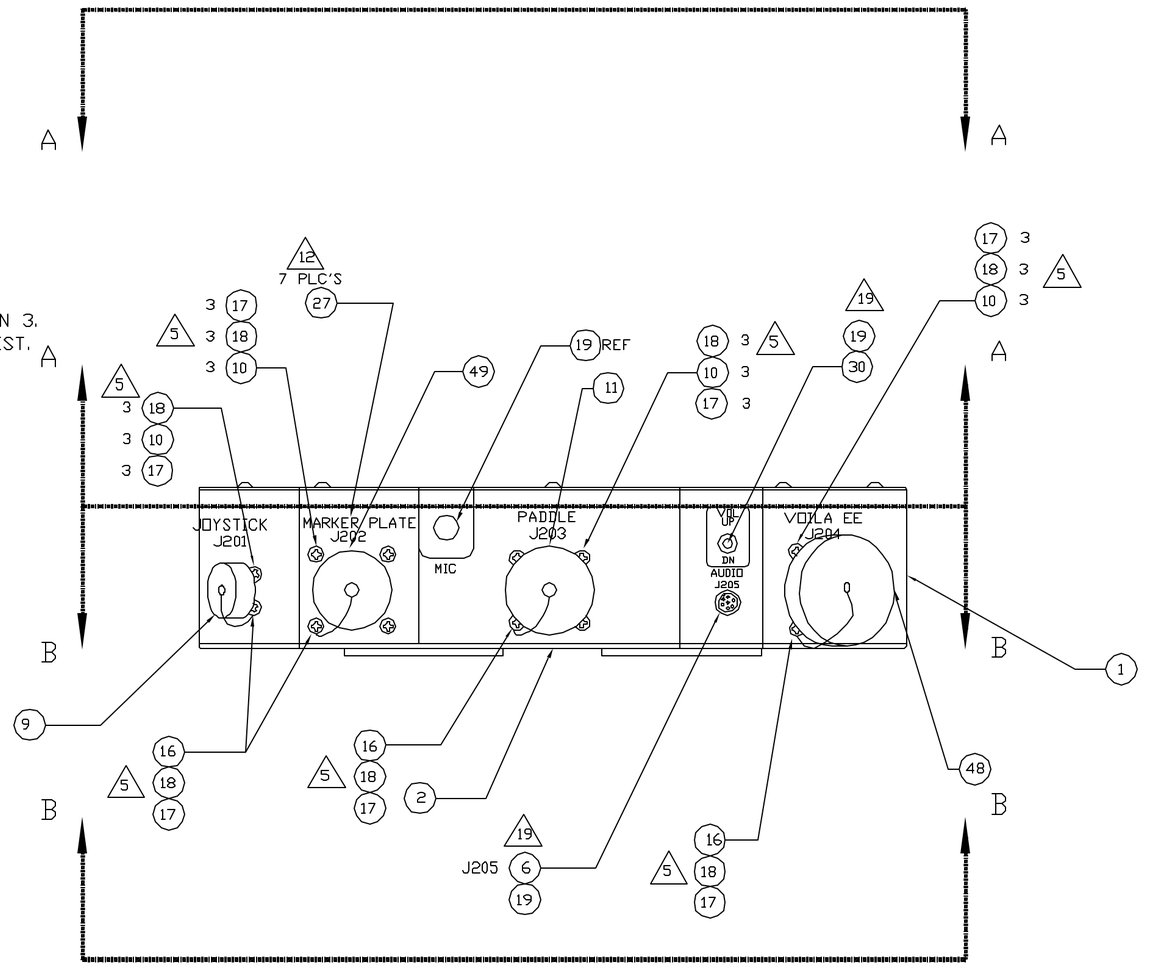
REVISIONS					
ZONE	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-75	01	INITIAL RELEASE			
85-139	02	REDESIGNED FOR TRAINING UNIT			
85-160	A	RELEASE FOR BUILD			

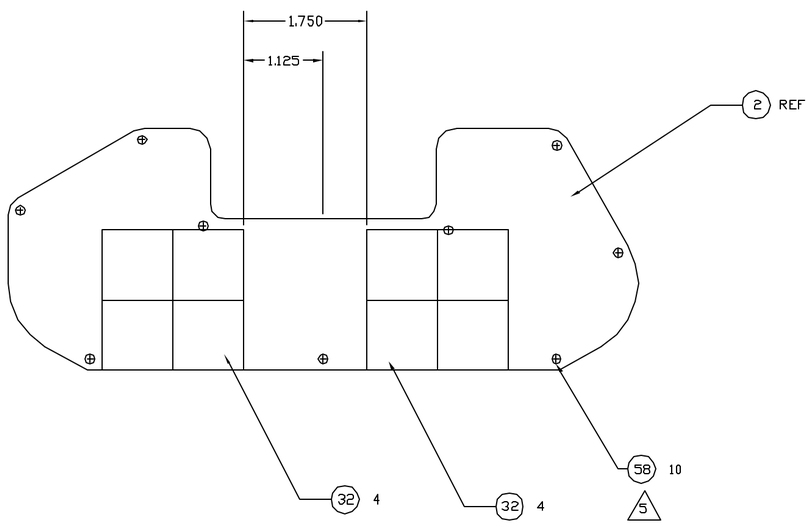
NOTES:

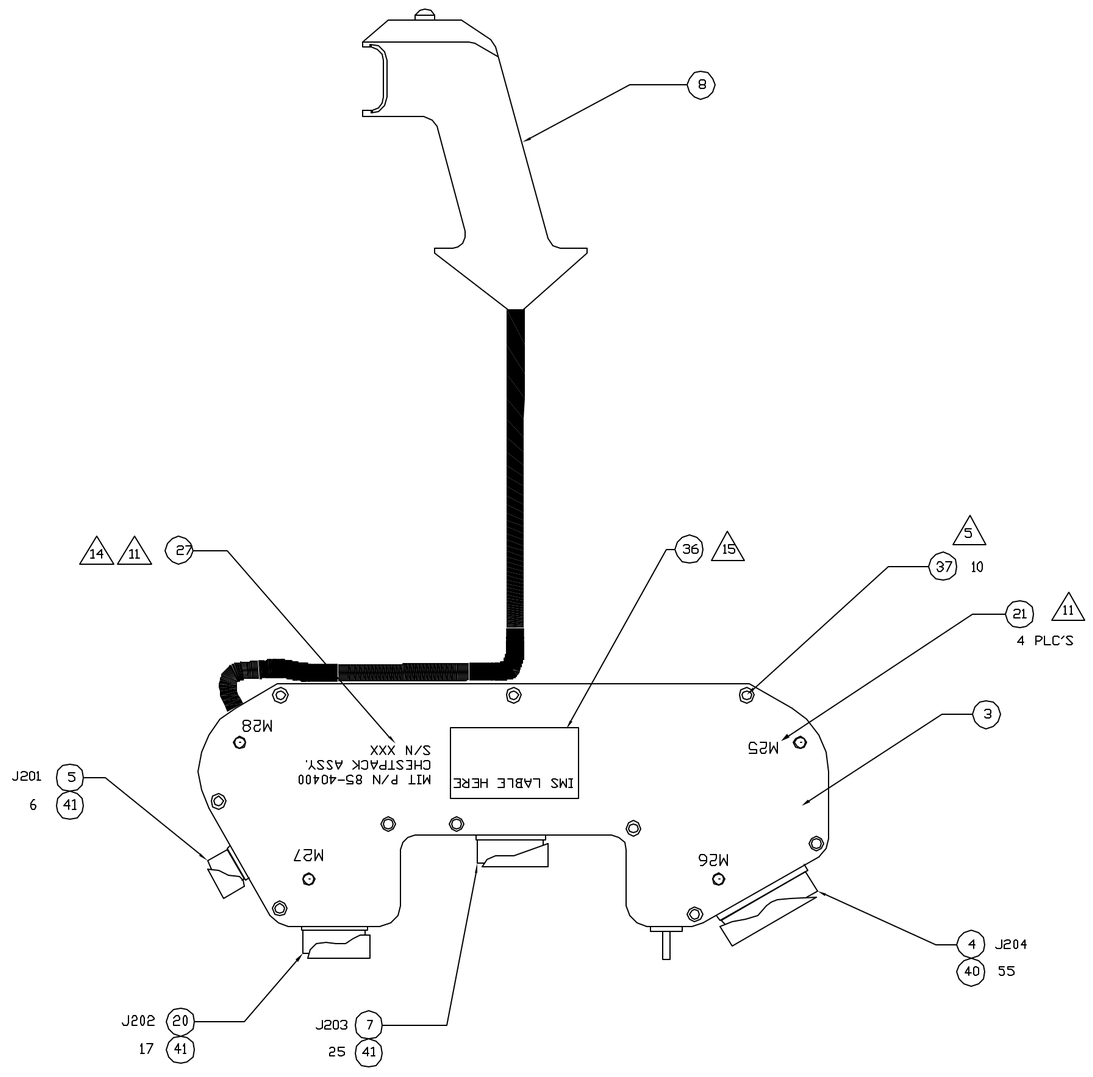
1. REFER TO MIT DRAWING 85-03020.40 FOR SCHEMATIC.
2. CLEAN ITEM IAW MIT SPECIFICATION 85-xxxxx.
3. WEIGH ASSEMBLY AFTER FINAL FABRICATION.
4. FABRICATE IAW NASA STD 8739.4
5. TORQUE F/N 10 AND 16 TO 5 IN-LBS. SPOTBOND NUT (CONN'S) USING F/N 19.
6. BOND F/N'S 22, 23 AND 24 TO F/N 3 USING F/N 19. ENSURE NO EPOXY GETS ON THE LED LENSES,
7. APPLY 1" X 1.5" STRIP OF DOUBLE SIDED TAPE, F/N 12 ONTO F/N 13 PRIOR TO INSTALLING ONTO F/N 3. CUT A HOLE FOR SCREW ACCESS. SOTBOND USING F/N 61 AROUND PERIMETER AFTER FUNCTIONAL TEST.
8. DO NOT INSTALL CONTACTS IN UNUSED POSITIONS.
9. PERFORM CONTACT RETENTION TEST ON ALL CONTACTS AFTER INSTALLATION.
10. PERFORM CONTINUITY AND DISCONTINUITY TESTS AFTER COMPLETION.
11. TYPE MIT IDENTIFICATION AS SHOWN IN .12 HIGH CHARACTERS USING BRADY MARKER XC PC PLUS PRINTER ROLL FILM (ITEM 27). MARK SERIAL NUMBER PER NOTE 14.
12. MARK CONNECTOR INFORMATION IN .125 HIGH CHARACTERS AS SHOWN USING BRADY MARKER XC PC PLUS PRINTER ROLL FILM (F/N 27) IN .125 HIGH CHARACTERS.
13. RECORD EPOXIES USED, MIX RATIOS AND EXPIRATION DATES ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF AWO.
14. SERIALIZE TRAINING UNIT STARTING WITH "10x" AND FLIGHT UNIT STARTING WITH "30x".
15. APPLY IMS LABEL (ITEM 36) APPROXIMATELY WHERE SHOWN
16. MARK THE ORIENTATION OF THE CONNECTOR MAIN KEYWAY ON THE HOUSING F/N 1 USING MARKING INK (ITEM 21).
17. BOND F/N 28 TO F/N 45 USING F/N 19.
18. REMOVE SCREW HOLDING F/N 13 AND DRILL THRU MOUNTING HOLE, ø .114 PER DRAWING 85-20254 REINSTALL ONTO F/N 3 USING HARDWARE SHOWN. SPOTBOND EDGES OF HOUSING ON F/N 13 USING F/N 19.
19. HAND TIGHTEN F/N 6, 30 AND 45 TO HOUSING , F/N 1. SPOTBOND USING F/N 19 ON THE INSIDE ONLY.



		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 PROJECT
			DRAWN M. SMITH 01/21/04	
			CHECKED	CHEST PACK ASSEMBLY
		MATERIAL / FINISH	APPROVED	
85-40000	VOILA		RELEASED	SIZE D · FSCM NO. 80230 · DWG NO. 85-40400 · REV A
NEXT ASSEMBLY	USED ON			SCALE 1:1 · SHEET 1 OF 3
APPLICATION			CAD FILE	

REVISIONS					
ZONE	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-75	01	SEE SH 1			
85-139	02	SEE SH 1			
85-160	A	SEE SH 1			



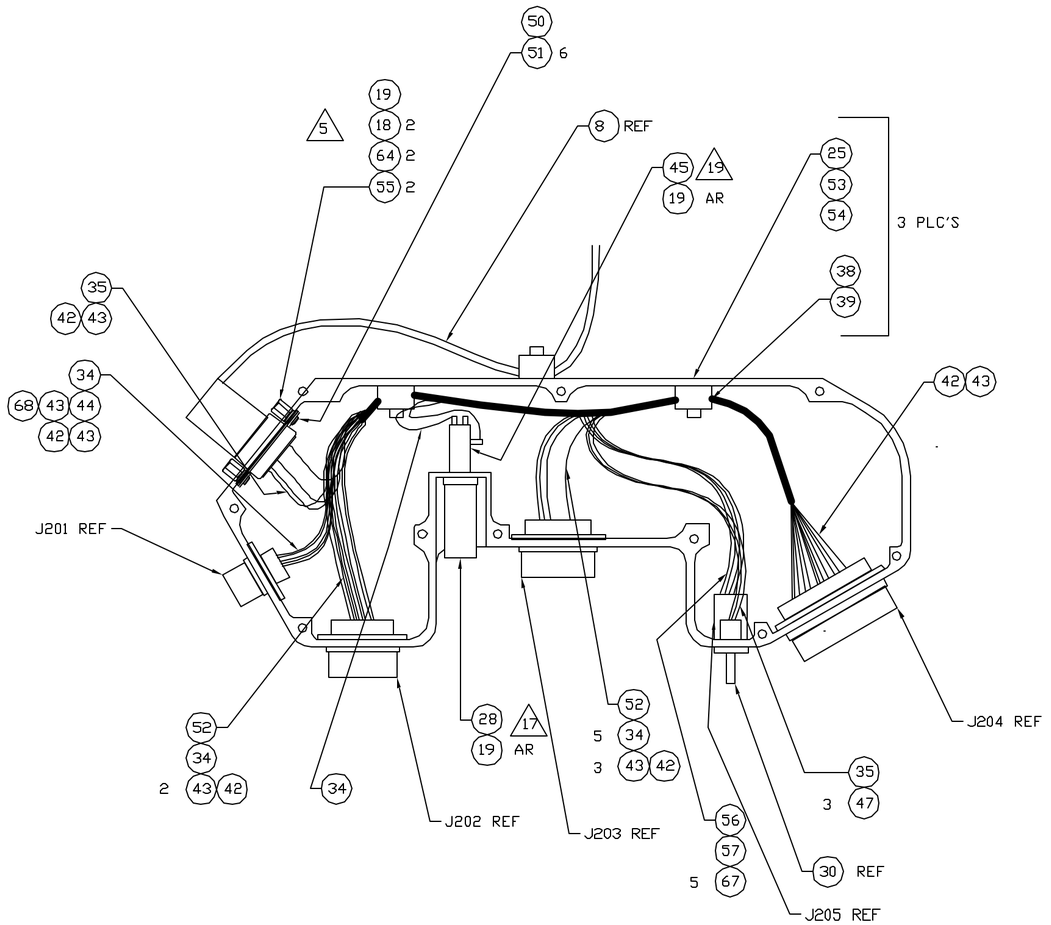


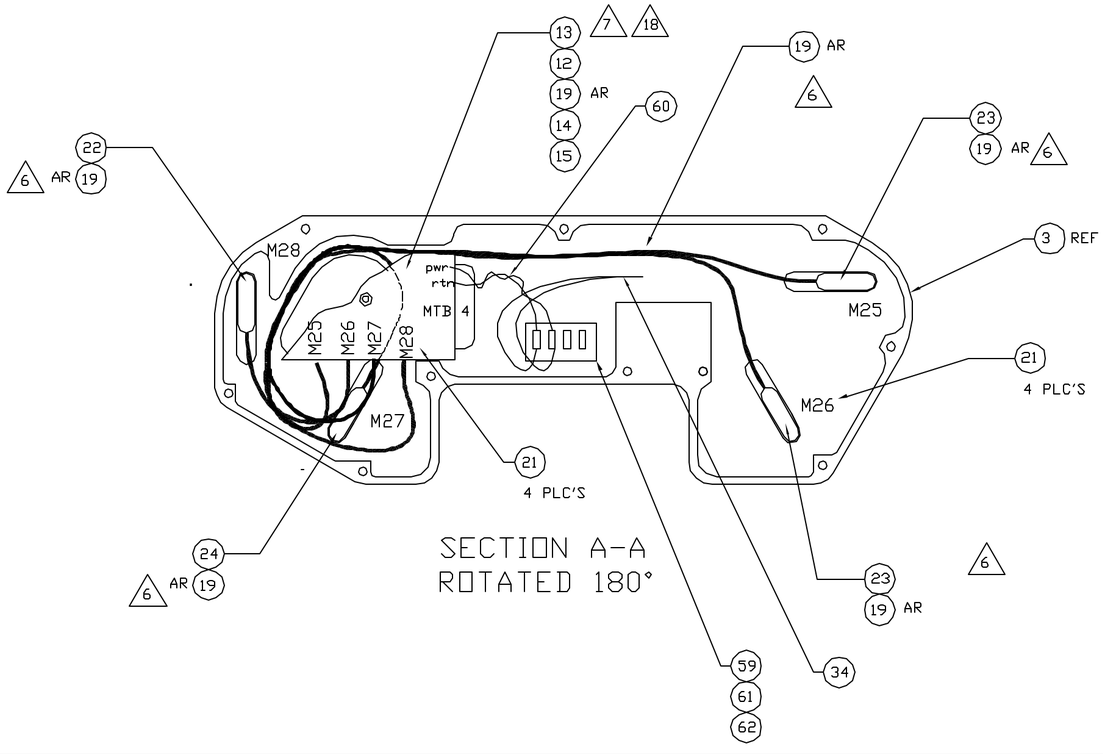
Massachusetts Institute of Technology
Center for Space Research
VOILA PROJECT

CHEST PACK
ASSEMBLY

SIZE	FSCM NO.	DWG NO.	REV
D	80230	85-40400	A
SCALE 1:1		SHEET 2 of 3	

REVISIONS					
ZONE	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-75	01	SEE SH 1			
85-139	02	SEE SH 1			
85-160	A	SEE SH 1			





Massachusetts Institute of Technology
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VOILA PROJECT

CHEST PACK
ASSEMBLY

SIZE	FSCM NO.	DWG NO.	REV
D	80230	85-40400	A
SCALE 1:1		SHEET 3 of 3	