TABLE A

<table>
<thead>
<tr>
<th>REF</th>
<th>TEXT</th>
<th>QTY</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>P104 To VOILA CHESTPACK J104</td>
<td>1</td>
</tr>
<tr>
<td>B</td>
<td>VOILA Chestpack Cable P/N 85-40806 S/N 3XX</td>
<td>3</td>
</tr>
<tr>
<td>C</td>
<td>P204 To VOILA Chestpack CHESTPACK J204</td>
<td>1</td>
</tr>
</tbody>
</table>

NOTES:

1. REFER TO MIT DRAWING 85-030200.00 FOR SCHEMATIC AND FOR REFERENCE ONLY SEE WIRE RUN LIST 85-40806.05
2. CLEAN F/N INS. MIT SPECIFICATION 85-xxxxxx
3. HI-REV ASSEMBLY AFTER FINAL FABRICATION. RECORD IN AMO.
4. FABRICATE W/ 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 20. TIGHTEN AS REQUIRED.
8. DO NOT INSTALL CONTACTS IN UNUSUAL 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 1/2" HIGH CHARACTERS USING BRAIDED MARKER. MARKING ROLL F/RM ROLL FILM (F/N 7) FOR CABLE MARKING. AT THE DESIRED LOCATION, WRAP 2-3 TIMES WITH GLASS CLOTH TAPE (F/N 8) WHERE ROLL FILM (F/N 7) ON GLASS CLOTH TAPE (F/N 8) WITH MARKING SHOWING & WRAP TWICE WITH TEFLON TAPE (F/N 26). TRIM OFF EXCESS MATERIALS. SEAL END OF TAPE WITH F/N 14 TO PREVENT UNRAVELLING.
12. MARK LABELS PER TABLE A. CHARACTERS TO BE 1/2" HIGH. EXACTLY AS SHOWN (EXCEPT SERIAL NUMBER TO BE AS NOTED)
14. RECORD EPOXY USED, MIX RATIOS AND EXPIRATION DATES ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF AMO.
15. APPLY (NS LABEL/P/N 2) 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. TAG AND TIE WITH MIT ASSEMBLY NUMBER AND DATE.
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. SEPARATE TRAILING UNIT STARTING WITH "1OW" AND FIELD UNIT STARTING WITH "30x".
20. MARK ON CONNECTOR BACKSIDE THE ORIENTATION OF CONNECTOR MAIN KEYWAY USING MARKING INK (F/N 13).
21. INSTALL WASHER (F/N 13) AS REQUIRED TO BALANCE PRESSURE ON BACKSIDE CABLE CLAMP SCREW.
22. INSTALL F/N 10 EVERY 3 METERS.
24. TERMINATE OVERALL BRAID SHEILD TO F/N 29 USING F/N 21. 29, AND 32. COVER WITH F/N 24.

Massachusetts Institute of Technology
Center for Space Research
VOILA PROJECT

CABLE: VOILA CHESTPACK (VOILA EE TO CHESTPACK)

UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE IN INCHES. ALL TOOLS TO BE 3 PLACE DECIMALS +/-. .005 2 PLACE DECIMALS +/-. .01

N/A

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