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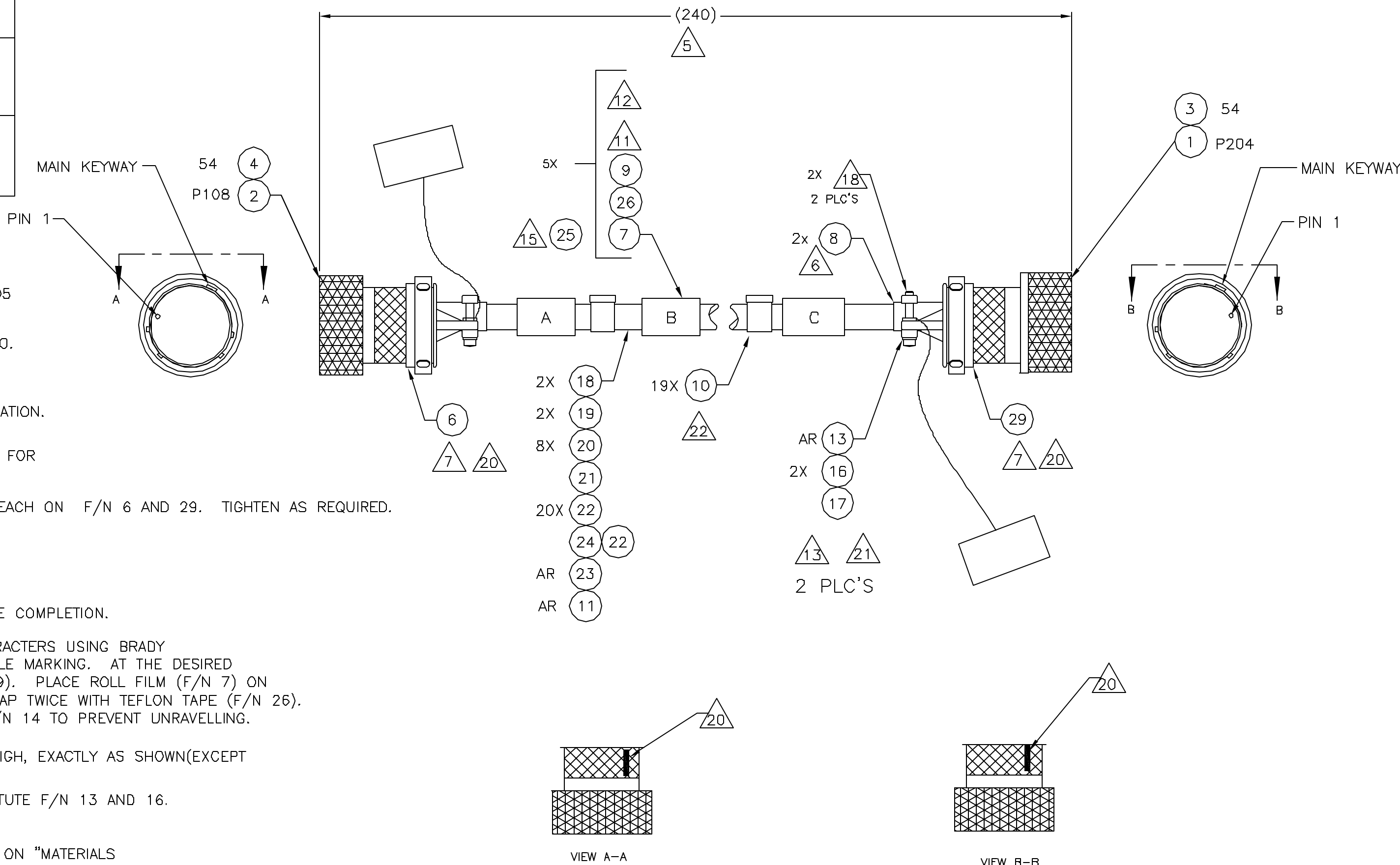
TABLE A

REF	TEXT	QTY
A	P104 To VOILA EE CHESTPACK J104	1
B	VOILA Chestpack Cable P/N 85-40806 S/N YXX 19 17	3
C	P204 To VOILA Chestpack CHESTPACK J204	1

REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-78	A	RELEASE			

NOTES:

1. REFER TO MIT DRAWING 85-03020.06 FOR SCHEMATIC. AND FOR REFERENCE ONLY SEE WIRE RUN LIST 85-40806.05
2. CLEAN F/N IAW MIT SPECIFICATION 85-xxxxxxx
3. WEIGH ASSEMBLY AFTER FINAL FABRICATION. RECORD IN AWO.
4. FABRICATE IAW NASA STD 8739.4
- 5 FINAL LENGTH TO BE DETERMINED AFTER ENGINEERING EVALUATION.
- 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 BACK SHELL AT 2 PLACES EACH ON F/N 6 AND 29. 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 .125 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. SEAL ENDS OF TAPE WITH F/N 14 TO PREVENT UNRAVELLING.
- 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 29. 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 AWO.
- 15 APPLY IMS LABEL(F/N 25) TO THE RIGHT OF PART NUMBER LABEL AT THE MIDPOINT OF CABLE. PLACE SO TEXT IS READING IN THE SAME DIRECTION AS 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 (3 PLACES) STARTING FROM THE CENTER AND WORKING TOWARDS THE CONNECTORS.
- 18 MAX ALLOWED 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 UNIT 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 SHEILD ON F/N 18 USING F/N22 AND F/N 23. COVER WITH F/N 24.
24. TERMINATE OVERALL BRAID SHEILD TO F/N 29 USING F/N 21, 23, AND 32. COVER CONNECTION WITH F/N 24.



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		4/12/04	CABLE, VOILA CHESTPACK (VOILA EE TO CHESTPACK)			
MATERIAL		N/A	SIZE C FSCM NO. 80230 DWG NO. 85-40806 REV A			
85-40800 VOILA		N/A	SCALE 1:1 SHEET 1 OF 1			
NEXT ASSEMBLY USED ON		APPLICATION		CAD FILE		