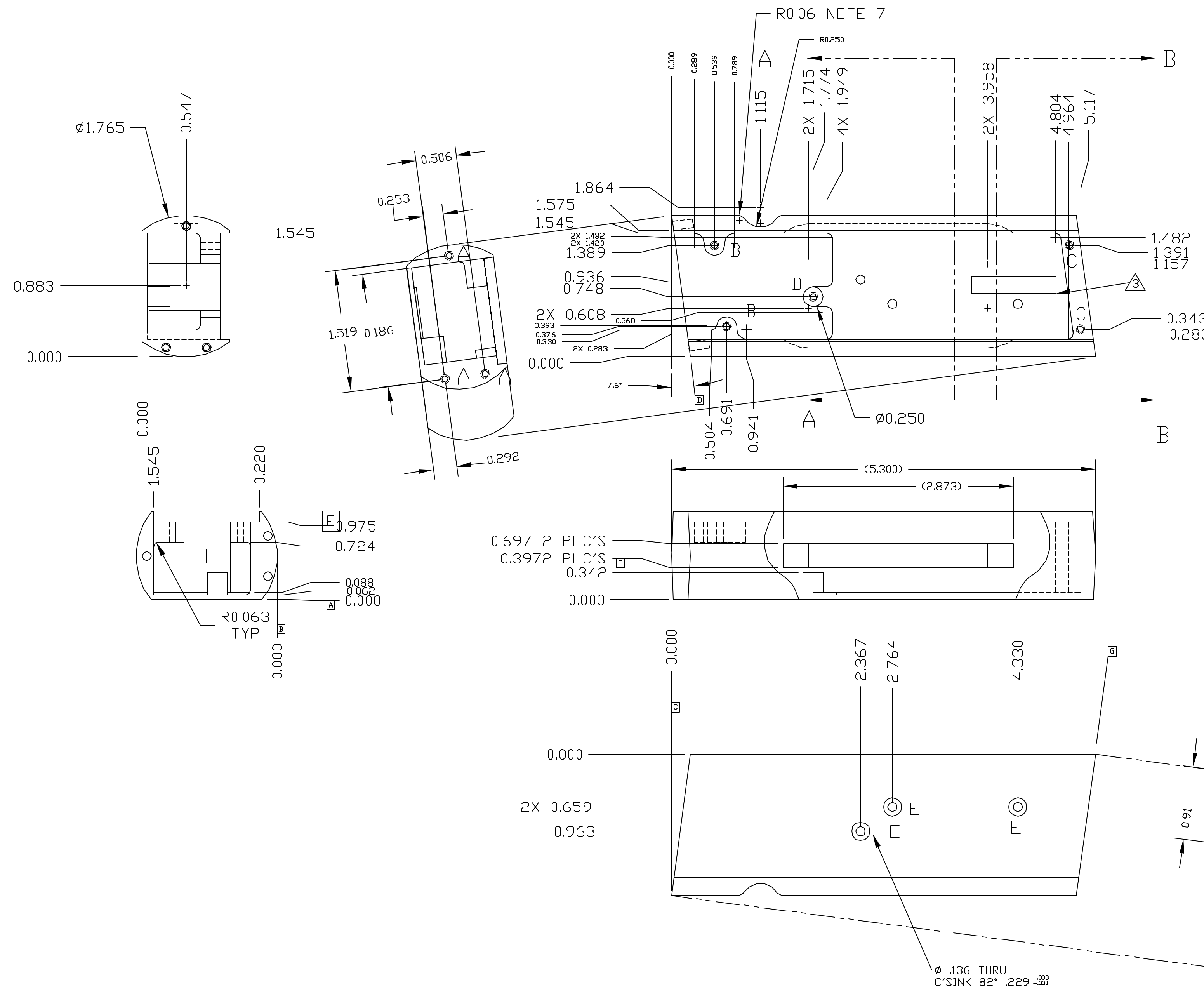
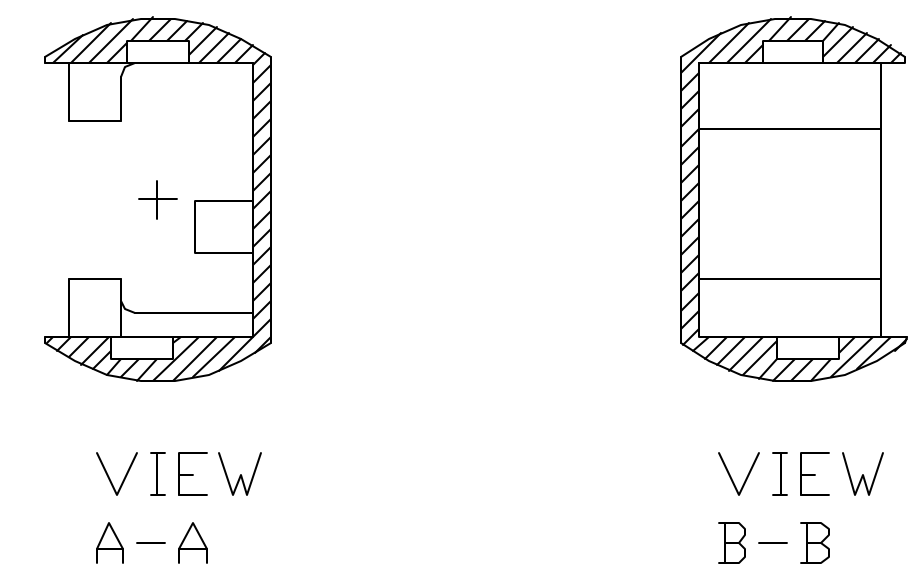


REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-74	01	INITIAL RELEASE		M. SMITH	3/8/04
85-80	A	RELEASE FOR BUILD			



HOLE CHART			
HOLE	QTY	TOLERANCE	DESCRIPTION
A	3	$\varnothing 0.010$ (M) D A B	$\varnothing 0.120$ $^{+0.003}_{-0.002}$ $\nabla$ .32 MIN DP, $\nabla \varnothing 0.14-.17$ X 120° $\pm 5^\circ$ , TAP $\nabla$ .212 FOR #4-40 UNC UNC HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
B	2	$\varnothing 0.010$ (M) E A B	$\varnothing 0.120$ $^{+0.003}_{-0.002}$ THRU, $\nabla \varnothing 0.14-.17$ X 120° $\pm 5^\circ$ , TAP $\nabla$ .212 FOR #4-40 UNC UNC HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
C	2	$\varnothing 0.010$ (M) E A B	$\varnothing 0.120$ $^{+0.003}_{-0.002}$ .32 MIN DP, $\nabla \varnothing 0.14-.17$ X 120° $\pm 5^\circ$ , TAP $\nabla$ .212 FOR #4-40 UNC UNC HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
D	1	$\varnothing 0.010$ (M) F A B	$\varnothing 0.120$ $^{+0.003}_{-0.002}$ .32 MIN DP, $\nabla \varnothing 0.14-.17$ X 120° $\pm 5^\circ$ , TAP $\nabla$ .212 FOR #4-40 UNC UNC HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
E	3	$\varnothing 0.010$ (M) A C B	$\varnothing 0.136$ $^{+0.003}_{-0.002}$ THRU, $\nabla \varnothing 0.229$ X 85° $\pm 5^\circ$ ,
F	1	$\varnothing 0.010$ (M) D A B	$\varnothing 0.120$ $^{+0.003}_{-0.002}$ THRU, $\nabla \varnothing 0.14-.17$ X 120° $\pm 5^\circ$ , TAP THRU FOR #4-40 UNC UNC HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.

- NOTES:
- ALL DIMENSIONS ARE IN INCHES.
  - CLEANLINESS REQUIREMENTS PER SN-C-0005 LEVEL VC-SENSITIVE.
  - PERMANENT INK STAMP PN AND REV IN .12 HIGH CHARACTERS WITH ITEM 2 LOCATE APPROXIMATELY WHERE SHOWN. ENGRAVING IS ACCEPTABLE.
  - CHEM FILM PER MIL-C-5541, CLASS 3.
  - INSTALL INSERTS PER MS33537, REMOVE TANG. INSTALL I INSERTS AFTER FINISH.
  - RADIUS ALL CORNERS .06 MAX. DEBUR AND BREAK SHARP EDGES. FILLET RADIUS .02 MAX.
  - RADIUS ALL AROUND EDGE.
  - UNTOLERANCED DIMENSIONS LOCATING TRUE POSITION ARE BASIC.

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 6061 T6 AL		DRAWN M. SMITH	3/7/04	
NOTE 4 FINISH		CHECKED		HANDLE, PADDLE ASSY
85-40500 VOILA		APPROVED		
NEXT ASSEMBLY USED ON		RELEASED		SIZE D
APPLICATION		CAD FILE		FSCM NO. 80230
				DWG NO. 85-40503
				SCALE 1:1
				SHEET 1 OF 1