NOTES:

1. LEAK CHECK F/N 1 PRIOR TO ASSEMBLY. MAXIMUM HELIUM LEAK RATE 1 X 10^-7 STD CC/SEC AT 1 ATM PRESSURE DIFFERENTIAL.
2. SOLDER IN ACCORDANCE WITH NASA STD-8739.1. CONNECT J1 AND J2 MATING CONNECTORS WHILE SOLDERING (USING JACKING HARDWARE).
3. CRIMP IN ACCORDANCE WITH NASA STD-8739.4.
4. SCHEMATIC INTERCONNECTION IN ACCORDANCE WITH 30-05021.03.
5. HANDLE WIRING IN ACCORDANCE WITH 30-01303.
6. TORQUE F/N S 2.3 TO 2.5 IN LBS. SPOTWELD USING T/N 12.
7. VACUUM PRE-BAKE F/N'S 2.3 AT 80°C FOR 48 HOURS, PRIOR TO ASSEMBLY.
8. LEAK CHECK FINISHED ASSEMBLY. MAXIMUM HELIUM LEAK RATE 1 X 10^-7 STD CC/SEC AT 1 ATM PRESSURE DIFFERENTIAL.
9. VACUUM BAKE FINISHED ASSEMBLY(AFTER FINAL LEAK CHECK) AT 80°C FOR 48 HOURS.

SECTION A-A