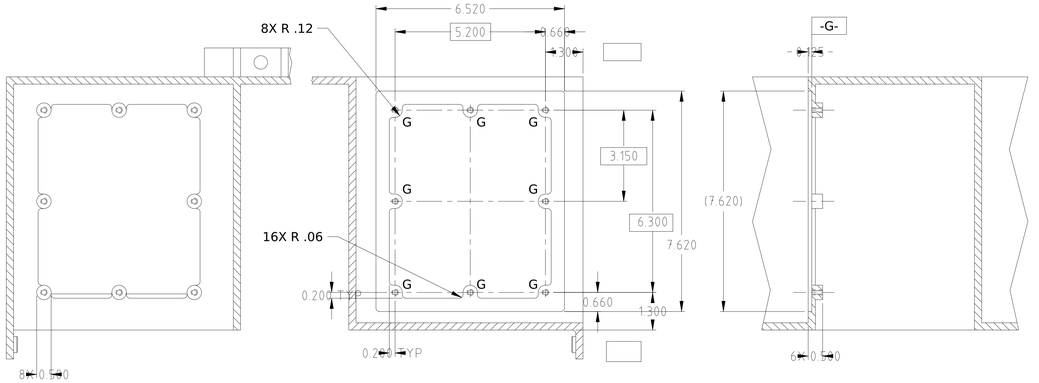
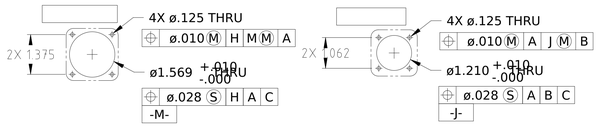
REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A	36-387	INITIAL RELEASE	FJK	RFG	02JAN96
B	36-469	ADDED STIFFENER HOLES ADDED DETAIL J	FJK	RFG	01MAR96
C	36-560	ADDED DETAIL K REVISED PAINT MASKING	FJK	RFG	13 MAY 96
D	36-685	UPDATE DETAIL K. REVISED SIDE PANEL MOUNTS.			



SECTION A–A
SCALE: FULL

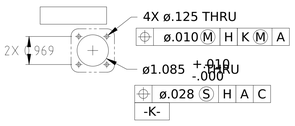
SECTION B–B
SCALE: FULL

SECTION C–C
SCALE: FULL

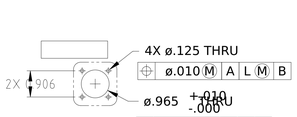


DETAIL D

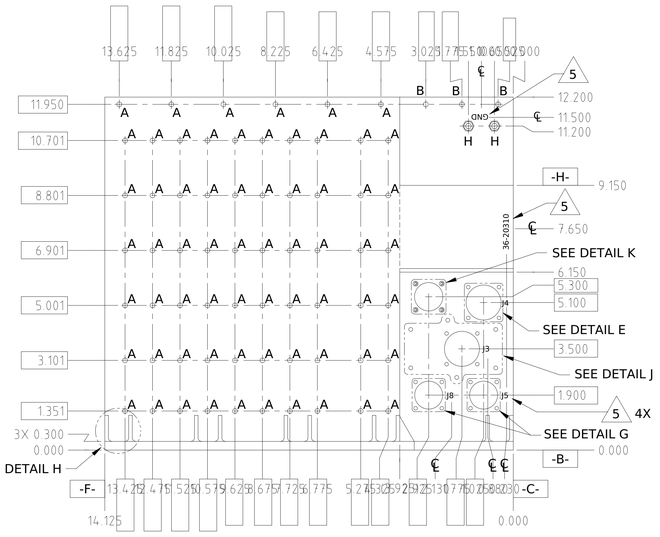
DETAIL E

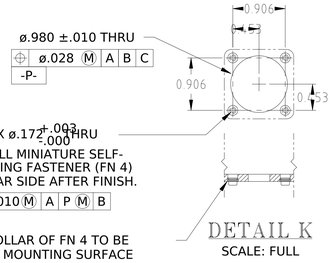


DETAIL F



DETAIL G





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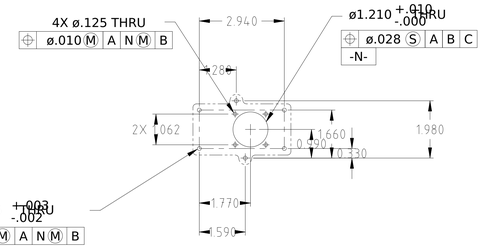
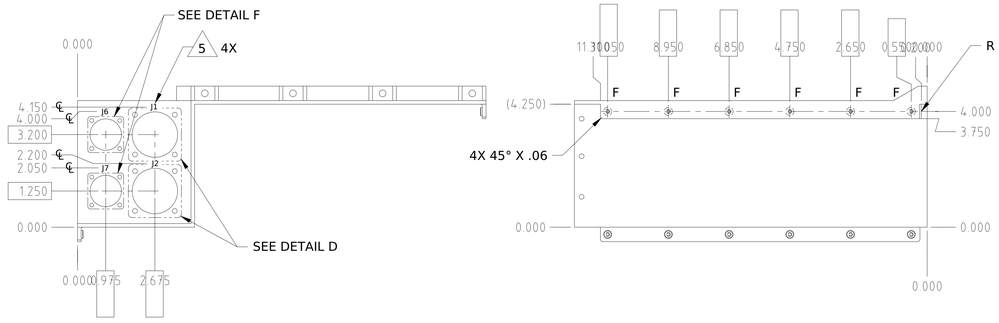
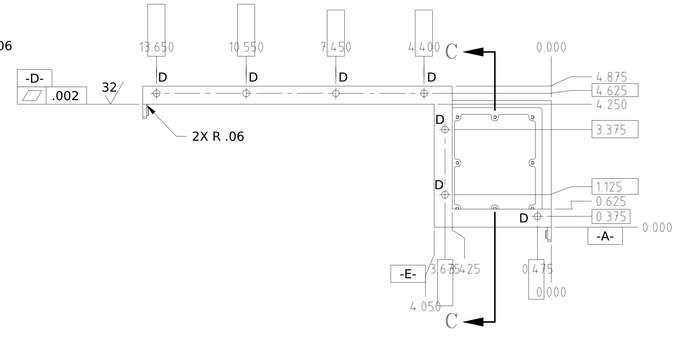
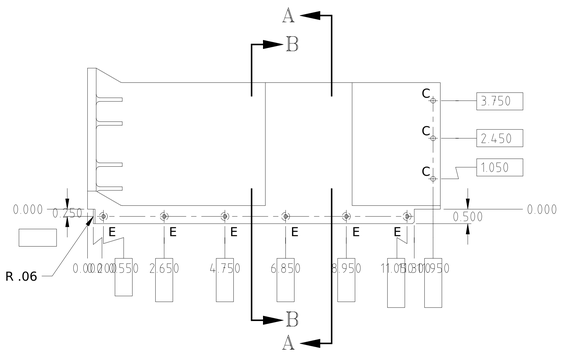
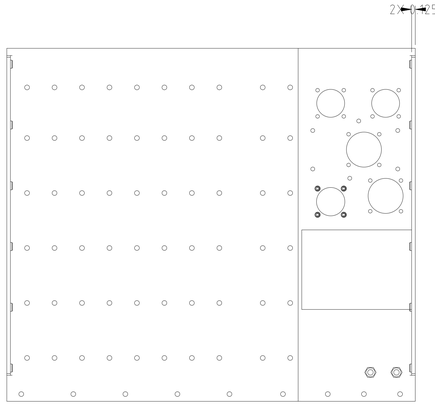


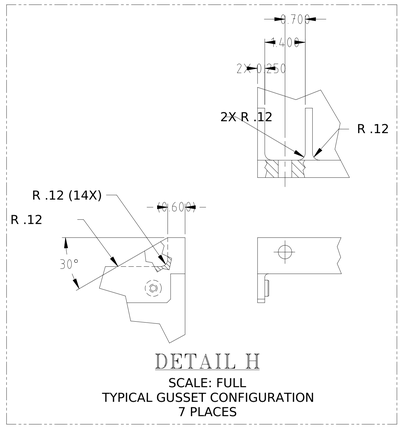
DETAIL J











DETAIL H
SCALE: FULL
TYPICAL GUSSET CONFIGURATION
7 PLACES

NOTES:

1. UNLESS OTHERWISE SPECIFIED ALL WALLS ARE .125 THICK.
2. REMOVE ALL BURRS AND SHARP EDGES R .010 MAX.
3. UNLESS OTHERWISE SPECIFIED ALL RADII R .12.
4. PART MAY BE FABRICATED FROM MULTIPLE PIECES. WELDING AND DIP BRAZING PERMISSIBLE. WELD AND GRIND FLUSH ALL WELDS. CONSTRUCTION METHOD MUST BE APPROVED BY MIT PRIOR TO MACHINING. DIP BRAZE IAW MIL-B-7883, TYPE V. HEAT TREAT IAW MIL-H-6088.
5. ENGRAVE USING .19 HIGH CHARACTERS LOCATED APPROXIMATELY AS SHOWN.
6. FINISH: CHEMICAL CONVERSION COAT ALL OVER PER MIL-C-5541, CLASS 3. MASK PART PER SHEET 3 OF THIS DRAWING. PRIME AND PAINT REMAINING SURFACES USING AEROGLAZE 9924 (PRIMER) AND AEROGLAZE Z306, BLACK (PAINT) IAW 36-02028.
7. HANDLE WITH CONTAMINATION FREE, POWDER FREE GLOVES DURING ALL POST-FINISH OPERATIONS.

HOLE CHART

HOLE	QTY	TOLERANCE	DESCRIPTION
A	66	ø.010 M D B C	ø.166 +.003 -.002 THRU
B	3	ø.010 M A B C	
C	3	ø.010 M E A B	
D	7	ø.010 M B A C	ø.234 +.003 -.002 THRU
E	6	ø.010 M C A B	ø.1875 +.0030 -.0000 THRU, INSTALL #6-32 UNC SELF-CLINCHING NUT (FN 2) FROM FAR SIDE. INSTALL NUT AFTER FINISH
F	6	ø.010 M F A B	
G	8	ø.010 M G A C	ø.120 +.003 -.002 THRU, ø.155 ±.015 X 120° ±5°, TAP THRU FOR #4-40 UNC HELICAL STI. INSTALL INSERT (FN 1) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
H	2	ø.010 M G A C	ø.312 +.003 -.000 THRU, INSTALL #10-32 SELF-CLINCHING FLUSH FASTENER (FN 3) FROM FAR SIDE. INSTALL INSERT AFTER FINISH.

36-20300	ACIS
NEXT ASSEMBLY	USED ON
APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCE: ANGLES ± 1°
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL ALUMINUM 6061-T6

INTERPRET DIMENSIONS AND TOLERANCES IAW ANSI Y14.5M-1982

WEIGHT

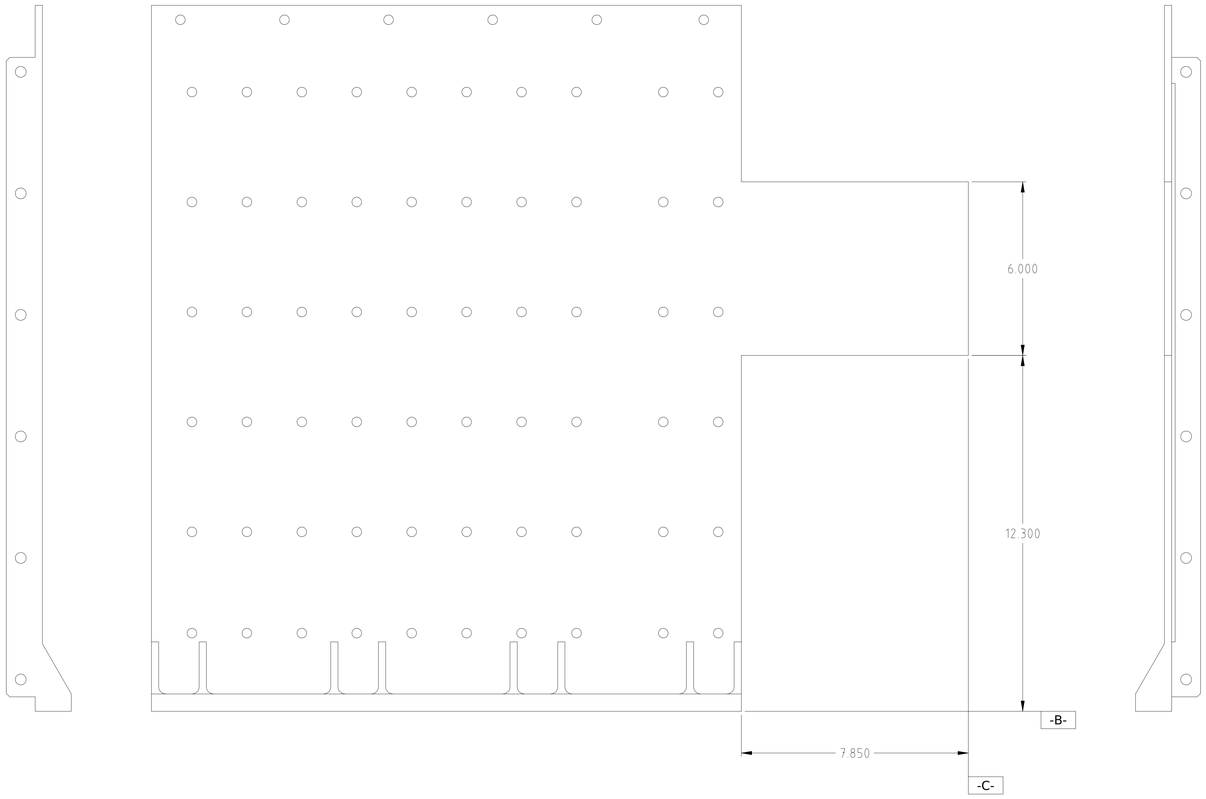
	NAME	DATE
DRAWN	M.LYONS	04APR95
CHECKED	F.Kasparian	2Jan96
APPROVED	R.F.Goeke	2Jan96
RELEASED	W.Mayer	2Jan96

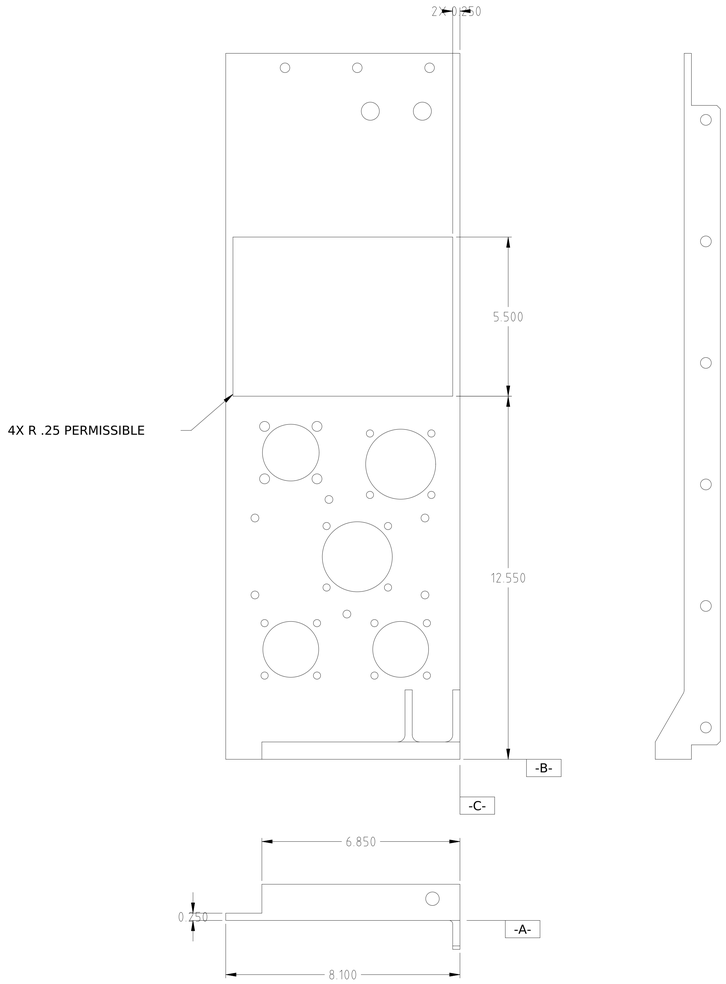
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
CENTER FOR SPACE RESEARCH
CAMBRIDGE, MA 02139

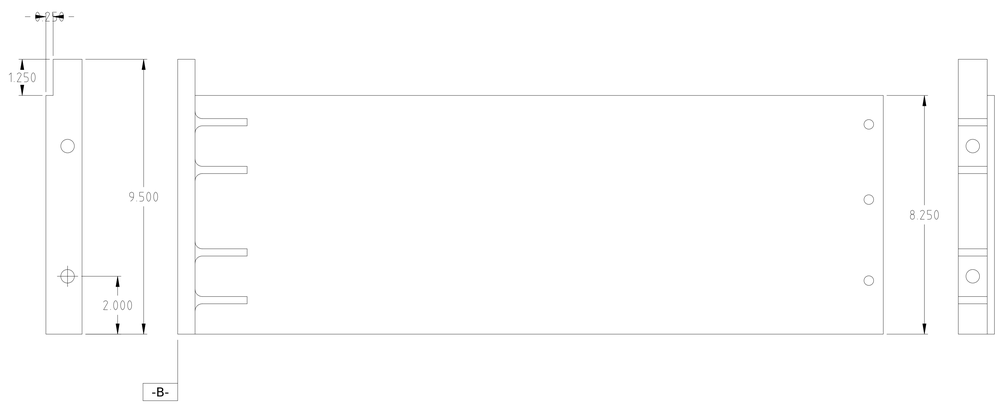
DPA PANEL, -Z

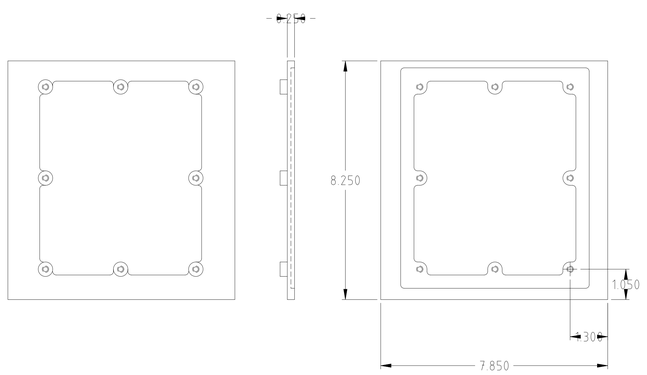
SIZE	CAGE CODE	DWG. NO.	REV.
E	80230	36-20310	D
SCALE 1/2		SHEET 1 OF 3	

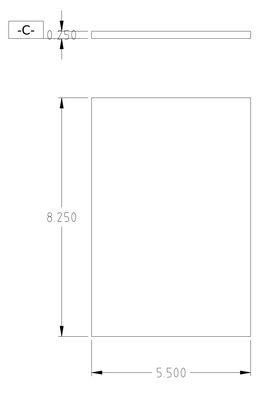
REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
		SEE SHEET 1			

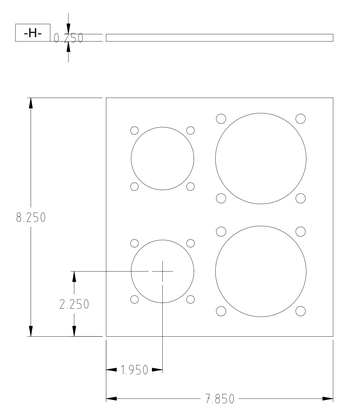










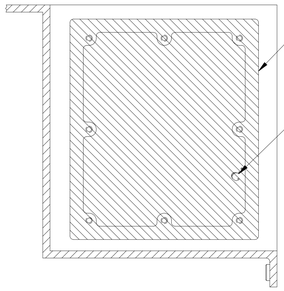


OPTIONAL METHOD OF CONSTRUCTION

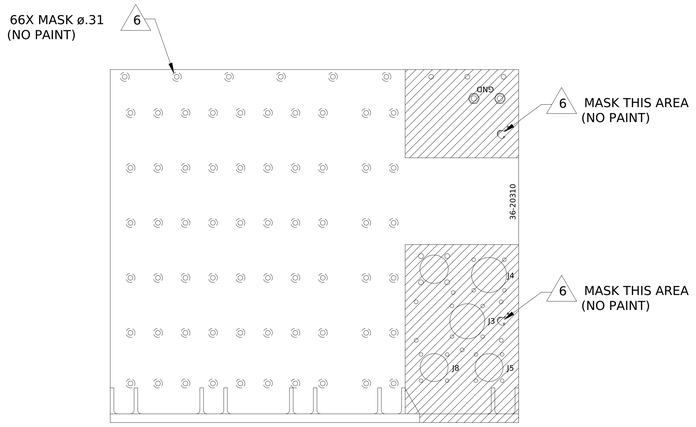
PARTIAL SECTIONS OF ASSEMBLY AND CORRESPONDING DIMENSIONS SHOWN ON THIS SHEET ARE ONE METHOD OF CONSTRUCTION. THIS CONFIGURATION IS OPTIONAL. CONSULT MIT CSR PRIOR TO SELECTING METHOD OF CONSTRUCTION AND MACHINING THIS PART.

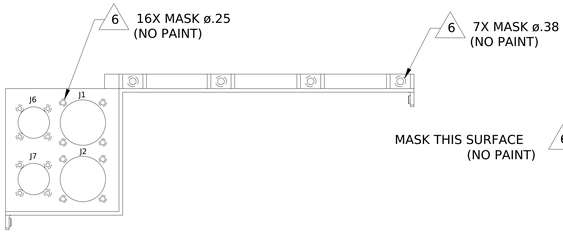
SIZE	CAGE CODE	DWG. NO.	REV.
E	80230	36-20310	D
SCALE 1/2		SHEET 2 OF 3	

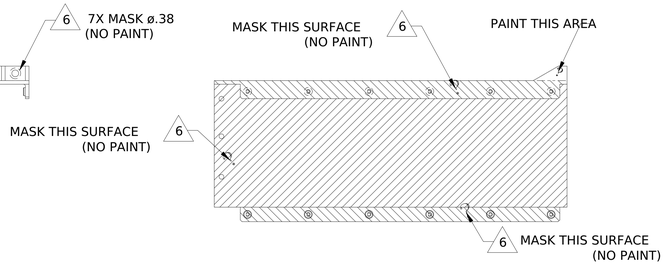
REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
		SEE SHEET 1			

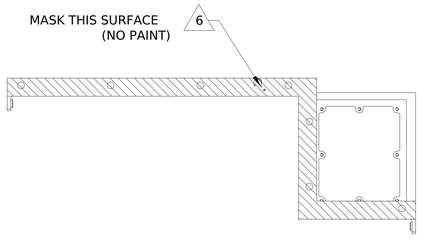


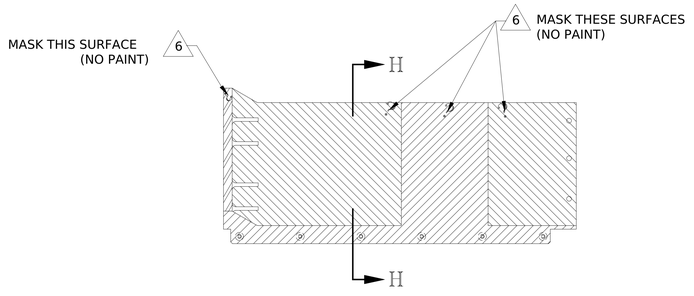
SECTION H–H
SCALE: FULL

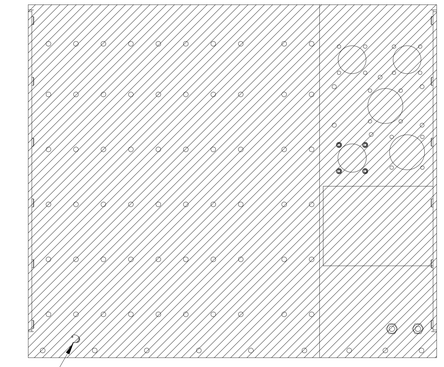












PAINT AND MASKING INFORMATION

SIZE	CAGE CODE	DWG. NO.	REV.
E	80230	36-20310	D
SCALE 1/2		SHEET 3 OF 3	