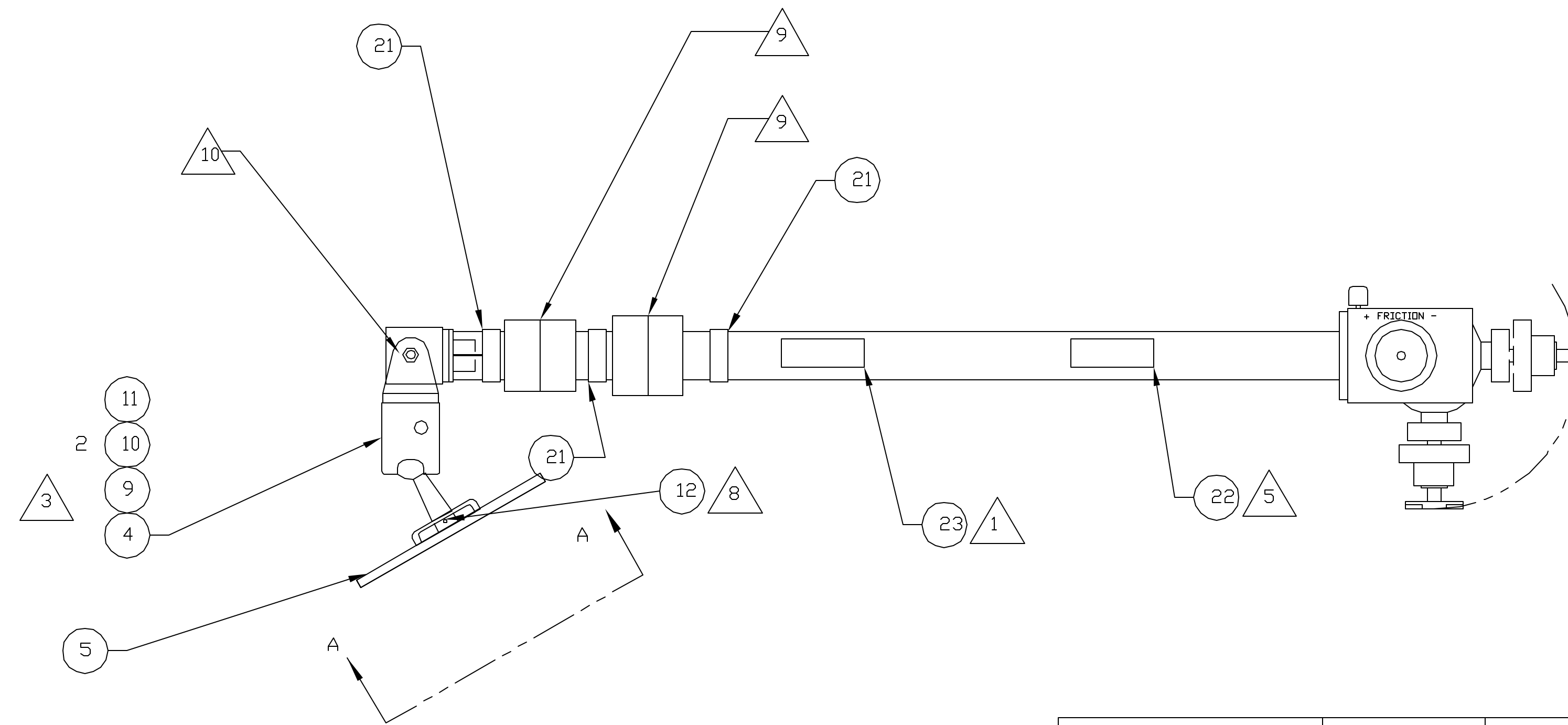
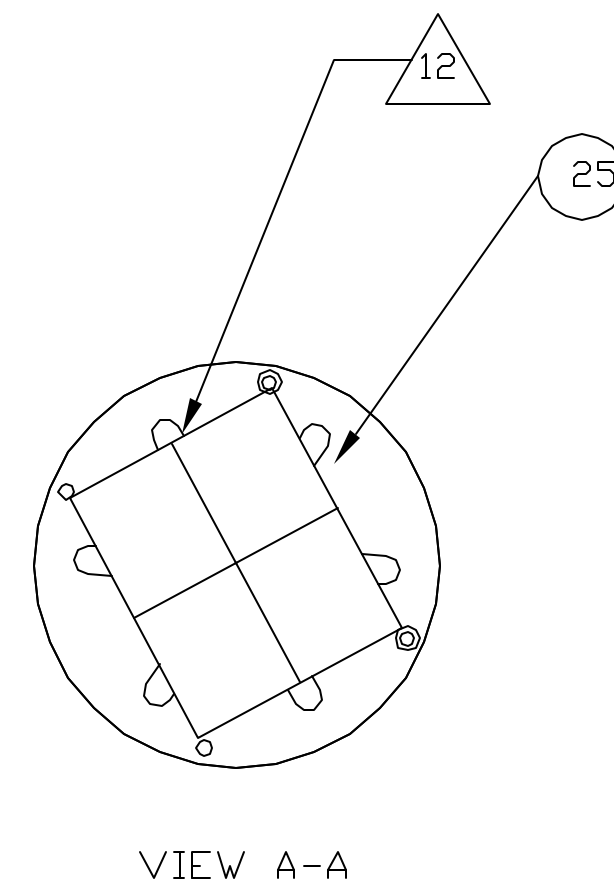
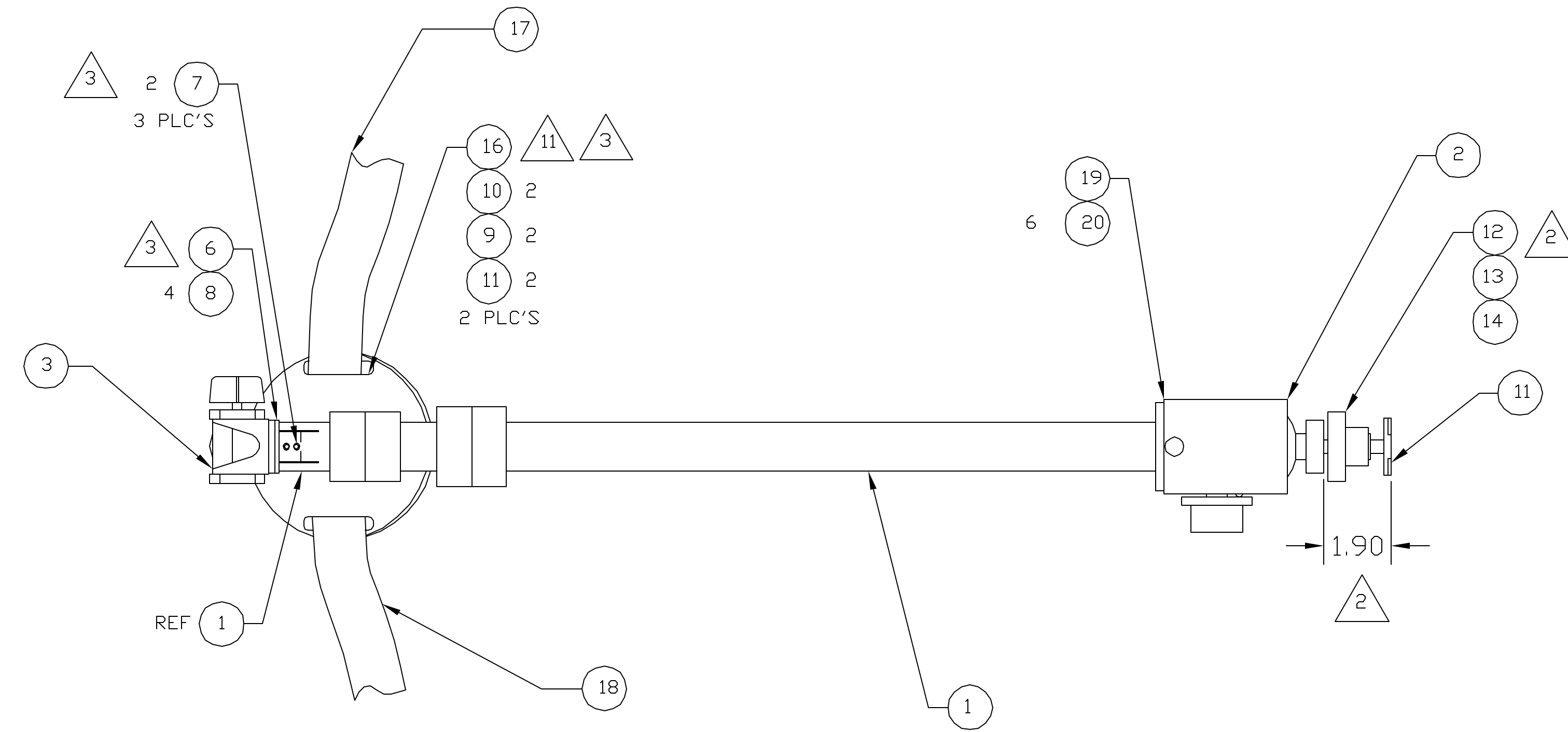


REVISIONS				
ECO	REV	DESCRIPTION	CHECKED	APPROVED
85-124	01	INITIAL RELEASE		M. SMITH
85-141	A	RELEASE		

- 12 INSTALL 2" X 2" VELCRO LOCK, F/N 25, OPTIONAL.
 - 11 INSTALL F/N 17 AND 18 PRIOR TO INSTALLING F/N 16 INTO F/N 5.
 - 10 SPOTBOND HEX HEAD BOLD USING F/N 15.
 - 9 ADJUST TENSION IN SPRING LOADED SCREWS TO A FORCE OF 10-15 LBS TO RELEASE LATCHES.
 - 8 APPLY VIBRATITE, F/N 13 TO THREADS ON BALL STEM OF F/N 4. HAND TIGHTED DRILL AND PIN F/N 5 AND 4 WITH F/N 12. FILE ENDS OF F/N 12 FLUSH TO F/N 5.
 - 5 APPLY IMS LABEL F/N 22 APPROXIMATELY WHERE SHOWN TO COVER UP LABELING ON THE POLE.
 - 4. CLEANLINESS REQUIREMENTS PER JSC SCN-0005 VC.
 - 3 TORQUE SCREWS PER THE FOLLOWING CHART;
 - #4-40 TO 5 IN-LBS.
 - #6-32 TO 7 IN-LBS
 - #8-32 TO 10 IN-LBS.
 - 2 INSTALL F/N 12 ONTO F/N 11. SCREW TO BOTTOM. DO NOT TIGHTEN. INSTALL JAM NUT F/N 14 ONTO F/N 11. APPLY VIBRATITE F/N 13 ONTO TOP FEW THREADS OF F/N 11. INSTALL F/N 11 INTO F/N 2 TO HEIGHT SHOWN. TORQUE JAM NUT, F/N 14, TO yyyy IN-LBS.
 - 1. MARK WITH MIT PART NUMBER, DRAWING NAME AND SERIAL NUMBER. SERIALIZE TRAINING UNITS STARTING WITH 100 AND FLIGHT UNITS STARTING WITH 300. MARK USING INK F/N 24 OR BRADY LABEL F/N 23.
- NOTES:



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-	VOILA	DRAWN	M. SMITH	DATE	POLE ASSEMBLY
NEXT ASSEMBLY	USED ON	CHECKED			
MATERIAL N/A		APPROVED			SIZE D
FINISH N/A		RELEASED			
APPLICATION		CAD FILE			FSCM NO. 80230
					DWG NO. 85-40700
					SCALE 1:1
					SHEET 1 OF 1