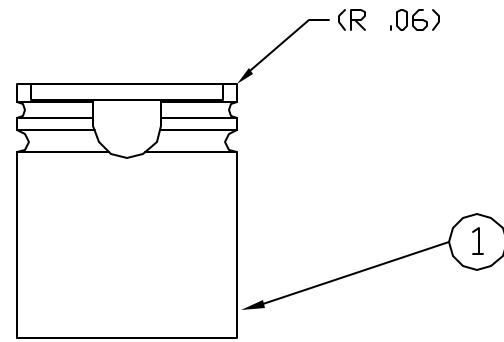
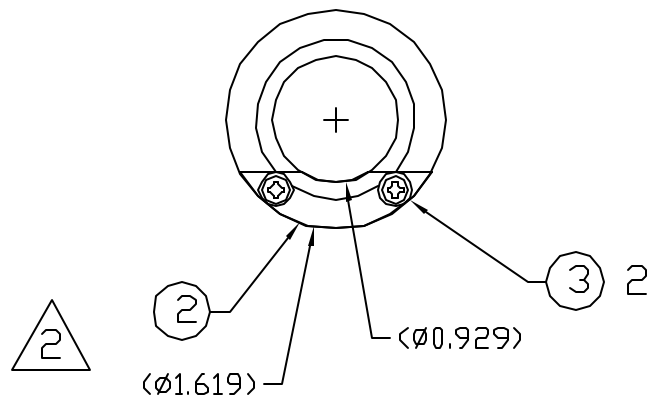


REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-123	A	INITIAL RELEASE			



NOTES:

- ALL DIMENSIONS ARE IN INCHES.
- INSTALL F/N 2 ONTO F/N 1 USING F/N 3. TORQUE TO 7 INCH-LBS.
MACHINE SO THAT F/N 2 MATCHES THE INSIDE DIAMETER Ø.929 OF F/N 1 AND AT SAME INSIDE CONTOUR ANGLE AS F/N 1.
MACHINE OUTER DIAMETER AND RADIUS TO MATCH F/N 1.
AFTER MACHINING DISASSEMBLE AND PASSIVATE F/N 2 PER QQ-P-35.
- AFTER MACHINING AND PASSIVATION PER NOTE 2, REASSEMBLE AND TORQUE F/N 3 TO 7 INCH-LBS.
- CLEANLINESS REQUIREMENTS PER SN-C-005, LEVEL VC.
- BAG AND TAG WITH MIT PART NUMBER, REV AND SERIAL NUMBER.
SERIALIZE TRAINING UNITS STARTING WITH 100 AND FLIGHT UNITS STARTING WITH 300.

		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	HOUSING, MODIFIED, MACHINE AND ASSEMBLY DRAWING			
		MATERIAL	CHECKED	APPROVED				
85-40704	voila	NOTE 3 FINISH	RELEASED		B	80230	85-40704.01	A
NEXT ASSEMBLY	USED ON		CAD FILE	SCALE	1:1	SHEET		1 OF 1