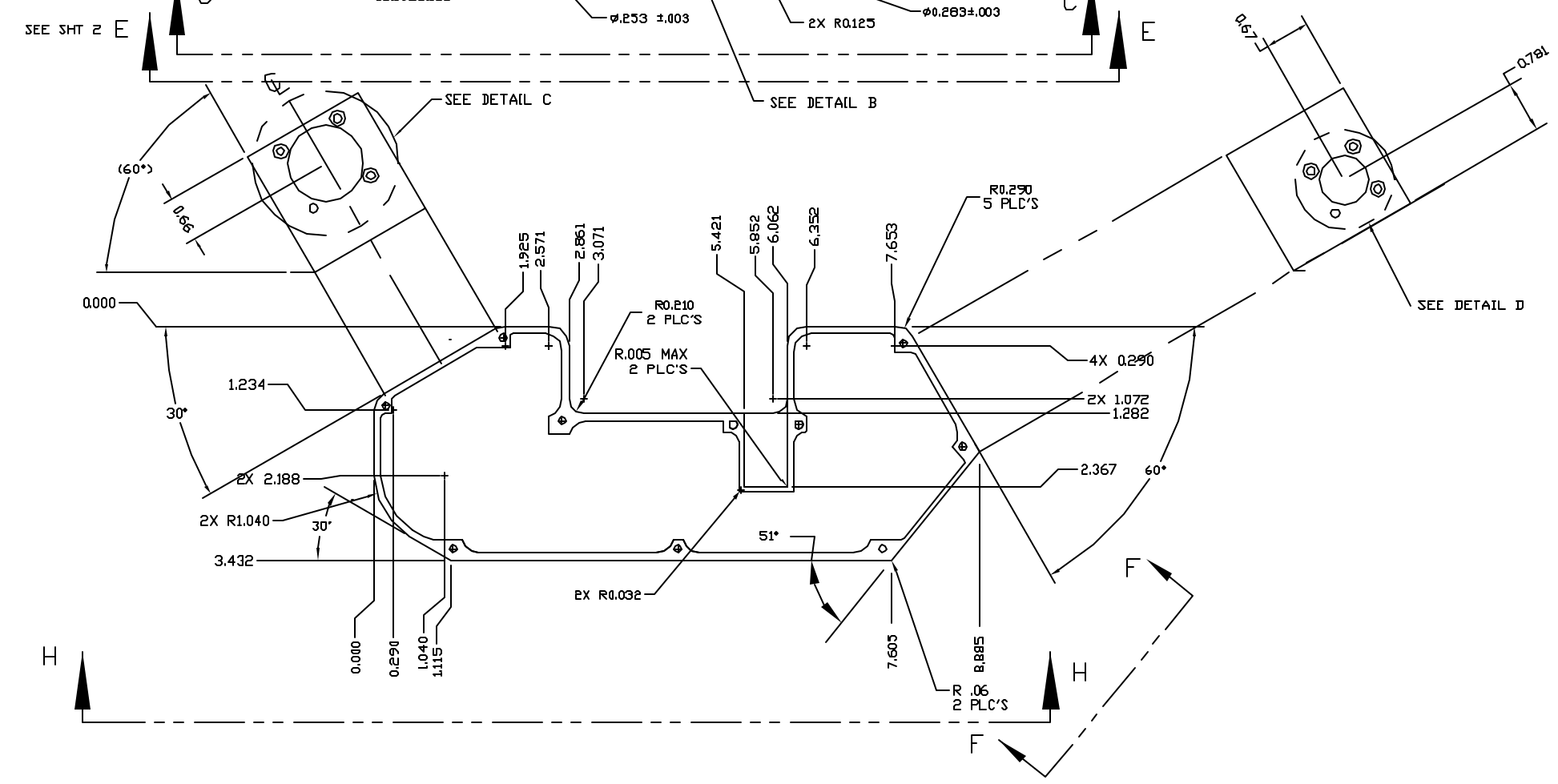
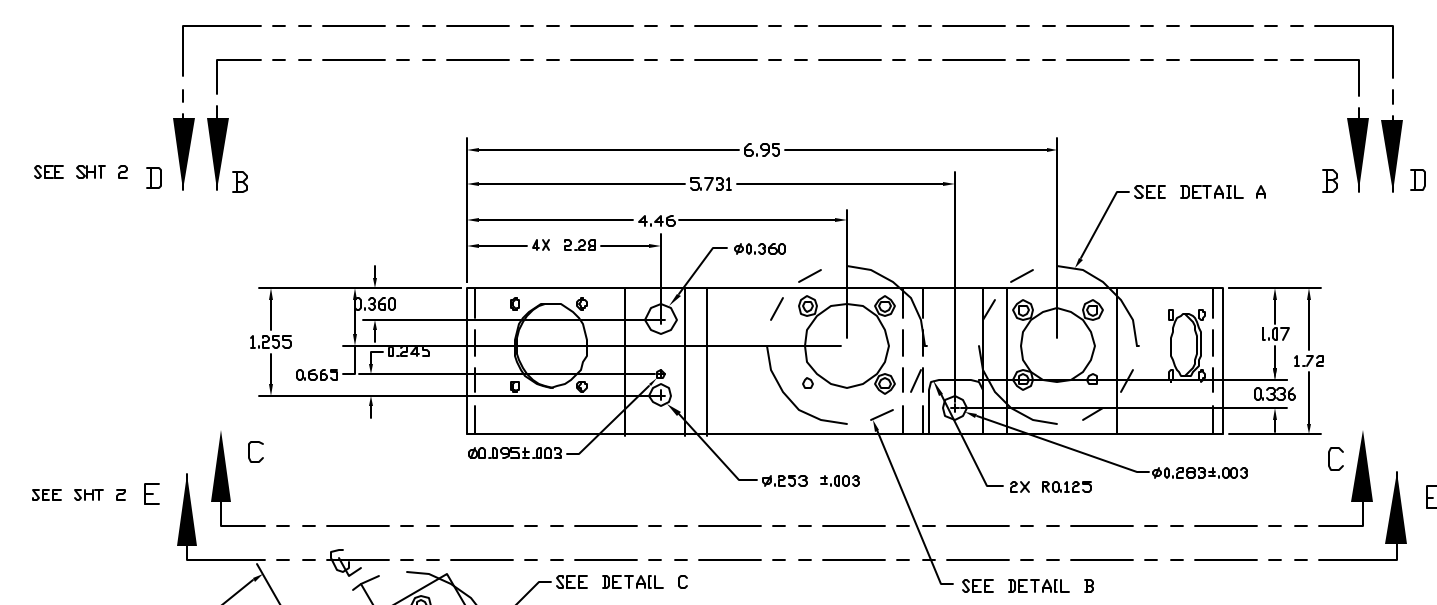
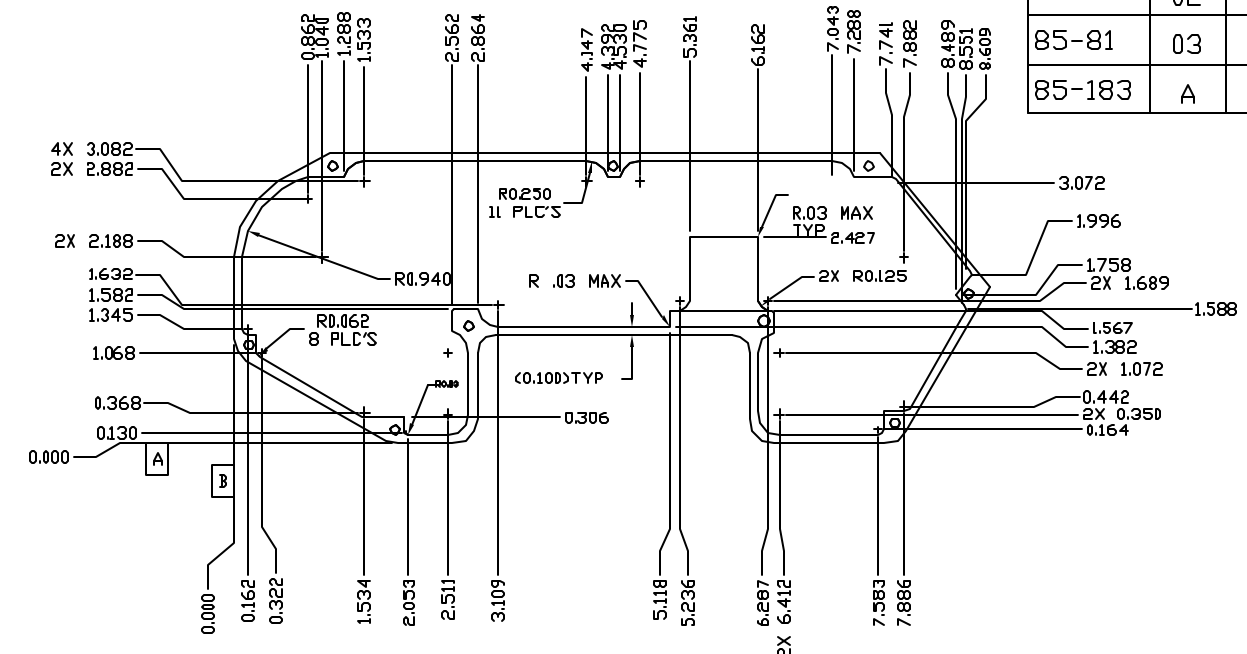
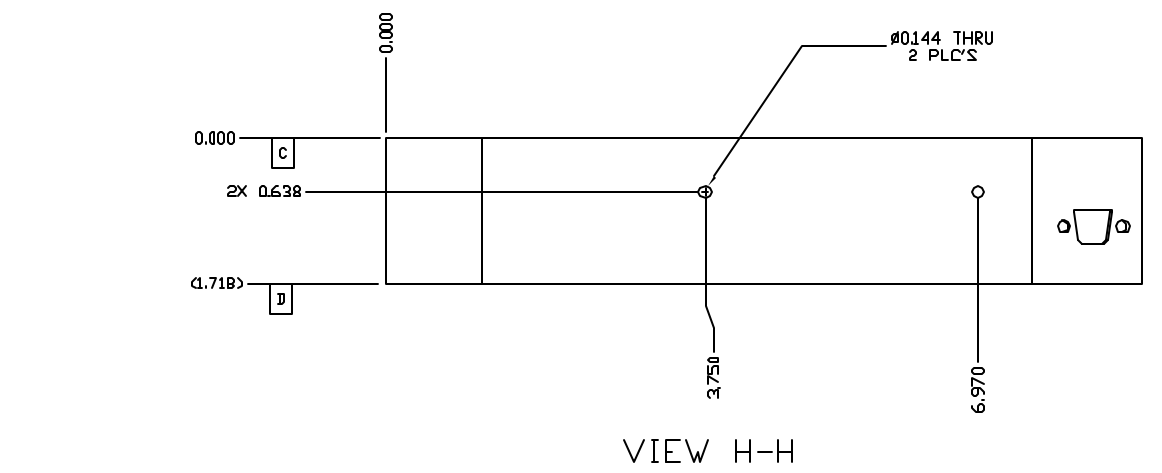
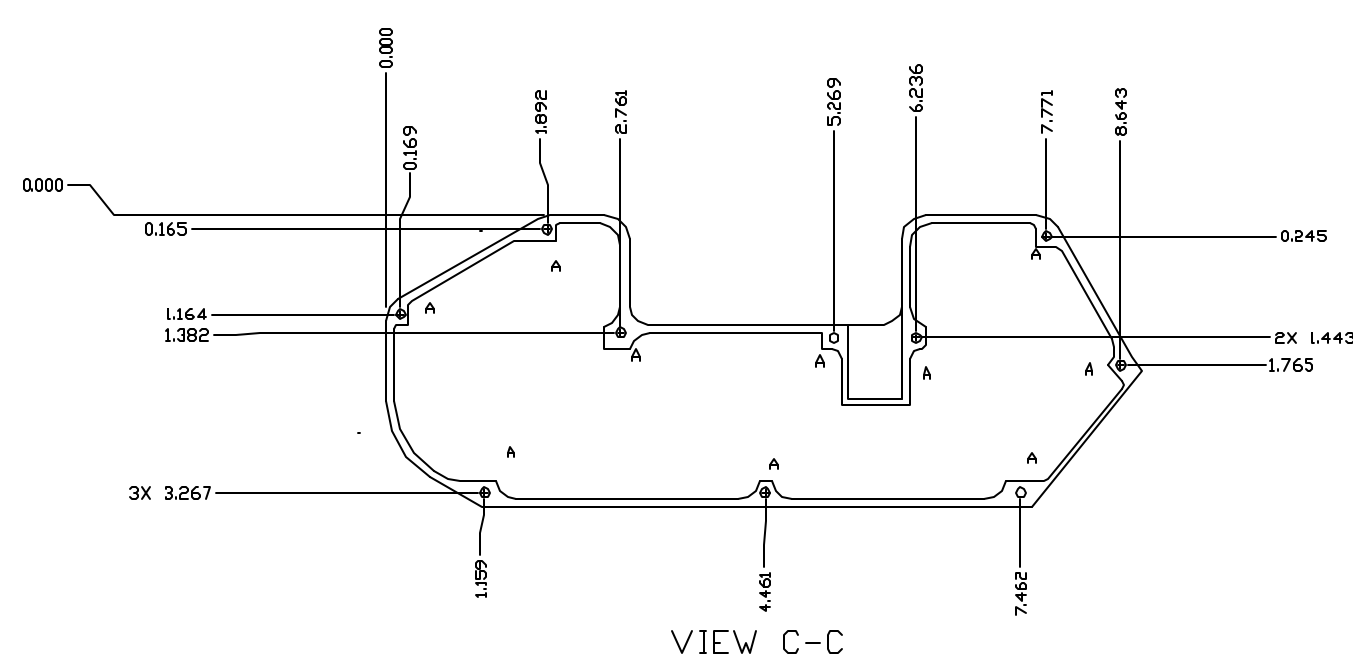
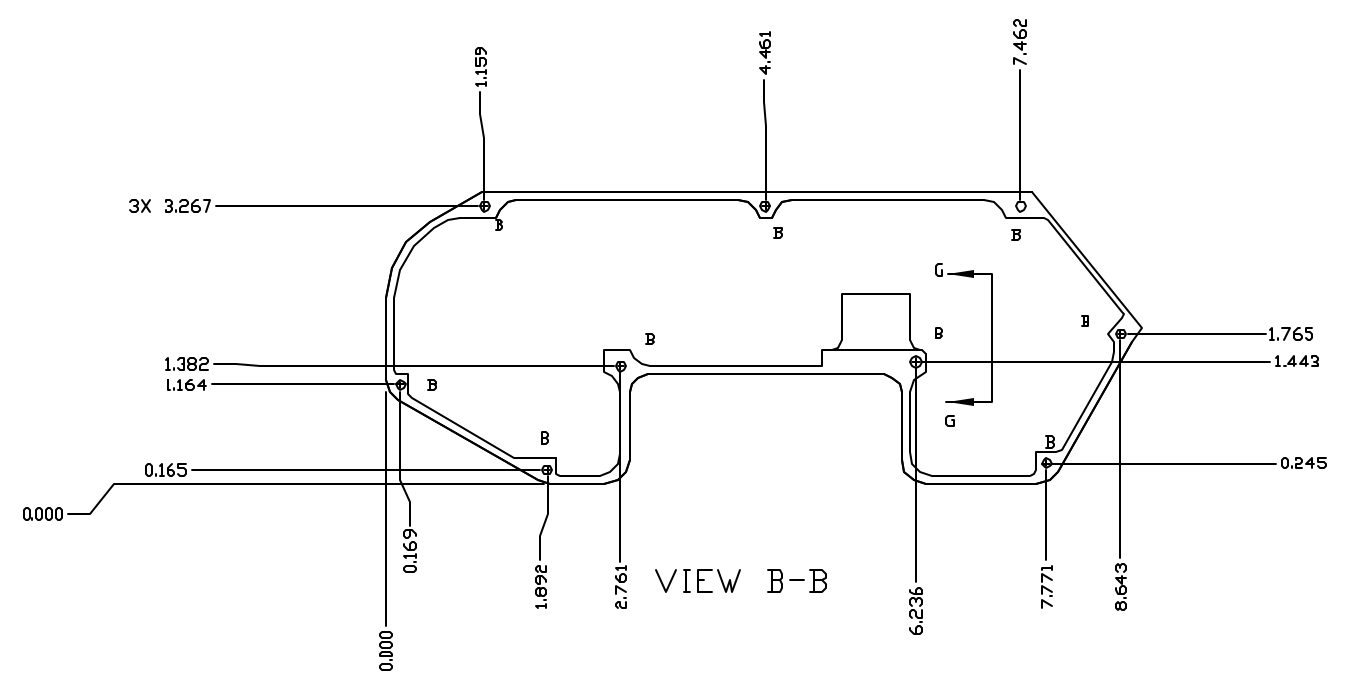


REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-68	01	TRAINING UNIT RELEASE		M. SMITH	1/25/04
85-75	02	ADD MISSING DIMENSIONS CHANGE MIC HOLE		M.SMITH	3/8/04
85-81	03	ADD LOCATION FOR D-SUB CONNECTOR		M.SMITH	4/16/04
85-183	A	ADD VIEW F-F, CHG RAD. AND DIA. ADD 2 Ø.09 HOLES. ADD VIEW G-G			



HOLE CHART			
HOLE	QTY	TOLERANCE	DESCRIPTION
A	10	⊕ ⌀.010 Ⓜ C   A   B	Ø.120 <sup>+0.003</sup> / <sub>-0.002</sub> THRU, √ Ø.155 ±0.015 X 120° ±5°, TAP ∇ .190 MIN FOR .112-40 UNC HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
B	9	⊕ ⌀.010 Ⓜ D   A   B	

- NOTES:
- CLEANLINESS REQUIREMENTS PER SN-C-0005 LEVEL VC-SENSITIVE.
  - BAG AND TAG WITH PART NUMBER AND REVISION.
  - BLACK ANODIZE PER NASA/JSC PRC 5006 CLASS 2 TYPE II, BLACK
  - MASK FROM ANODIZED FINISH. CONVERSION COAT PER MIL-C-5541, CLASS 3.
  - INSTALL INSERTS PER MS33537, REMOVE TANG. INSTALL INSERTS AFTER FINISH.
  - DEBURR AND BREAK SHARP EDGES.

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
MATERIAL 6061-T6 AL		DRAWN		
NOTE 3,4		CHECKED		ENCLOSURE, CHEST PACK
85-40400 VOILA		APPROVED		
NEXT ASSEMBLY USED ON		RELEASED		SIZE E
APPLICATION		FINISH		FSCM NO. 80230
				DWG NO. 85-40401
				REV A
				SCALE 1:1
				SHEET 1 OF 2

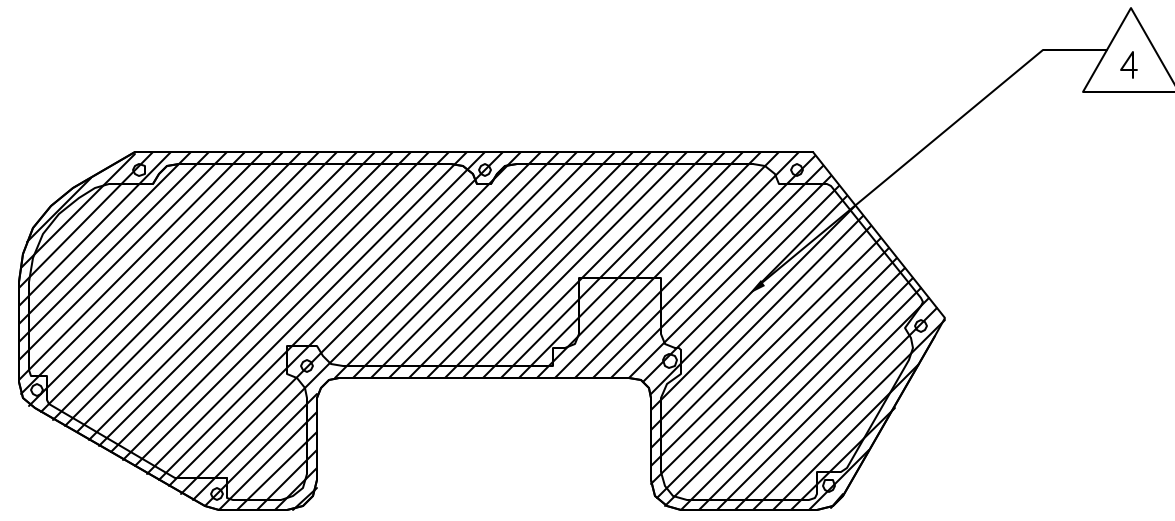
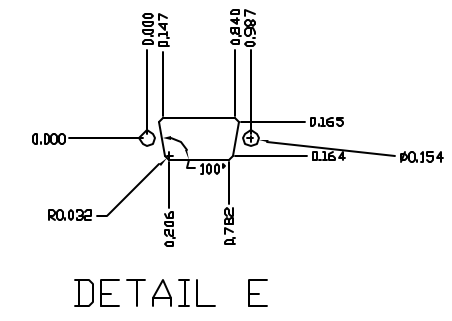
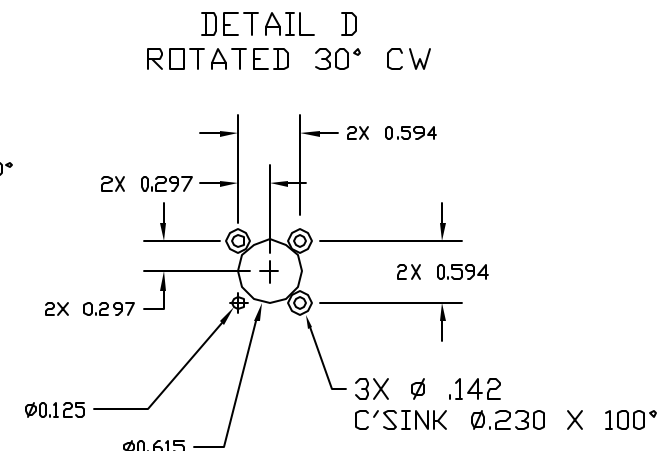
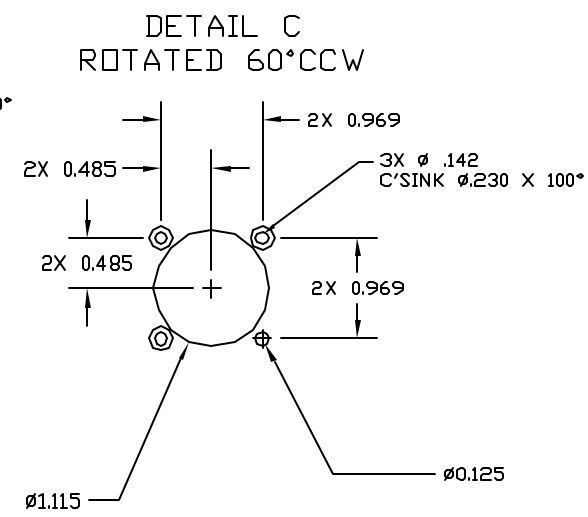
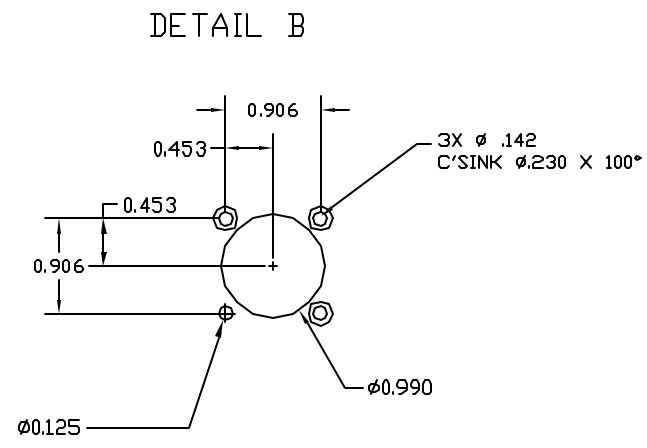
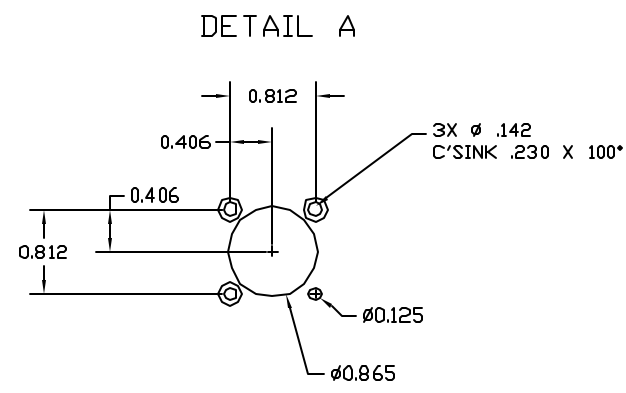
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3

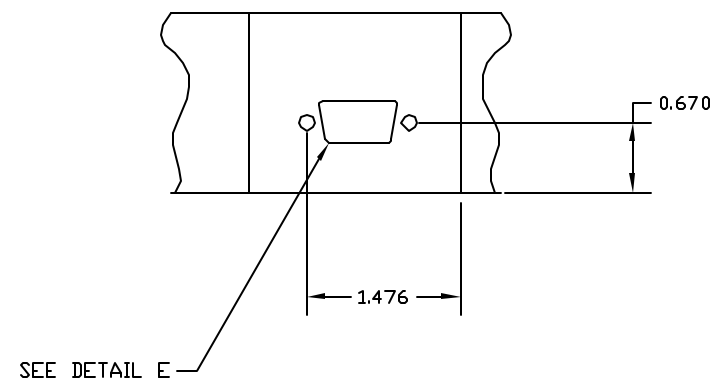
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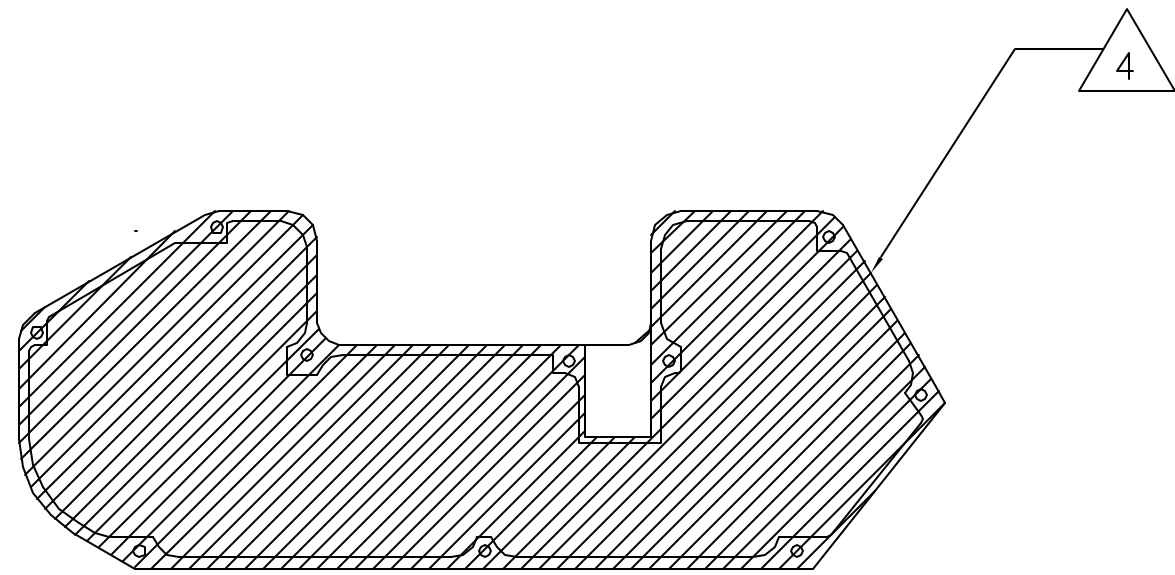
REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-183	A	SEE SHT 1			



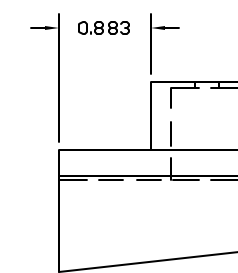
VIEW D-D



VIEW F-F



VIEW E-E



VIEW G-G

Massachusetts Institute of Technology  
Center for Space Research  
VOILA PROJECT

ENCLOSURE,  
CHEST PACK

SIZE E	FSCM NO. 80230	DWG NO. 85-40401	REV A
SCALE 1:1	SHEET 2 OF 2		

4

3

2

1