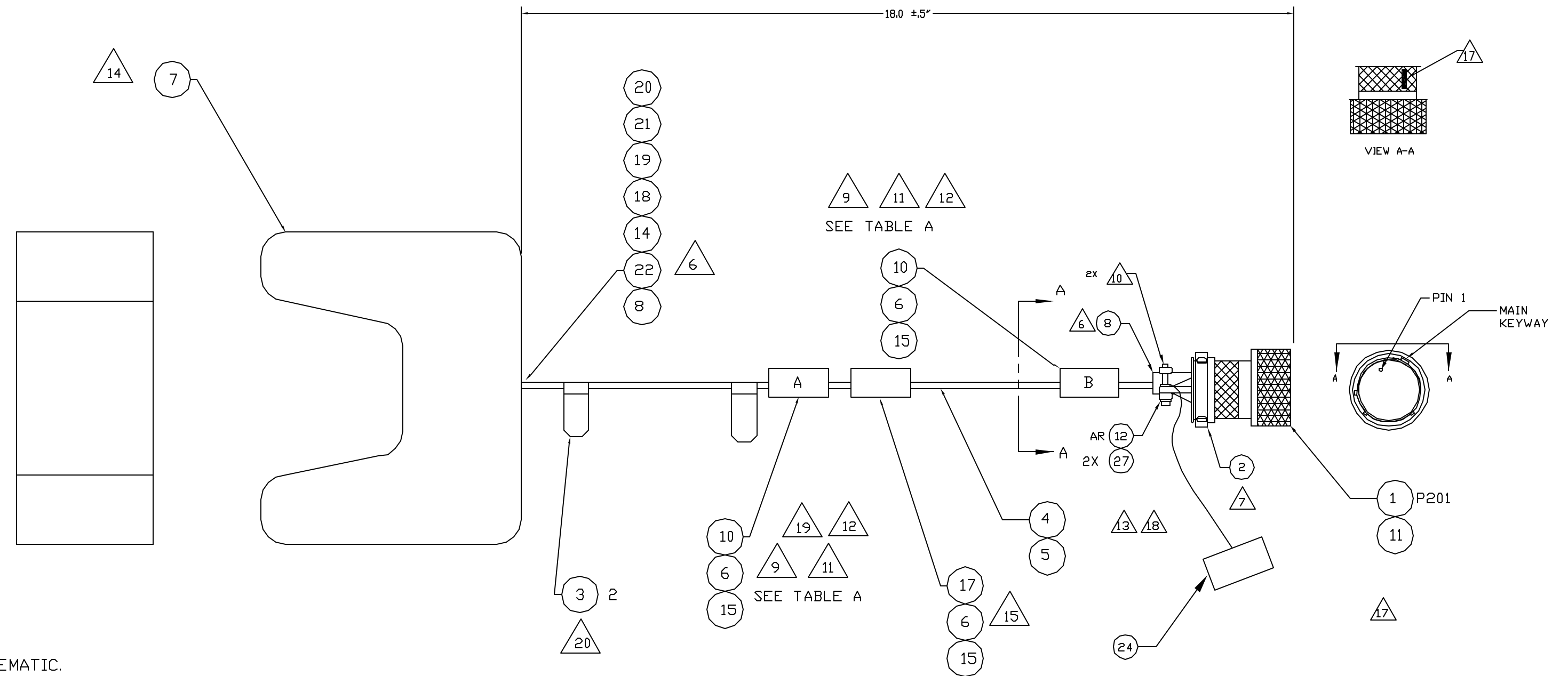


REV		DESCRIPTION	CHECKED	APPROVED	DATE
85-89	A	INITIAL RELEASE			

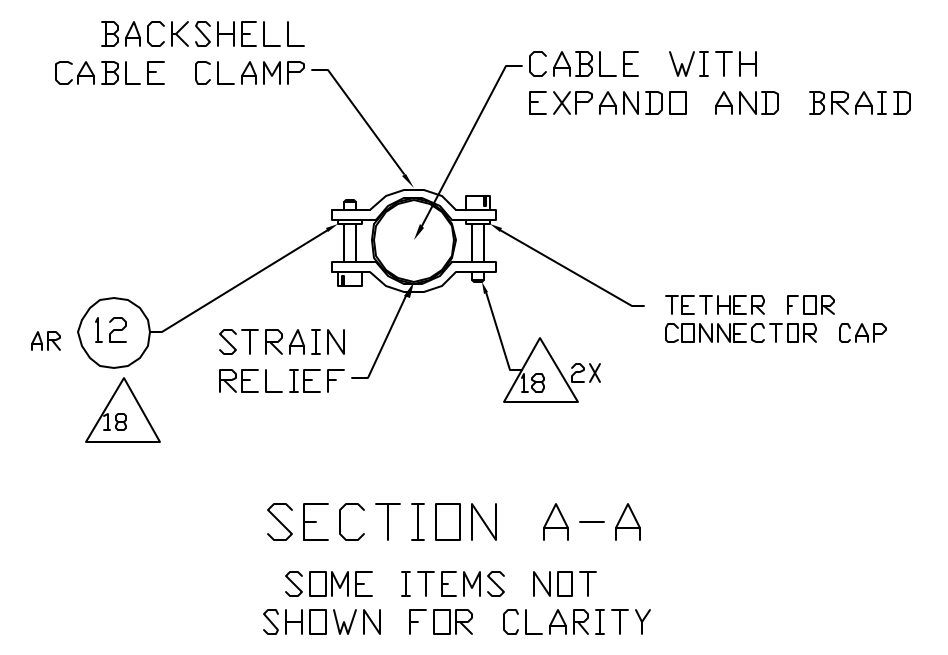


NOTES:

1. REFER TO MIT DRAWING 85-03020.45 FOR SCHEMATIC.
2. CLEAN ITEM 1AW MIT SPECIFICATION 85-xxxxxxx
3. WEIGH ASSEMBLY AFTER FINAL FABRICATION. RECORD IN AWD.
4. FABRICATE JAW NASA STD 8739.3 AND NASA STD 8739.4
- 5.
6. ADD SHRINK TUBING (ITEM 8) TO INCREASE CABLE DIAMETER FOR SNUG FIT INTO CABLE CLAMP.
7. APPLY F/N 13 TO BACK OF BACKSHELL F/N 2 IN TWO PLACES. TIGHTEN AS REQUIRED.
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 PROTURUSION OF SCREWS IS TWO THREADS AFTER FINAL TORQUE. CUT AND FILE IS ACCEPTABLE. APPLY F/N 22 OVER EXPOSED THREADS.
11. TYPE LABEL IDENTIFICATION PER TABLE A IN .12 HIGH CHARACTERS USING BRADY MARKER XC PC PLUS PRINTER ROLL FILM (ITEM 10) FOR CABLE MARKING. AT THE DESIRED LOCATION, WRAP 2-3 TIMES WITH GLASS CLOTH TAPE (ITEM 15). PLACE ROLL FILM (ITEM 10) ON GLASS CLOTH TAPE (ITEM 15) WITH MARKING SHOWING & WRAP TWICE WITH TEFLON TAPE (ITEM 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. DISCARD HARDWARE SUPPLIED WITH F/N 2 AND SUBSTITUTE F/N 12 AND 20. HAND TIGHTEN AND SPOTBOND PER NOTE 10.
14. REMOVE TOP HALF OF F/N 7. AFTER COMPLETION OF WIREING AND INSPECTIONS REINSTALL. TORQUE SUPPLIED HARDWARE TO ___ IN OZ. SPOTBOND HARDWARE USING F/N 22.
15. APPLY IMS LABEL (ITEM 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 ITEM 6. TRIM OFF EXCESS. TORQUE F/N 21 TO 54 IN OZ.
- 16.
17. MARK MAIN KEY ON BACKSHELL F/N 2 USING F/N 25.
18. ADD F/N 12 AS REQUIRED TO BALANCE THE PRESSURE ON BACKSHELL CABLE CLAMP SCREWS
19. LOCATE APPROXIMATELY AT MIDPOINT OF CABLE.
20. LOCATE F/N 3 NEAR F/N 7 AND AT THE MIDPOINT OF CABLE, TO THE LEFT OF LABEL 'A'.

TABLE A

REF	TEXT	QTY
A	VOILA JOYSTICK ASSY P/N 85-40600 S/N YXX 9	1
B	P201 To VOILA Chestpack JOYSTICK J201 11	1



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	
	DRAWN	M. SMITH	12/03/01	JOYSTICK ASSEMBLY
	CHECKED			
	APPROVED			
MATERIAL N/A	FINISH N/A	SIZE D	FROM NO. 80230	DWG NO. 85-40600
		SCALE 1:1		REV A
				SHEET 1 OF 1