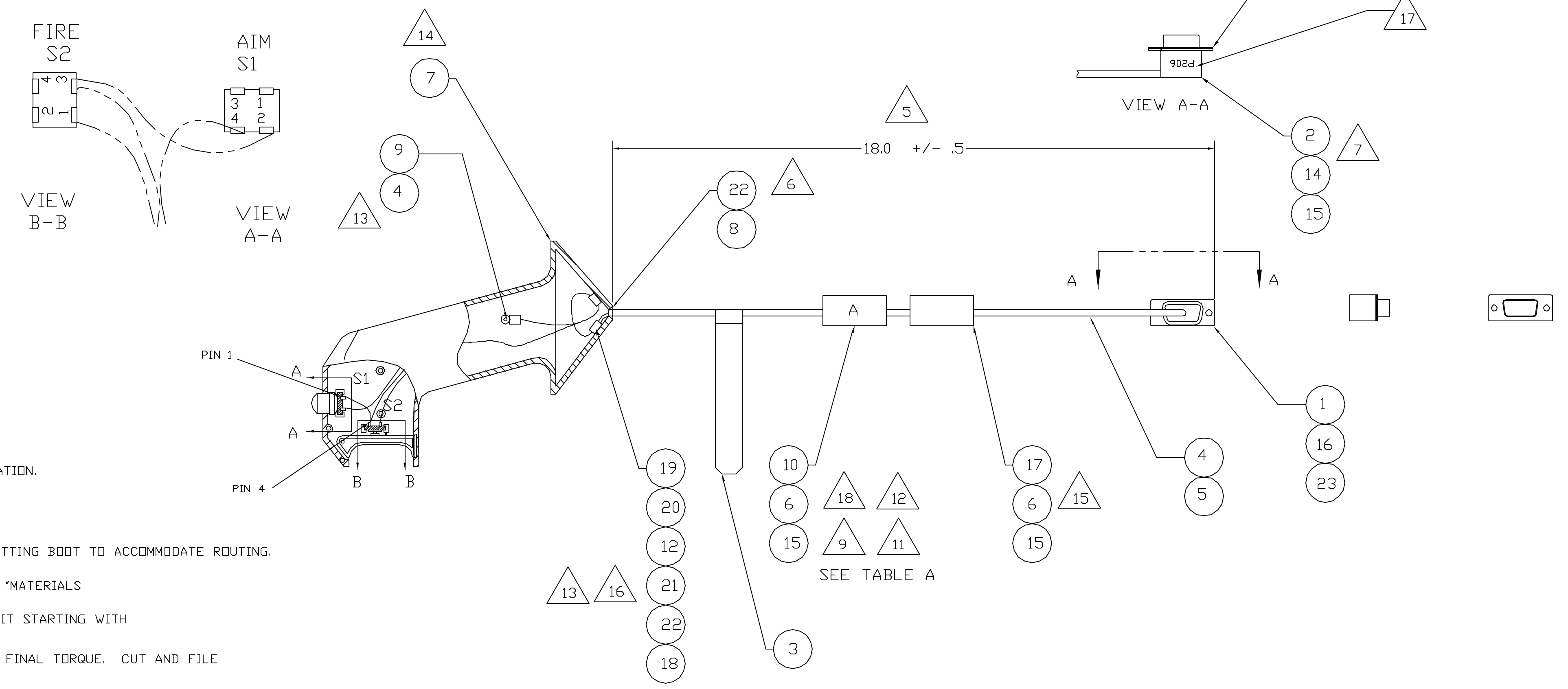


8 7 6 5 4 2 1

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-89	A	INITIAL RELEASE			



NOTES:

1. REFER TO MIT DRAWING 85-03020.41 FOR SCHEMATIC.
2. CLEAN F/N IAW MIT SPECIFICATION 85-xxxxxxx
3. WEIGH ASSEMBLY AFTER FINAL FABRICATION.
4. FABRICATE IAW NASA STD 8739.3.
5. FINAL LENGTH TO BE DETERMINED AFTER TRAINING UNIT FABRICATION.
6. ADD SHRINK TUBING (F/N 8) TO INCREASE CABLE DIAMETER FOR SNUG FIT INTO CABLE CLAMP.
7. POT WITH F/N 14 AND 13. ROUTE CABLE AS SHOWN. NOTCH POTTING BOOT TO ACCOMMODATE ROUTING.
8. RECORD EPOXIES USED, MIX RATIOS AND EXPIRATION DATES ON 'MATERIALS PROCESSING MIXING RECORD' SECTION OF AWD.
9. SERIALIZE TRAINING UNIT STARTING WITH '10x' AND FLIGHT UNIT STARTING WITH '30x'.
10. MAX ALLOWED PROTRUSION OF SCREWS IS TWO THREADS AFTER FINAL TORQUE. CUT AND FILE IS ACCEPTABLE. APPLY F/N 15 OVER EXPOSED THREADS.
11. TYPE LABEL IDENTIFICATION PER TABLE A IN .12 HIGH CHARACTERS USING BRADY MARKER XC PC PLUS PRINTER ROLL FILM (F/N 10) FOR CABLE MARKING. AT THE DESIRED LOCATION, WRAP 2-3 TIMES WITH GLASS CLOTH TAPE (F/N 15). PLACE ROLL FILM (F/N 10) ON GLASS CLOTH TAPE (F/N 15) WITH MARKING SHOWING & WRAP TWICE WITH TEFLON TAPE (F/N 6). TRIM OFF EXCESS MATERIALS.
12. MARK LABELS PER TABLE A. CHARACTERS TO BE .125" HIGH, EXACTLY AS SHOWN (EXCEPT SERIAL NUMBER TO BE AS NOTED.)
13. SPOT BOND USING F/N 22.
14. REMOVE TOP HALF OF F/N 7. AFTER COMPLETION OF WIRING AND INSPECTIONS REINSTALL. TORQUE SUPPLIED HARDWARE TO 42 IN OZ. SPOT BOND USING F/N 22.
15. APPLY IMS LABEL (F/N 17) TO THE RIGHT OF PART NUMBER LABEL AT THE MIDPOINT OF CABLE. PLACE SD TEXT IS READING IN THE SAME DIRECTION AS CABLE LABEL. COVER WITH 2-3 TURNS OF CLEAR TAPE F/N 6. TRIM OFF EXCESS.
16. TORQUE F/N 21 TO ___ IN OZ.
17. MARK "P206" ON CONNECTOR AS SHOWN USING F/N 24. COVER WITH F/N 13.
18. LOCATE APPROXIMATELY AT MIDPOINT OF CABLE.
19. SPOT BOND BODY OF S1 AND S2 USING F/N 22. DO NOT IMPEDE ACTION OF SWITCHES
20. BAG AND TAG WITH MIT PART NUMBER AND REVISION.

2 PLC'S

TABLE A

REF	TEXT	QTY
A	VOILA HANDSWITCH ASSY P/N 85-40408 S/N YXX	1

MATERIAL N/A	NAME	DATE	Massachusetts Institute of Technology Center for Space Research VOILA PROJECT	
	DRAWN	M. SMITH	12/03/01	
	CHECKED			
	APPROVED			
FINISH			HANDSWITCH ASSEMBLY	
	SIZE	FRGM NO.	DWG NO.	REV
	D	80230	85-40408	A
CAD FILE	SCALE	1:1	SHEET	1 OF 1