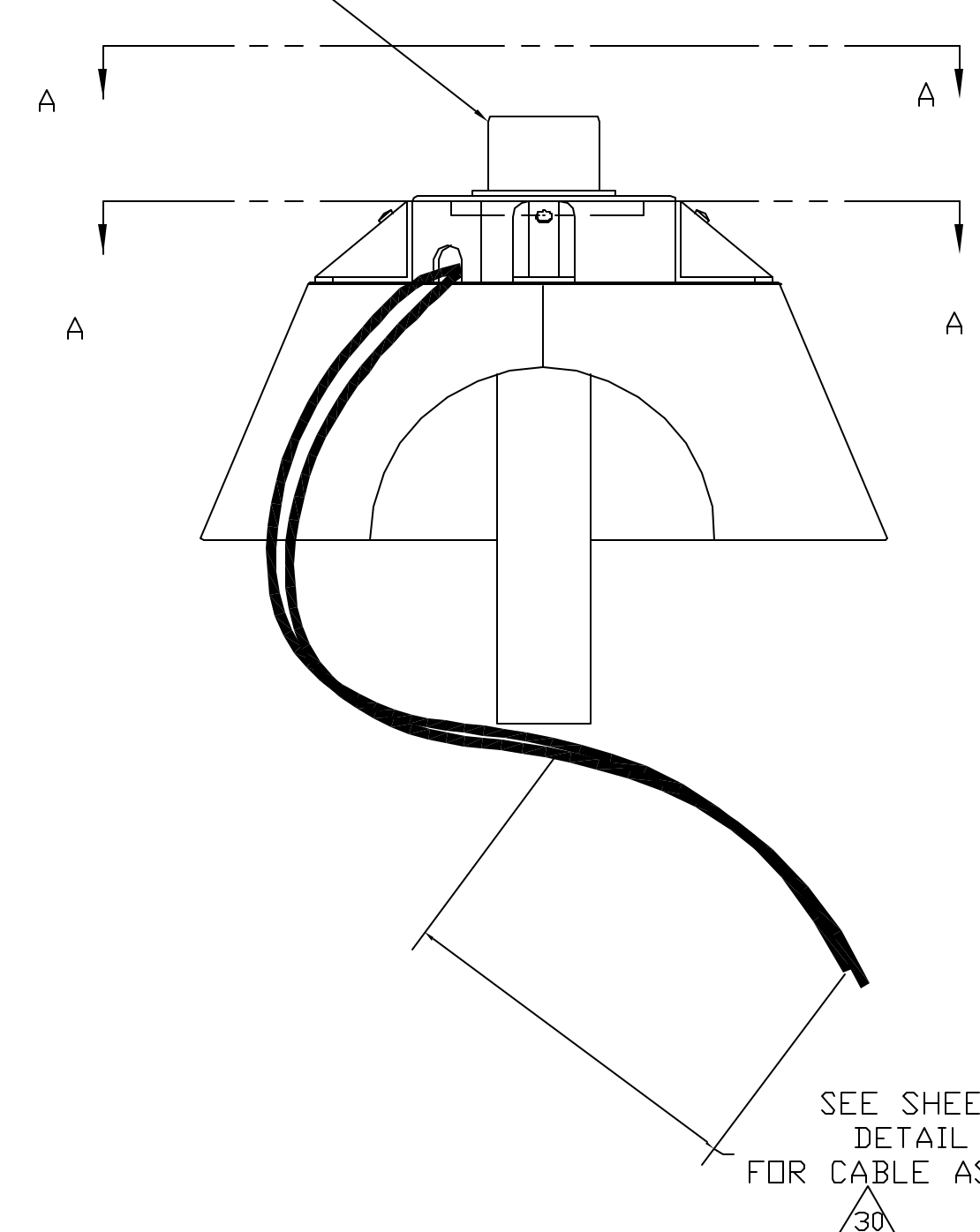
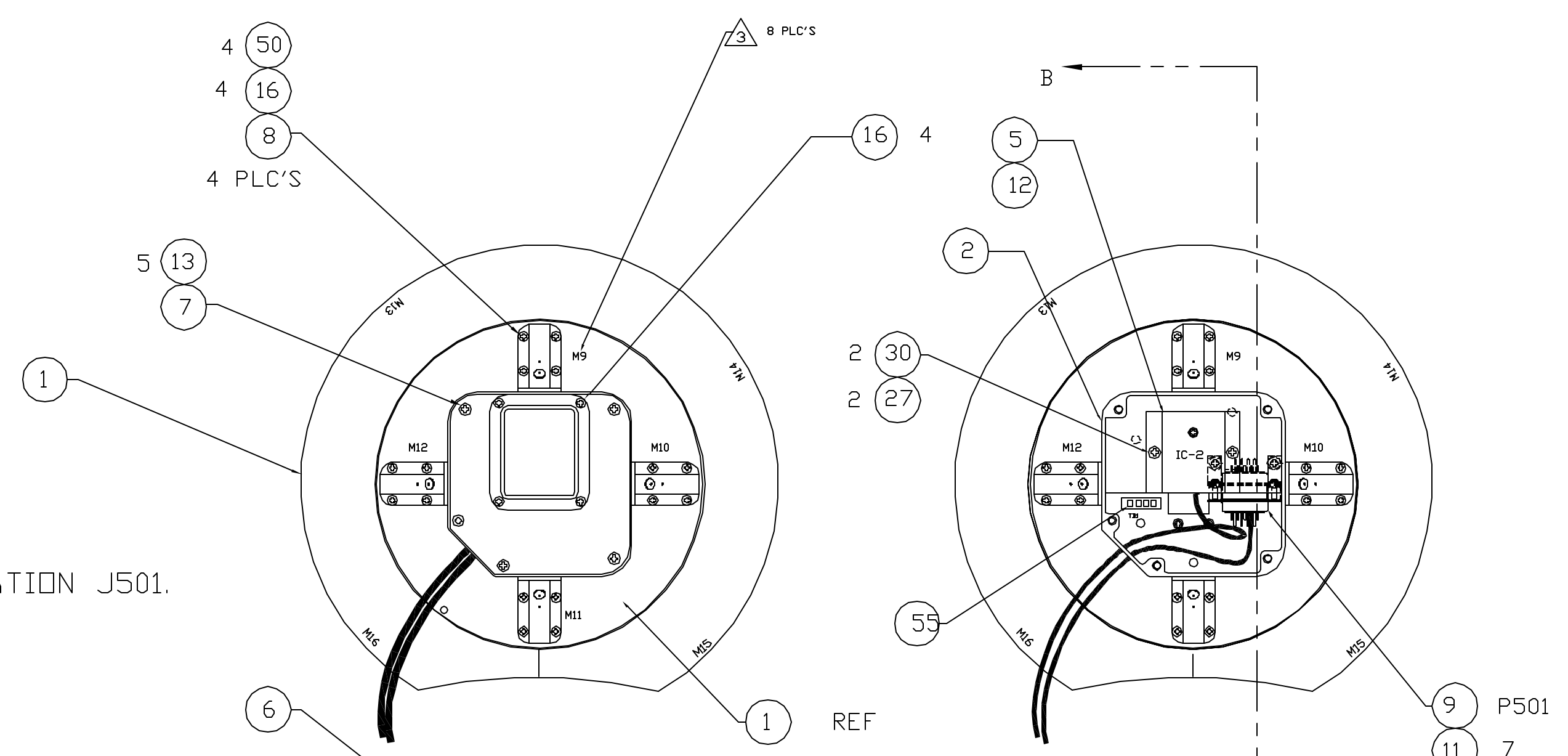


NOTES:

1. OVERALL LENGTH OF CABLE SHOULD BE 6.5 FEET.
2. CLEANLINESS REQUIREMENTS PER SN-C-0005 LEVEL GC.
3. PERMANENT INK STAMP IN .12 HIGH CHARACTERS WITH ITEM 20. LOCATE APPROXIMATELY WHERE SHOWN.
4. APPLY 1.5" OF F/N 55 ONTO F/N 54 PRIOR TO PLACING ONTO F/N 1. BOND F/N 54 TO F/N 1 USING F/N 57 AROUND PERIMETER OF F/N 54 IN 4 PLACES APPROXIMATELY WHERE SHOWN.
5. APPLY THIN LAYER OF F/N 28 TO TOP OF F/N 51, 52 AND 53. DO NOT GET ANY EPOXY ON LED. PRESS ONTO F/N 1 AND 8 FROM THE FAR SIDE. EPOXY AROUND PERIMETER OF F/N 51, 52 AND 53 USING F/N 28.
6. LOCATE F/N 24 APPROXIMATELY WHERE SHOWN.
7. FILL VOID WITH F/N 28.
8. TORQUE F/N 15, 16 AND 17 TO 54 IN- OZ.
9. TORQUE F/N 10, 13, 14 AND 30, TO 5 IN-LBS.
10. DISASSEMBLE F/N 54 AND REMOVE LED COVER USING DRILL BIT. ALSO DRILL THRU CENTER BUSHING USING A .091 DRILL. DISCARD SUPPLIED SCREW AND INSTALL USING F/N 17
11. STRIP OFF PVC OUTER JACKET ON F/N 48 AND REMOVE FROM CABLE. INSTALL F/N 48 TO F/N 3. ROUTE CABLE AS SHOWN. INSTALL F/N 48 TO F/N 1. ROUTE CABLE TO LOCATION J501. CUT CABLE FROM F/N 48 TO LENGTH AND INSTALL F/N 19. INSTALL CONTACTS INTO F/N 18
12. REFER TO MIT DRAWING 85-03020.51 FOR SCHEMATIC.
13. WEIGH ASSEMBLY AFTER FINAL FABRICATION. RECORD IN AWD.
14. FABRICATE IAW NASA STD 8739.4 AND .3.
15. ADD SHRINK TUBING (F/N 22) TO INCREASE CABLE DIAMETER FOR SNUG FIT INTO CABLE CLAMP.
16. APPLY F/N 29 TO THREADS OF BACKSHELL, F/N 43. TIGHTEN AS REQUIRED.
17. DO NOT INSTALL CONTACTS IN UNUSED POSITIONS.
18. PERFORM CONTACT RETENTION TEST ON ALL CONTACTS AFTER INSTALLATION.
19. TERMINATE SHIELD ON F/N 32 USING F/N'S 36 AND 37. COVER WITH F/N 38.
20. TYPE LABEL IDENTIFICATION PER TABLE A IN .125 HIGH CHARACTERS USING BRADY MARKER XC PC PLUS PRINTER ROLL FILM (F/N 21) FOR CABLE MARKING. AT THE DESIRED LOCATION, WRAP 2-3 TIMES WITH GLASS CLOTH TAPE (F/N 23). PLACE ROLL FILM (F/N 21) ON GLASS CLOTH TAPE (F/N 23) WITH MARKING SHOWING & WRAP TWICE WITH TEFLON TAPE (F/N 40). TRIM OFF EXCESS MATERIALS. LOCATE LABEL A APPROXIMATELY IN THE MIDDLE OF CABLE.
21. DISCARD HARDWARE SUPPLIED WITH F/N 43 AND SUBSTITUTE F/N 27 AND 30. HAND TIGHTEN AND SPOTBOND PER NOTE 25.
22. RECORD EPOXIES USED, MIX RATIOS AND EXPIRATION DATES ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF AWD.
23. APPLY IMS LABEL (F/N 39) RIGHT OF CABLE PART NUMBER LABEL WHEN THE LABEL NEAR THE MIDDLE OF THE CABLE. ORIENTATE TEXT IN LINE WITH CABLE LABEL. COVER WITH 2-3 TURNS OF CLEAR TAPE F/N 40. TRIM OFF EXCESS.
25. MAX PROTRUSION OF SCREW IS TWO THREADS AFTER FINAL TORQUE. CUT AND FILE IS ACCEPTABLE. APPLY F/N 29 OVER EXPOSED THREADS.
26. MARK LABELS PER TABLE A. CHARACTERS TO BE EXACTLY AS SHOWN (EXCEPT SERIAL NUMBER TO BE AS NOTED IN NOTE 27)
27. SERIALIZE TRAINING UNIT STARTING WITH "10X" AND FLIGHT STARTING WITH "3XX".
28. MARK ON CONNECTOR BACKSHELL THE ORIENTATION OF CONNECTOR MAIN KEYWAY USING MARKING INK (F/N 26).
29. INSTALL WASHER (F/N 27) AS REQUIRED TO BALANCE PRESSURE ON BACKSHELL CABLE CLAMP SCREWS.
30. LENGTH FROM HANDLE TO THE END OF P203 SHOULD BE ABOUT 4.5 FEET.

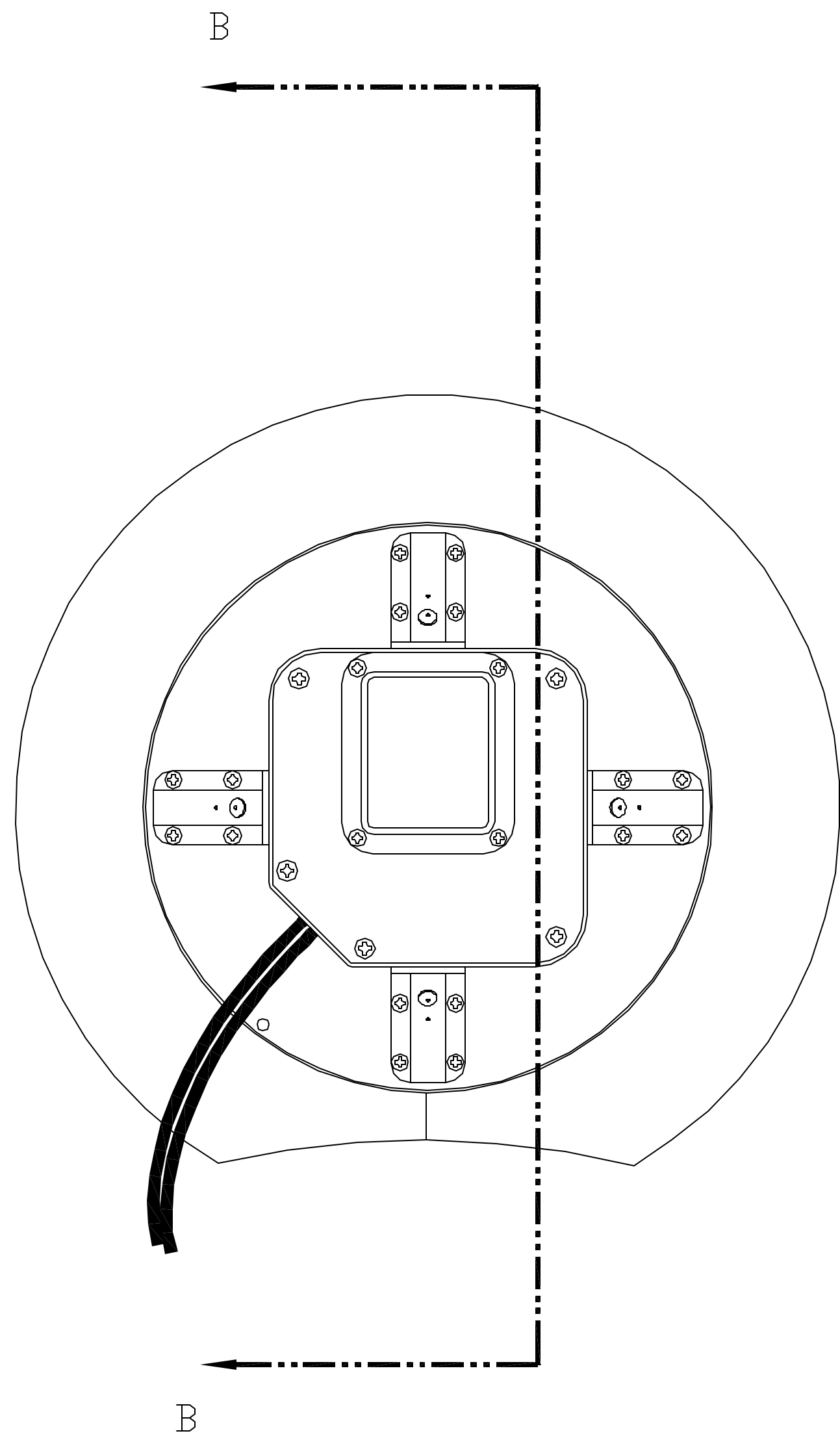
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85-96	A			RELEASE FOR MANUFACTURE			



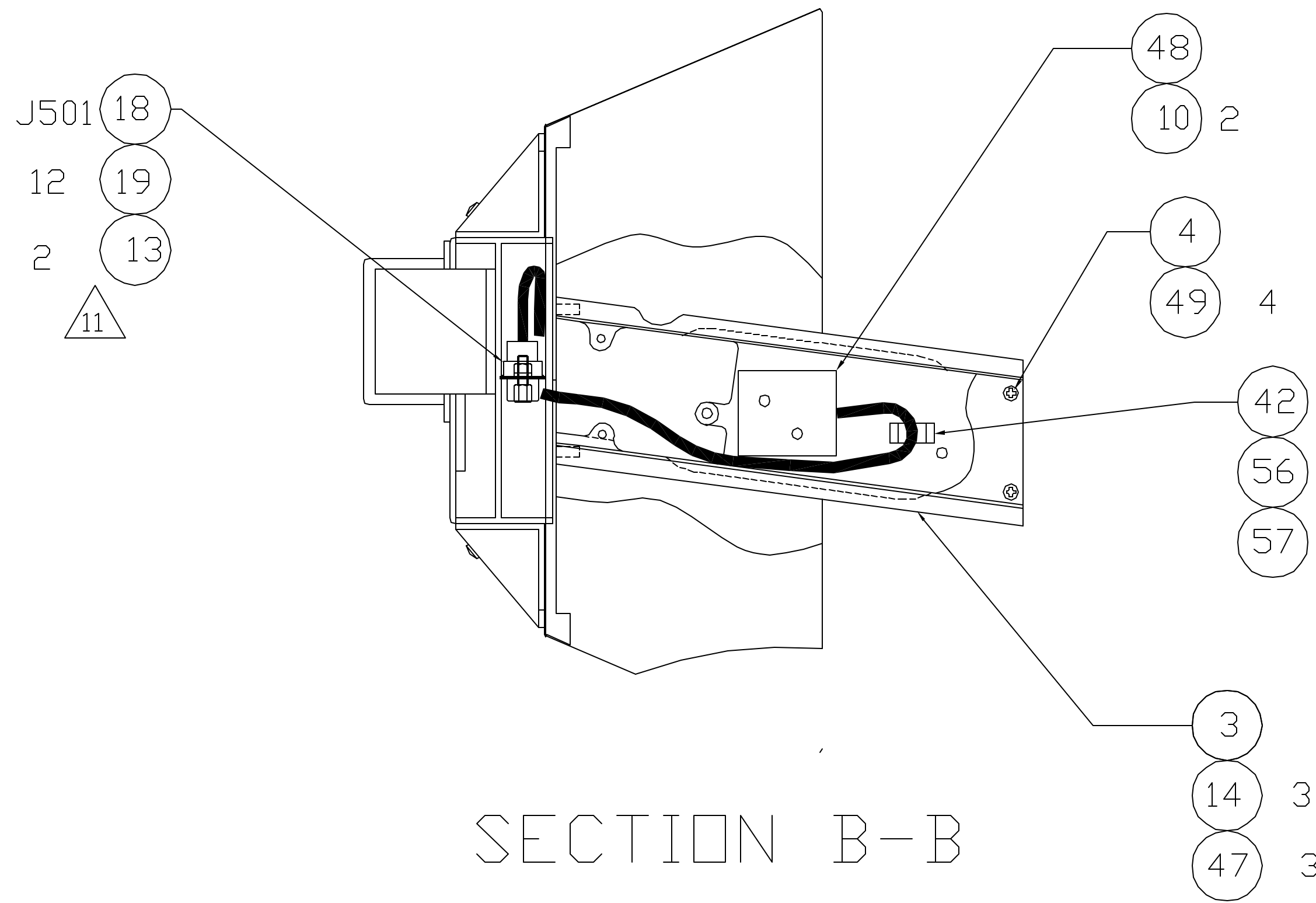
SEE SHEET 3
DETAIL B
FOR CABLE ASSEMBLY

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	
85-40000	VOILA	DRAWN		PADDLE ASSY	
		CHECKED			
		APPROVED			
		RELEASED			
NEXT ASSEMBLY	USED ON	FINISH		SIZE D	FSCM NO. 80230
APPLICATION				DWG NO. 85-40500	REV A
				SCALE 1:1	SHEET 1 OF 3

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-96	A	INITIAL RELEASE			



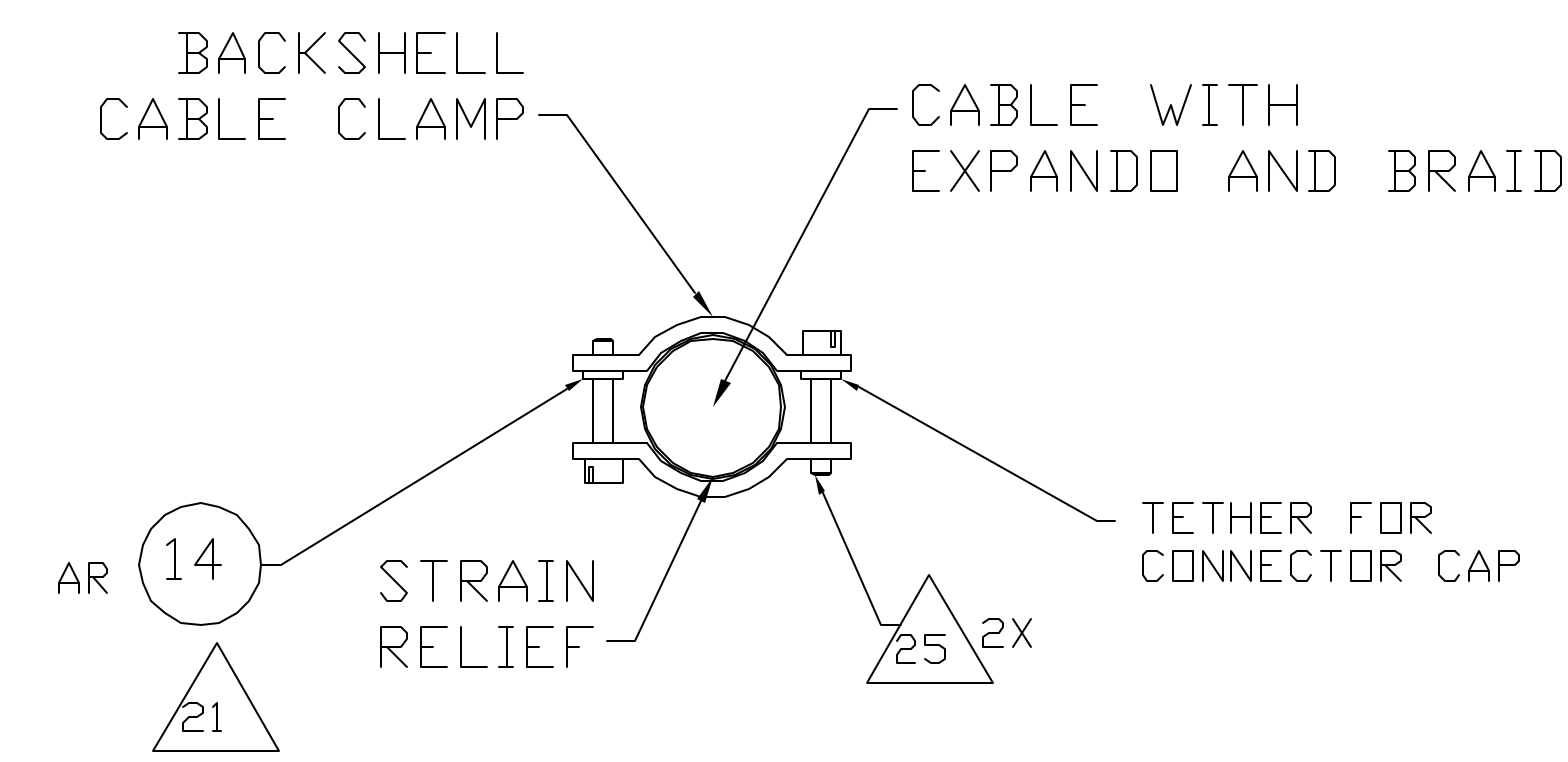
VIEW A-A



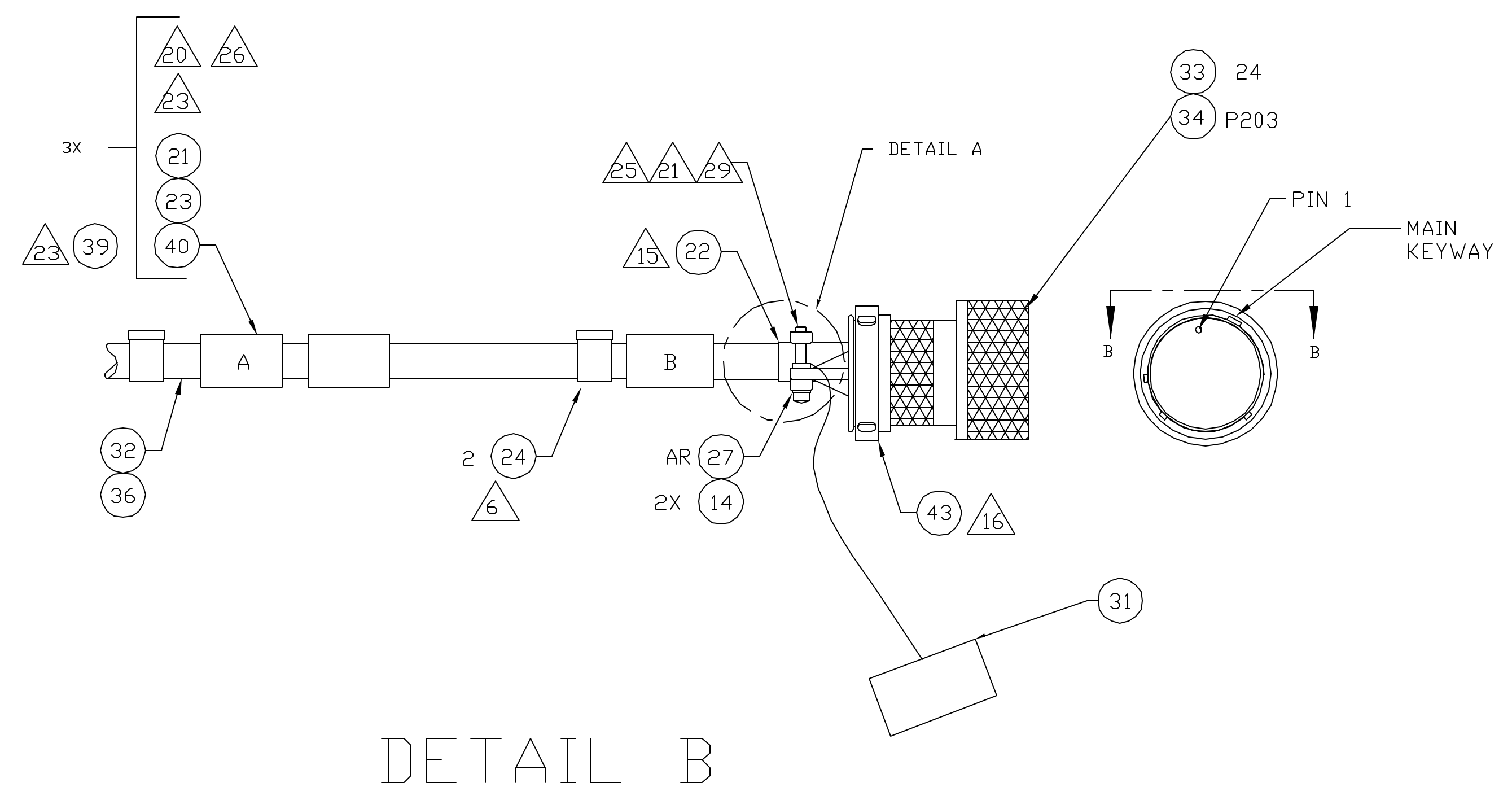
SECTION B-B

Massachusetts Institute of Technology Center for Space Research VOILA			
PADDLE ASSY			
SIZE D	FSCM NO. 80230	DWG NO. 85-40500	REV A
SCALE 1:1	SHEET 2 OF 3		

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-96	A	SEE SHEET 1			





DETAIL A
SOME ITEMS NOT SHOWN FOR CLARITY



DETAIL B

TABLE A

REF	TEXT	QTY
A	VOILA Paddle Assembly P/N 85-40500 S/N YXX  	1
B	P203 To VOILA Chestpack PADDLE J203	1

Massachusetts Institute of Technology
Center for Space Research
VOILA

PADDLE ASSY

SIZE D	FSCM NO. 80230	DWG NO. 85-40500	REV A
SCALE 1:1	SHEET 3 OF 3		