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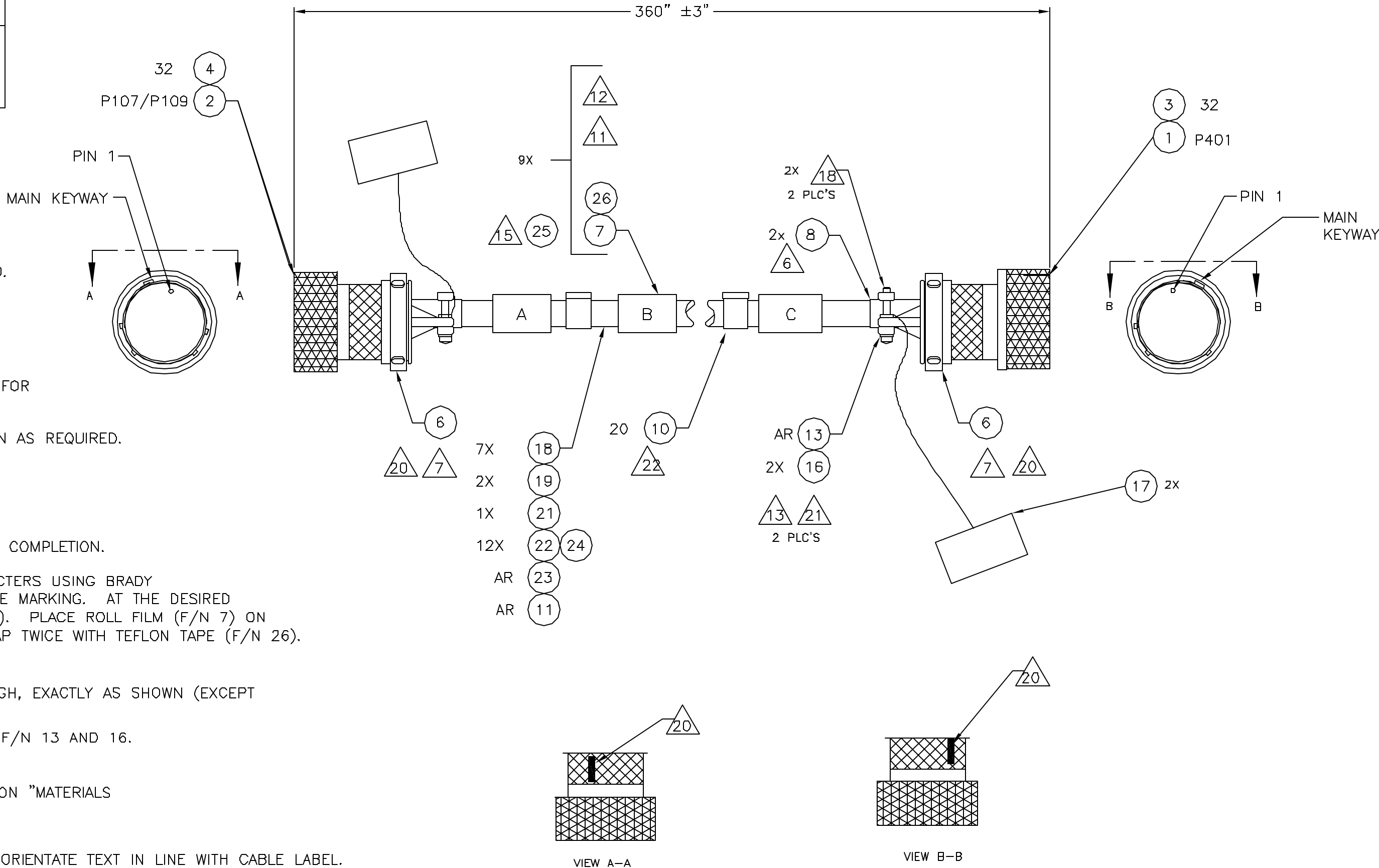
TABLE A

REF	TEXT	QTY
A	P107/P109 To VOILA EE TRACKER BAR J107/J109	1
B	VOILA Tracker Bar Cable P/N 85-40803 S/N YXX 19 17	5
C	P401 To VOILA Tracker Bar TRACKER J401	1

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-61	01	TRAINING UNIT RELEASE			
85-78	A	RELEASE FOR BUILD	R. GOEKE	R. FOSTER	4/28/04
85-175	B	CHANGE LENGTH TO 360"			

NOTES:

1. REFER TO MIT DRAWING 85-03020.03 FOR SCHEMATIC.
2. NOT USED
3. WEIGH ASSEMBLY AFTER FINAL FABRICATION. RECORD IN AWD.
4. FABRICATE IAW NASA STD 8739.4
5. NOT USED
- 6 ADD SHRINK TUBING (F/N 8) TO INCREASE CABLE DIAMETER FOR SNUG FIT INTO CABLE CLAMP.
- 7 APPLY F/N 14 TO THREADS OF BACKSHELL, F/N 6. TIGHTEN AS REQUIRED.
8. DO NOT INSTALL CONTACTS IN UNUSED POSITIONS.
9. PERFORM CONTACT RETENTION TEST ON ALL CONTACTS AFTER INSTALLATION.
10. PERFORM CONTINUITY AND DISCONTINUITY TESTS AFTER CABLE COMPLETION.
- 11 TYPE LABEL IDENTIFICATION PER TABLE A IN .12 HIGH CHARACTERS USING BRADY MARKER XC PC PLUS PRINTER ROLL FILM (F/N 7) FOR CABLE MARKING. AT THE DESIRED LOCATION, WRAP 2-3 TIMES WITH GLASS CLOTH TAPE (F/N 9). PLACE ROLL FILM (F/N 7) ON GLASS CLOTH TAPE (F/N 9) WITH MARKING SHOWING & WRAP TWICE WITH TEFLON TAPE (F/N 26). 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 6 AND SUBSTITUTE F/N 13 AND 16. HAND TIGHTEN AND SPOTBOND PER NOTE 18.
14. RECORD EPOXIES USED, MIX RATIOS AND EXPIRATION DATES ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF AWD.
- 15 APPLY IMS LABEL(F/N 25) RIGHT OF CABLE PART NUMBER LABEL WHEN THE LABEL NEAR THE MIDDLE OF THE CABLE. ORIENTATE TEXT IN LINE WITH CABLE LABEL. COVER WITH 2-3 TURNS OF CLEAR TAPE F/N 26. TRIM OFF EXCESS.
16. BAG AND TAG WITH MIT ASSEMBLY NUMBER AND LATEST REVISION.
- 17 APPLY LABEL B EVERY 2 METERS (5 PLACES) STARTING AT MIDPOINT OF CABLE.
- 18 MAX PROTRUSION OF SCREW IS TWO THREADS AFTER FINAL TORQUE. CUT AND FILE IS ACCEPTABLE. APPLY F/N 15 OVER EXPOSED THREADS.
- 19 SERIALIZE TRAINING UNIT STARTING WITH "10x" AND FLIGHT STARTING WITH "30x".
- 20 MARK ON CONNECTOR BACKSHELL THE ORIENTATION OF CONNECTOR MAIN KEYWAY USING MARKING INK (F/N 12).
- 21 INSTALL WASHER (F/N 13) AS REQUIRED TO BALANCE PRESSURE ON BACKSHELL CABLE CLAMP SCREWS.
- 22 INSTALL F/N 10 EVERY .5 METERS.
- 23 TERMINATE SHIELD ON F/N 18 USING F/N'S 22 AND 23. COVER WITH F/N 24.



4/28/04

		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			
		MATERIAL		DRAWN		M. SMITH		3/14/04		CABLE, TRACKER BAR (VOILA EE TO TRACKER BAR)	
85-40800		VOILA		CHECKED		R. GOEKE		4/27/04			
NEXT ASSEMBLY		USED ON		APPROVED		R. FOSTER		4/28/04			
APPLICATION		FINISH		RELEASED		D. GAGE		4/28/04			
				SIZE		FSCM NO.		DWG NO.		REV	
				C		80230		85-40803		B	
				SCALE		1:1		SHEET		1 OF 1	

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