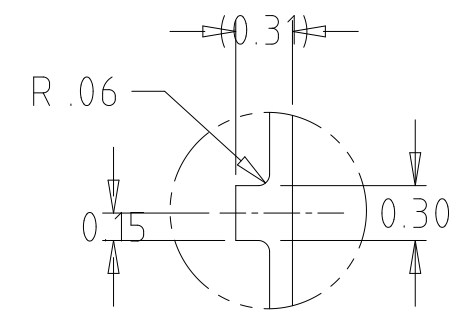
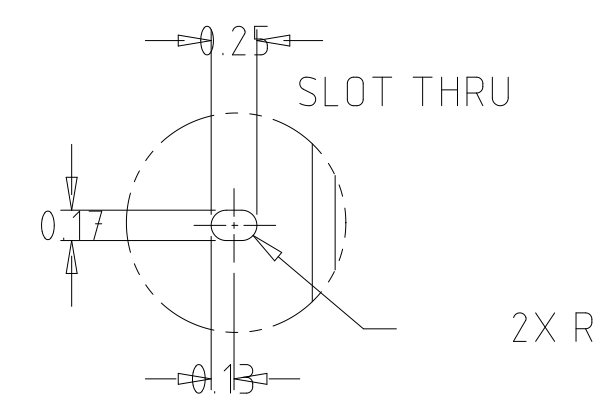


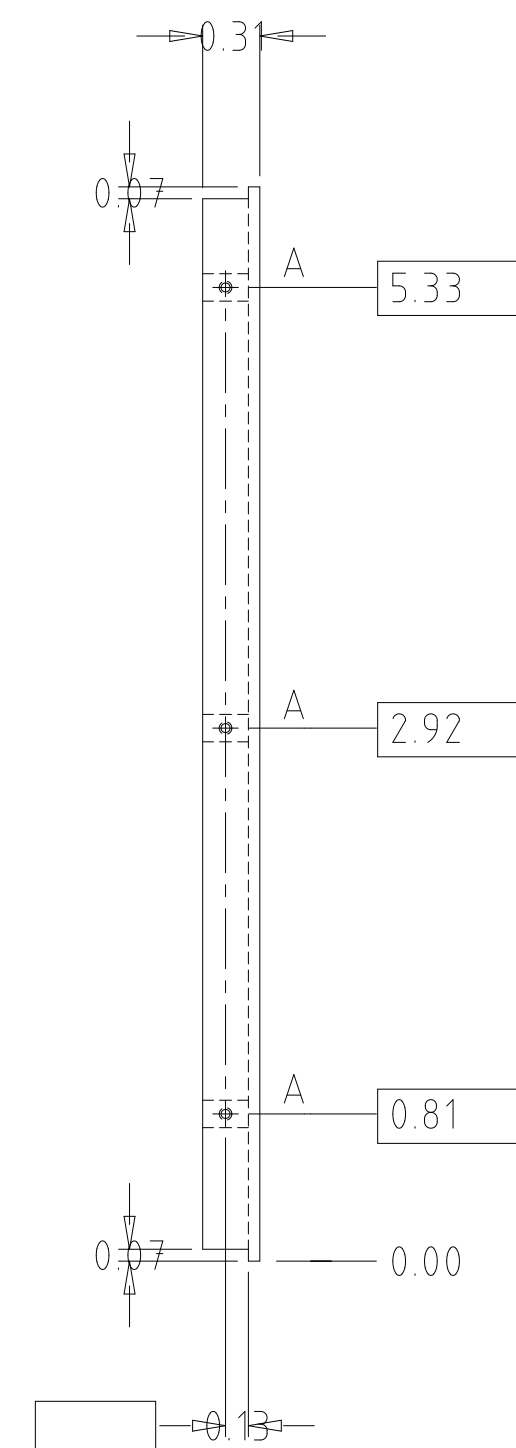
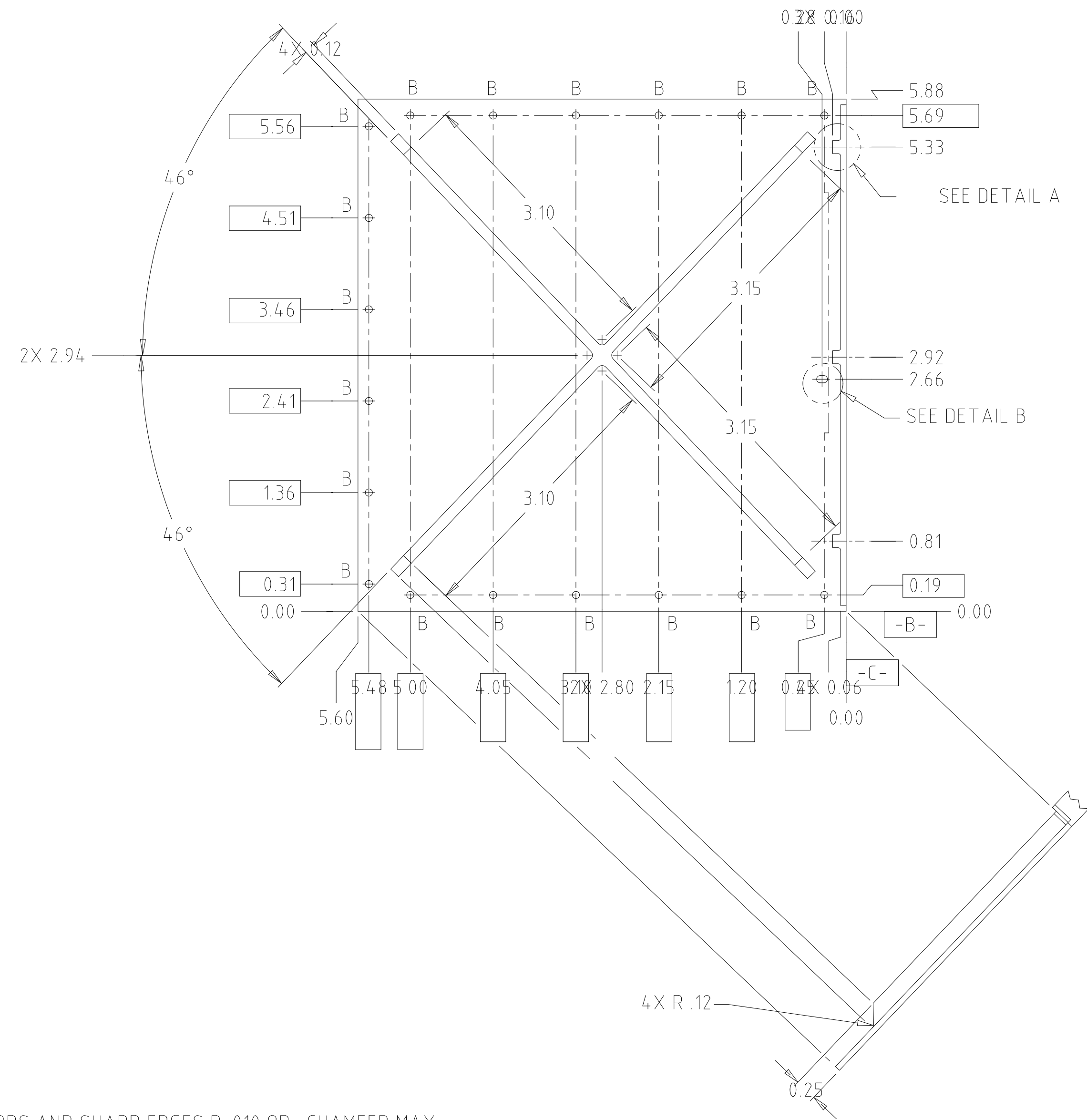
REVISIONS					
REV	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A	36-383	INITIAL RELEASE	FJK	RFG	3Nov95
B	36-456	MASK OUTSIDE OF PANEL			



DETAIL A
SCALE: FULL
TYPICAL 3 PLACES



DETAIL B
SCALE: FULL



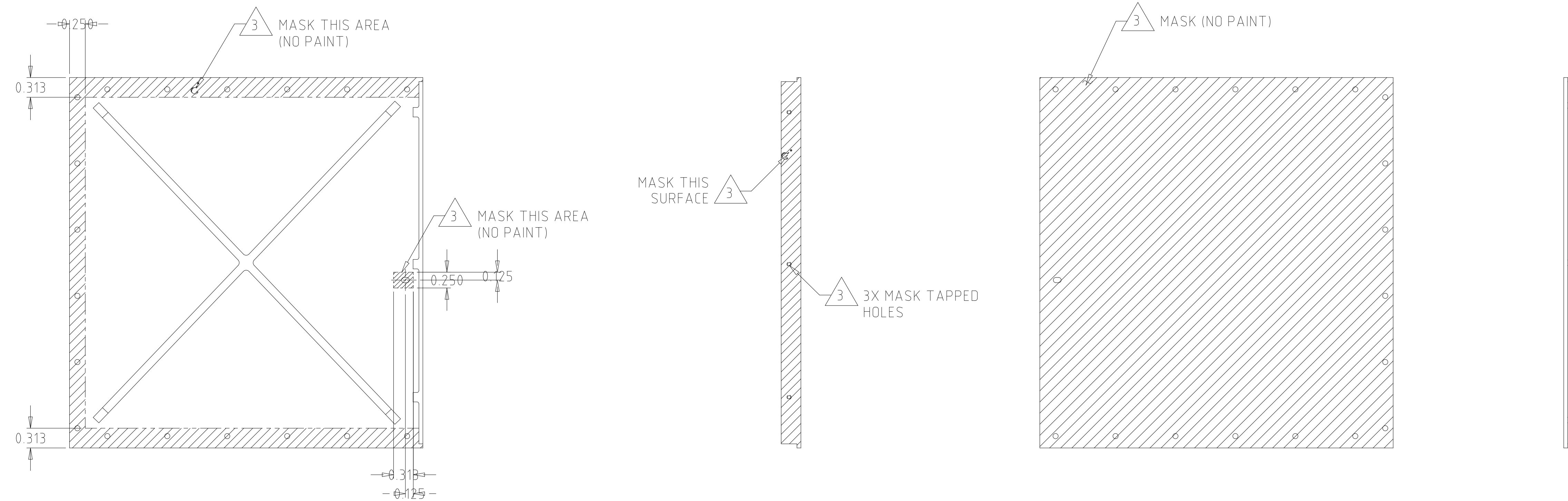
HOLE CHART		
HOLE	DESCRIPTION	QTY
A	$\phi.147^{+0.003}_{-0.002}$ THRU, $\phi.195 \pm 0.015 \times 120^\circ \pm 5^\circ$, TAP THRU FOR No. 6-32 UNC HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH. $\text{⊕ } \phi.010 \text{ (M) } \text{C} \text{ A} \text{ B}$	3
B	$\phi.166^{+0.003}_{-0.002}$ THRU $\text{⊕ } \phi.010 \text{ (M) } \text{A} \text{ B} \text{ C}$	18

- NOTES:
- REMOVE BURRS AND SHARP EDGES R .010 OR CHAMFER MAX.
 - UNLESS OTHERWISE SPECIFIED ALL RADII R .12.

3 FINISH: CHEMICAL CONVERSION COAT ALL OVER PER MIL-C-5541, CLASS 3. MASK PART PER SHEET 2 OF THIS DRAWING AND PAINT REMAINING SURFACES USING AEROGLAZE Z306, BLACK.

NAME		DATE		MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
DRAWN	M.LYONS		29May95	CENTER FOR SPACE RESEARCH CAMBRIDGE, MA 02139	
CHECKED	F.Kasparian		3Nov95	COVER, -X	
APPROVED	R.F.Goeke		3Nov95		
RELEASED	D.Gage		3Nov95		
MATERIAL		ALUMINUM 6061-T6		SIZE	D 80230
36-20200 ACIS		INTERPRET DIMENSIONS AND TOLERANCES IAW ANSI Y14.5M-1982		DWG NO.	36-20213
NEXT ASSEMBLY USED ON				SCALE	1/2
APPLICATION				WEIGHT	
				REV.	B
				SHEET	1 OF 2

REVISIONS					
REV	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
		SEE SHEET 1			



PAINT AND MASKING INFORMATION

SIZE	CAGE CODE	DWG NO.	REV.
D	80230	36-20213	B
SCALE	SHEET		2 OF 2
1/2			