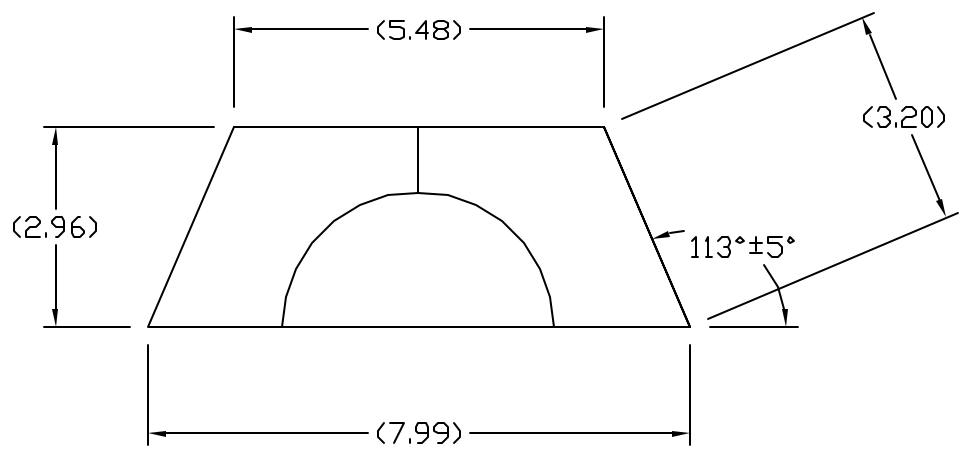
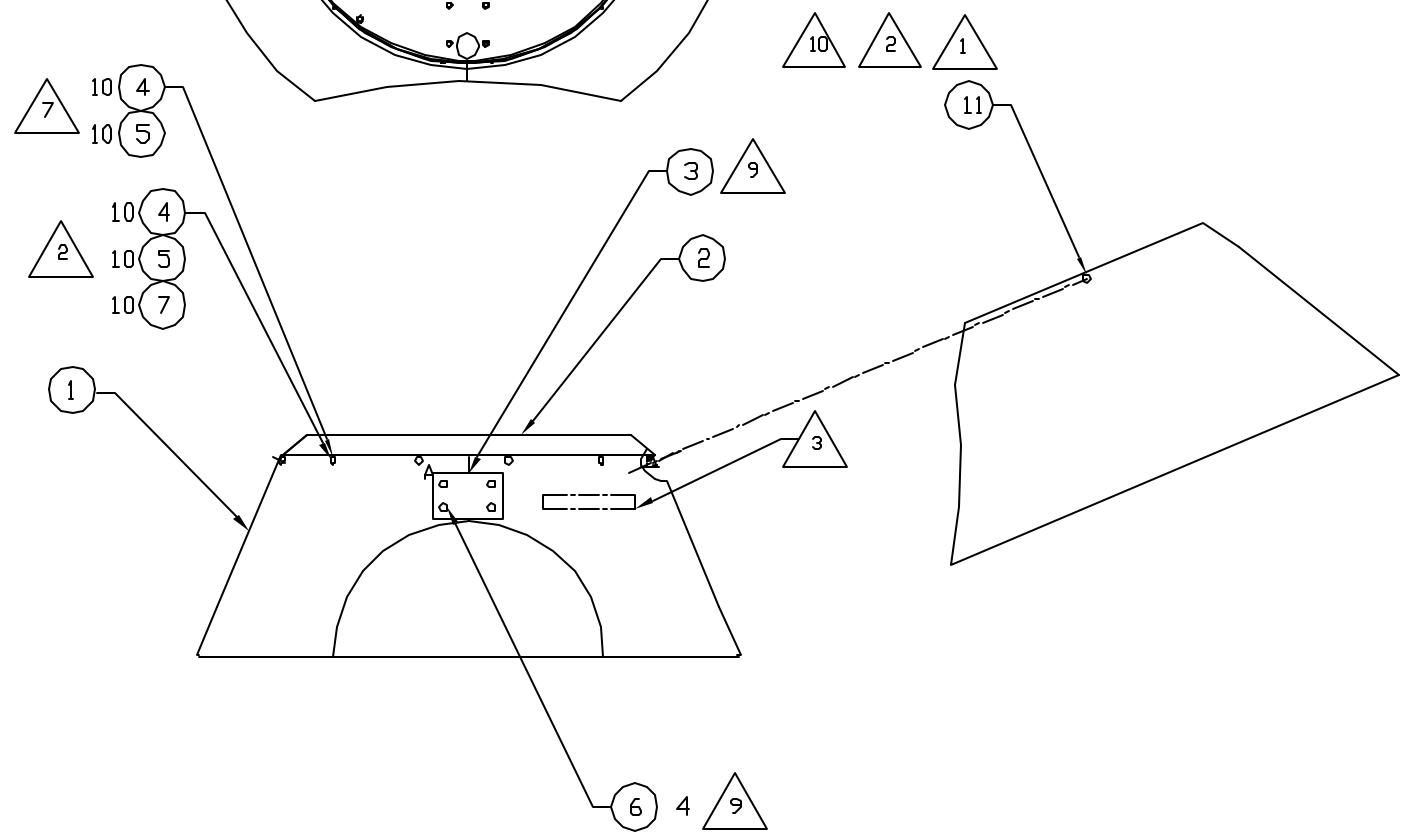
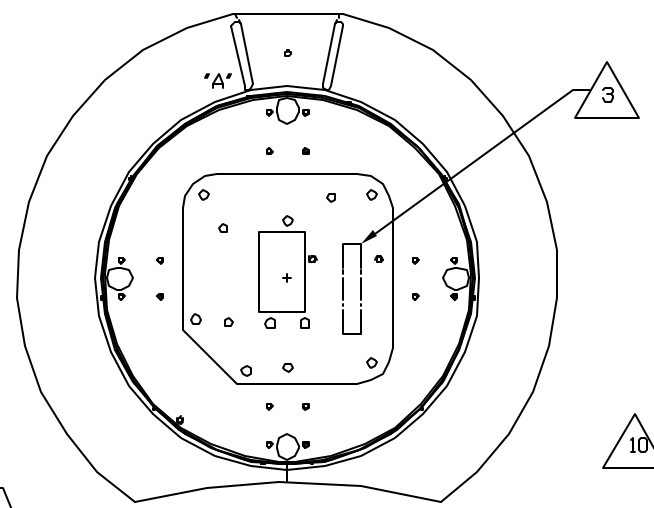


8 7 6 5 4 3 2 1

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-75	01	INITIAL RELEASE			
85-133	A	ADD SHT 2 AND 3, PLATING			

NOTES

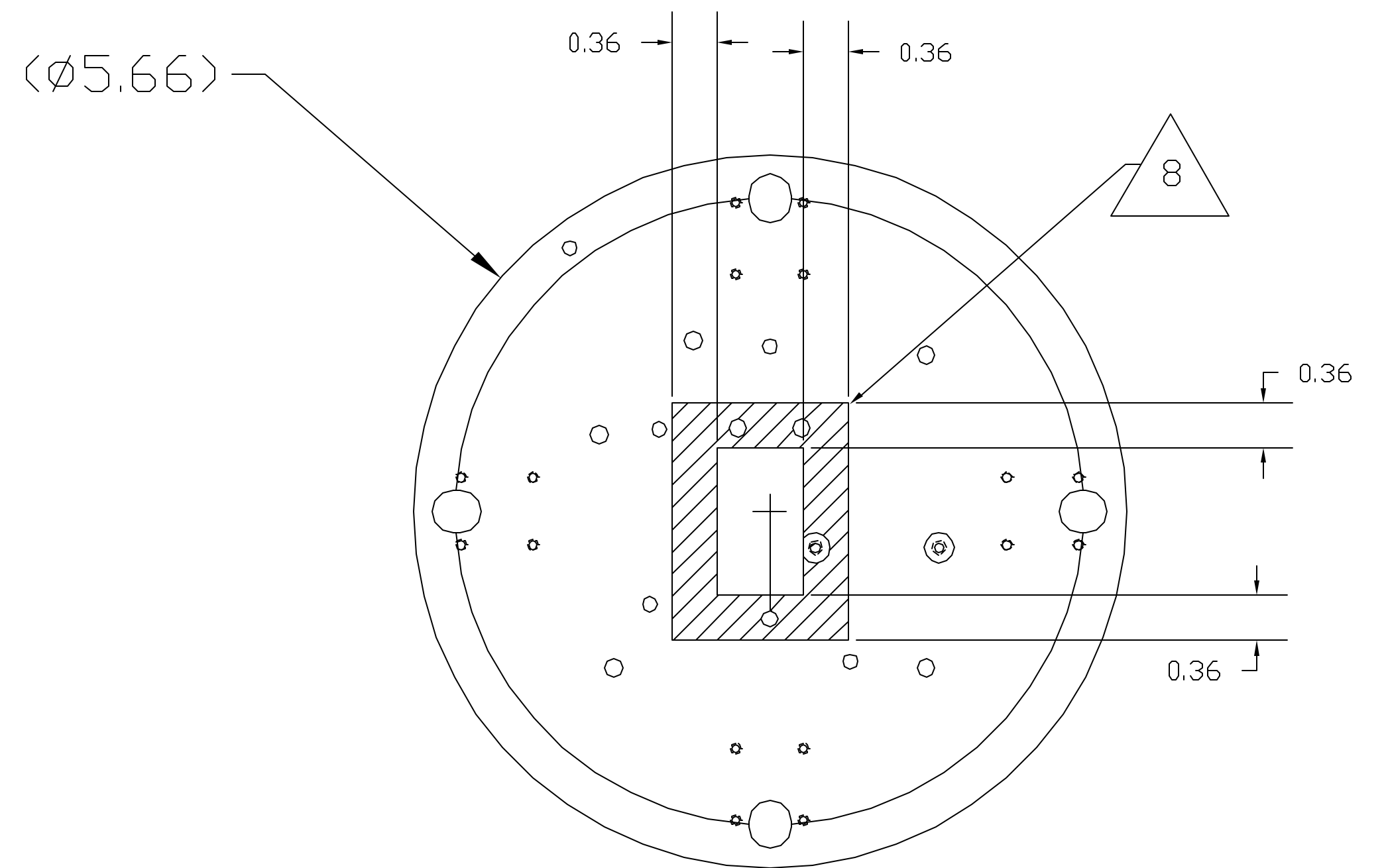
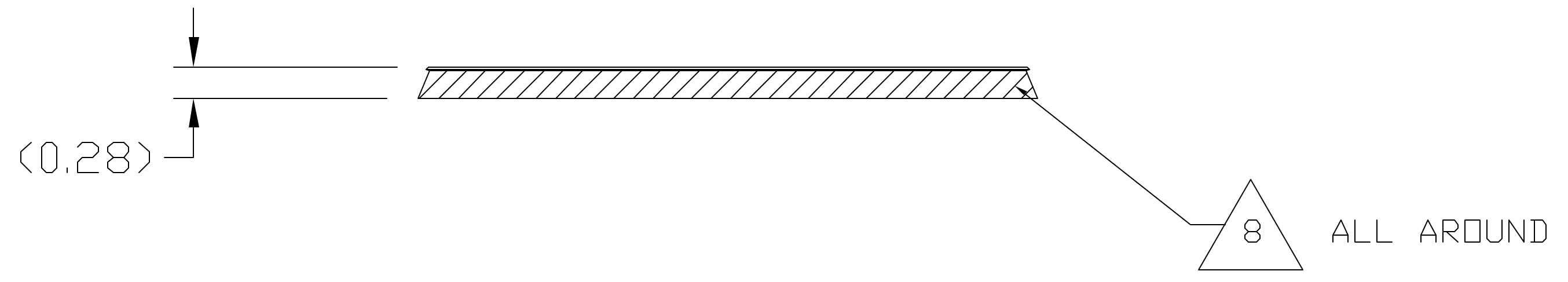
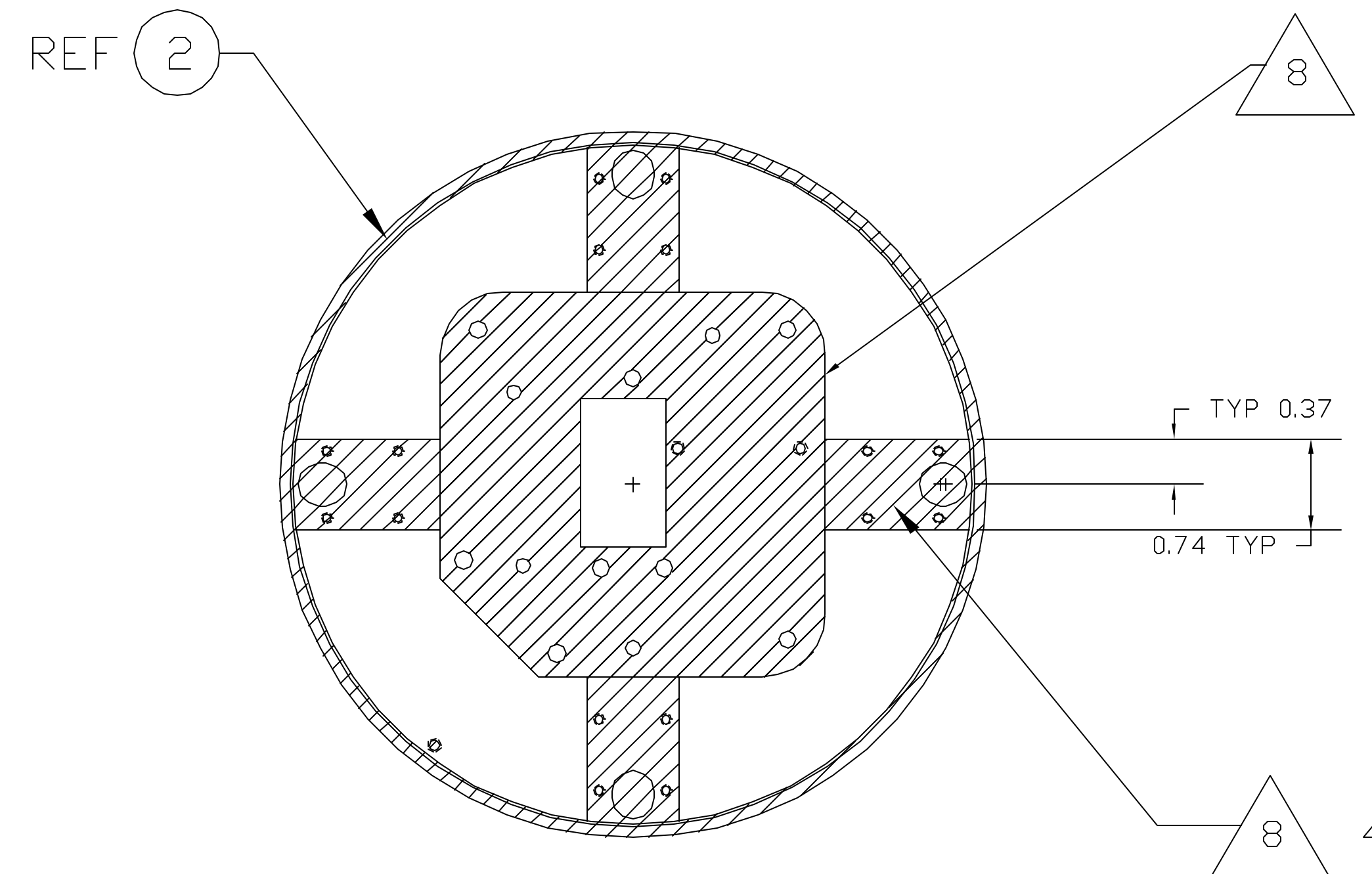
- 1. FORM F/N 1 TO ANGLE SHOWN AND WRAP AROUND F/N 2. ALIGN AND SECURE "A" HOLE. MATCH DRILL REMAINING 9 HOLES USING .0938 DRILL. DRILL PERPENDICULAR TO MATING SURFACE. TAP FOR #2-56 HELICAL STI. DRILL AND TAP THRU. INSTALL F/N 11 INTO F/N 2 AFTER PLATING.
- 2. TEMPORARILY INSTALL F/N 4, 5, AND 7 AFTER EACH DRILL OPERATION. INSTALL HARDWARE TO SECURE SKIRT PRIOR TO DRILLING NEXT HOLE. AFTER FORMING F/N 1 AND MATCH DRILLING F/N3 (SEE NOTE 9), REMOVE AND DISCARD HARDWARE.
- 3. ENGRAVE MATCHING SERIAL NUMBERS PER NOTE 6 ON EACH PART, FAR SIDE. MAINTAIN AS A MATCHED SET.
- 4. THIS DRAWING IS NOT TO SCALE.
- 5. AFTER FORMING AND MACHINING OPERATIONS ARE COMPLETE, DISASSEMBLE DISASSEMBLE F/N 1, 2 AND 3 AND BLACK ANODIZE F/N 1 AND 2 PER NASA/JSC PRC-5006, TYPE II, CLASS 2, COLOR BLACK.
- 6. MARK TRAINING UNITS STARTING WITH SERIAL NUMBER 100 AND FLIGHT WITH 300.
- 7. APPLY F/N 9 TO THREADS OF F/N 8 DURING FINAL ASSEMBLY.
- 8. MASK FROM ANODIZED FINISH. CHEM FILM PER MIL-C-5541 CLASS 3.
- 9. MATCH DRILL F/N 1 THRU F/N 3 PRIOR TO PLATING. INSTALL F/N 6 AT FINAL 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	
MATERIAL N/A		DRAWN	M. SMITH	3/8/D4	DOME/SKIRT FAB ASSEMBLY
NOTE 5 FINISH		CHECKED			
85-40500	VOILA	APPROVED			SIZE
NEXT ASSEMBLY	USED ON	RELEASED			FORM NO.
APPLICATION		CAO FILE			DWG NO.
					85-40501
					REV
					A
					SCALE
					1:1
					SHEET
					1 OF 4

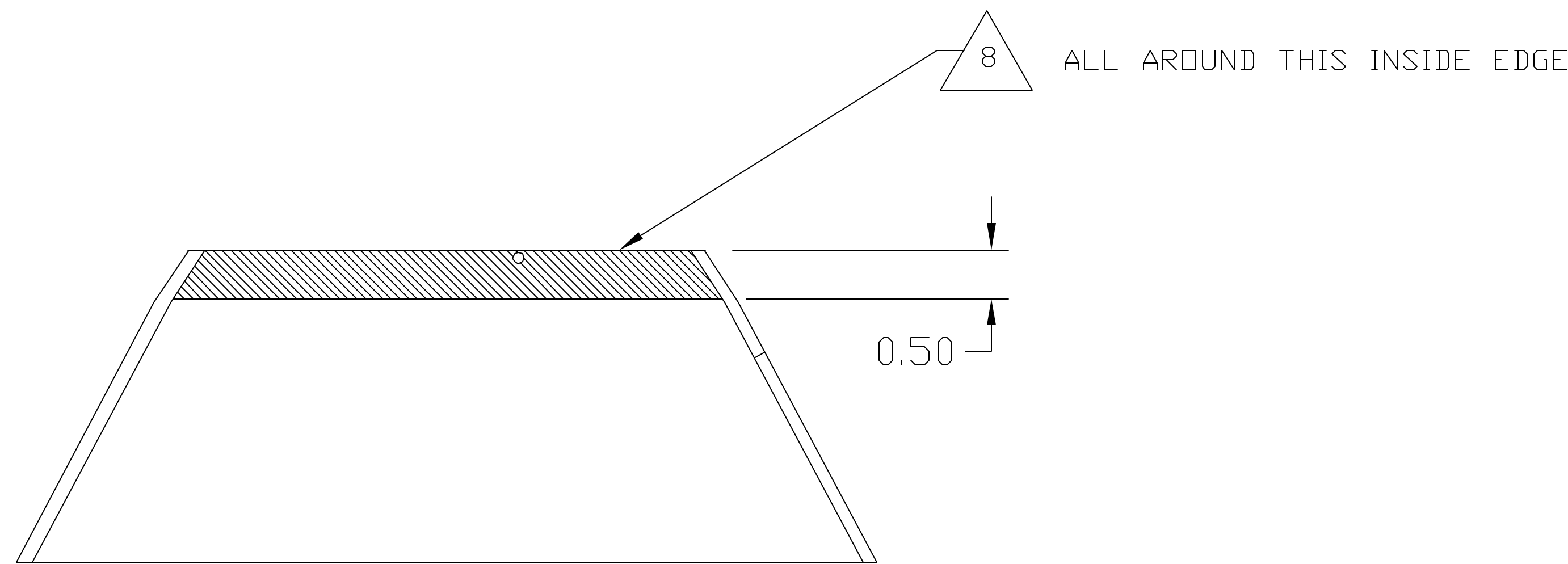
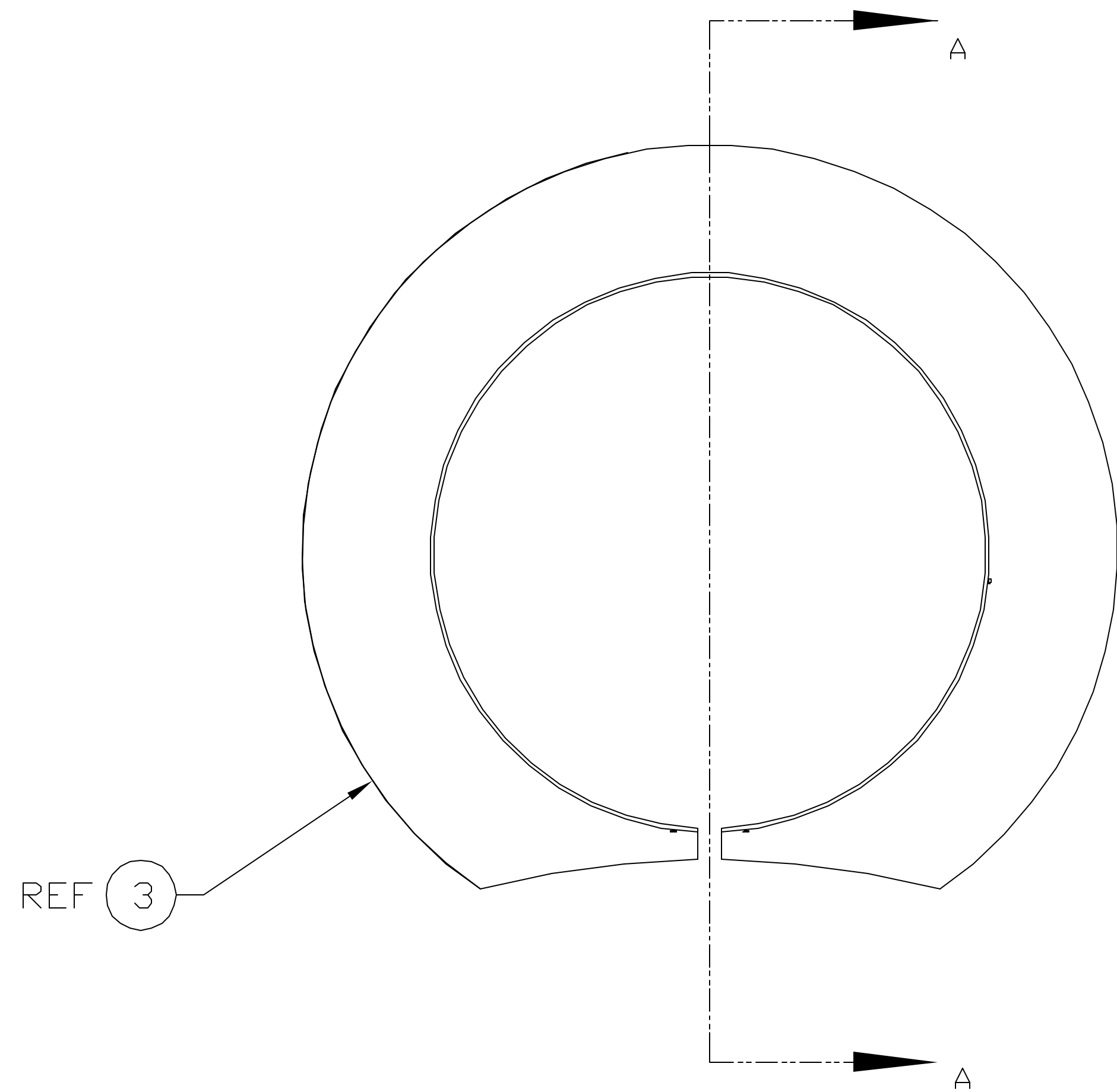
8 7 6 5 4 3 2 1

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-75	01	INITIAL RELEASE			
		ADD SHT 2 AND 3, PLATING			

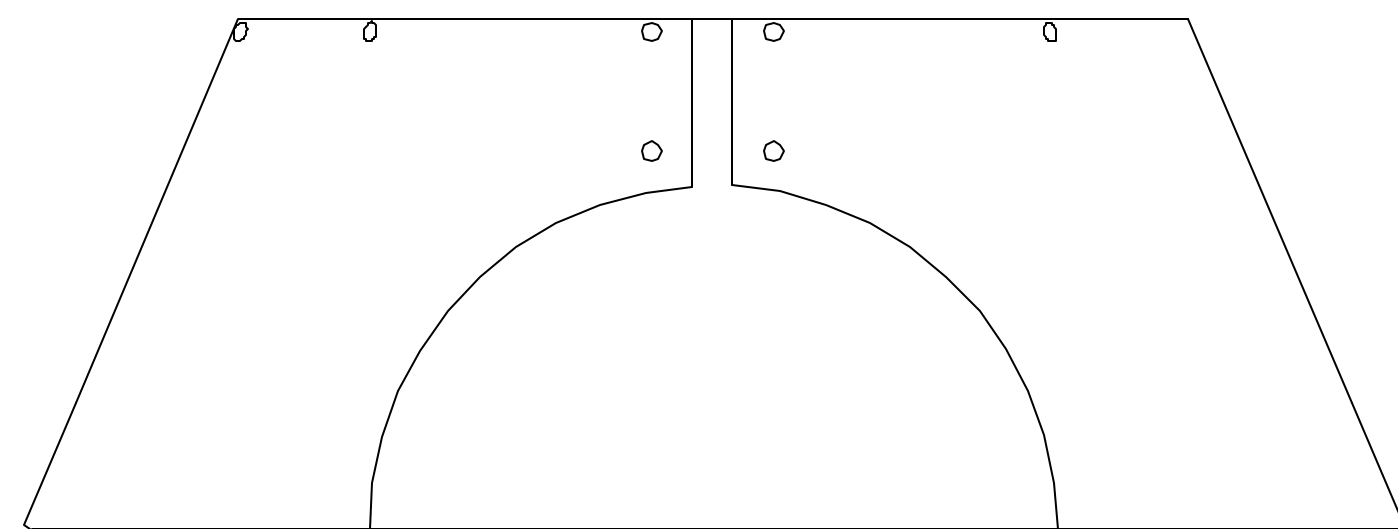


UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE: ANGLES +/- 1° 3 PLACE DECIMALS +/- .005 2 PLACE DECIMALS +/- .01	NAME	DATE	Massachusetts Institute of Technology Center for Space Research VOILA			
	DRAWN M. SMITH	3/8/04	DOME/SKIRT FAB ASSEMBLY			
	CHECKED					
	APPROVED					
MATERIAL N/A	RELEASED		SIZE D	FSCM NO. 80230	DWG NO. 85-40501	REV A
NOTE 5, 8 FINISH			SCALE 1:1	SHEET 2 OF 3		

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-75	01	INITIAL RELEASE			
85-155	A	ADD SHT 2 AND 3, PLATING			



SECTION A-A
ROTATED 90° CW



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			
	DRAWN M. SMITH	3/8/04	DOME/SKIRT FAB ASSEMBLY			
	CHECKED					
	APPROVED					
MATERIAL N/A	RELEASED		SIZE D	FSCM NO. 80230	DWG NO. 85-40501	REV A
NOTE 5, 8 FINISH			SCALE 1:1	SHEET 30F 3		