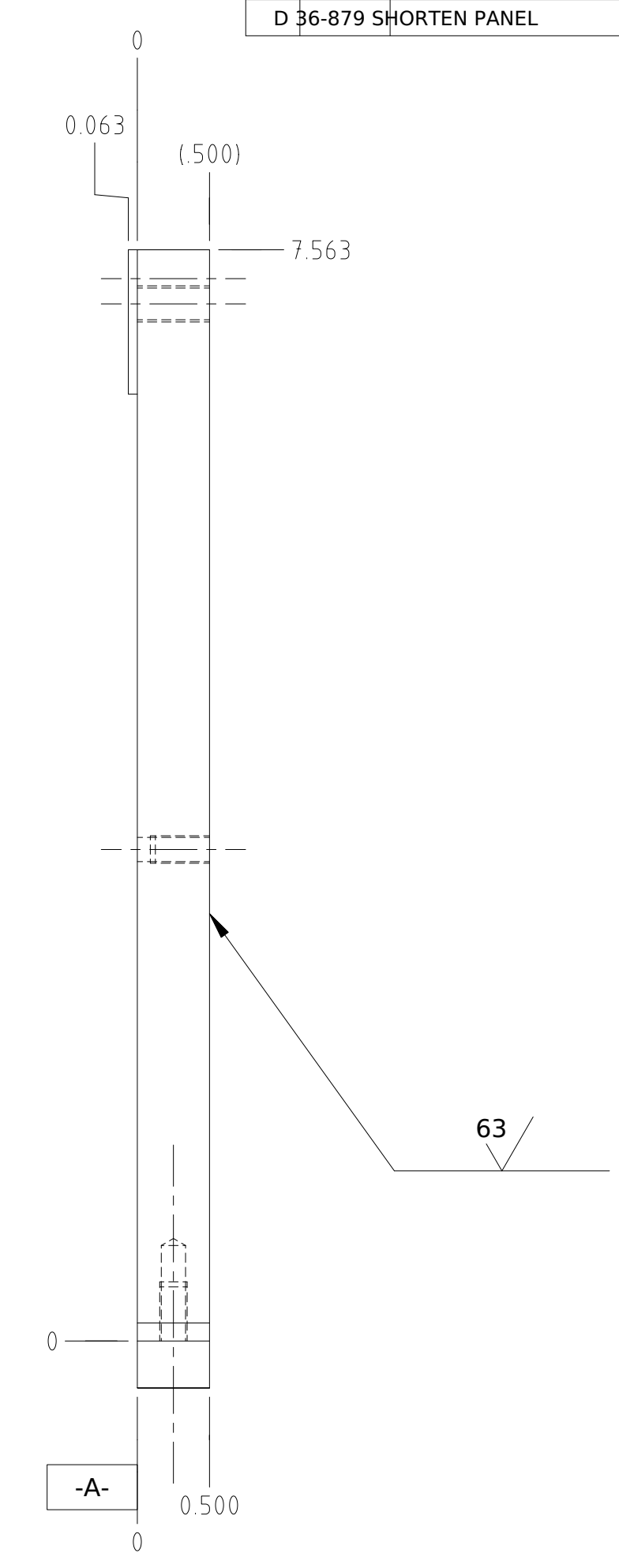
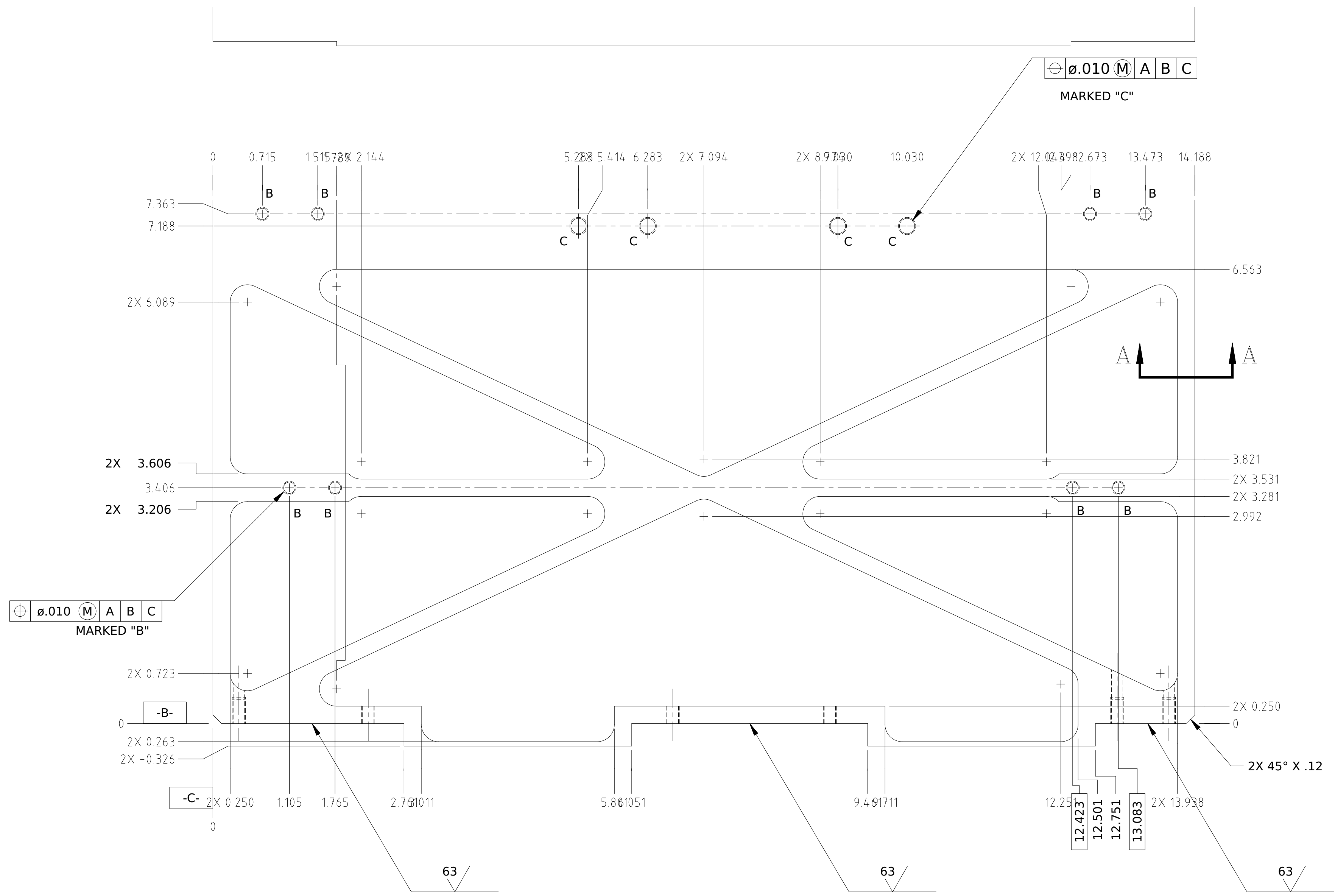


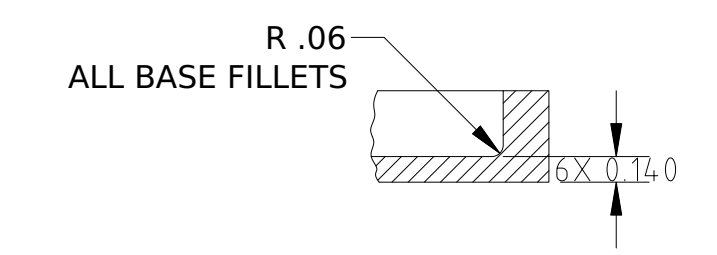
REVISIONS					
REV.	ECO NO.	DISCRIPTION	CHECKED	APPROVED	DATE
A	36-452	INITIAL RELEASE	PCT RFG		2/1/96
B	36-569	REVISED PER ECO 36-569	PCT	WFM	5/3/96
C	36-677	REVISED PER ECO 36-677	PCT RFG		7/11/96
D	36-879	SHORTEN PANEL			



⊕ 0.010 (M) A B C  
MARKED "B"

⊕ 0.010 (M) A B C  
MARKED "C"

⊕ 0.010 (M) B A C  
MARKED "A"



SECTION A-A  
SCALE: 1/1

HOLE CHART		
HOLE	DESCRIPTION	QTY
A	Ø.199-.204 X THRU, 120±5° X Ø.23-.26 HELICAL COIL TAP THRU, #10-32UNF-3B COUNTERSINK & INSTALL FN2 FROM NEARSIDE	3
B	Ø.199-.204 X THRU, 120±5° X Ø.23-.26 HELICAL COIL TAP THRU, #10-32UNF-3B COUNTERSINK & INSTALL FN2 FROM FAR SIDE	8
C	Ø.259-.264 THRU, 120±5° X Ø.29-.32 HELICAL COIL TAP THRU, #1/4-28UNF-3B COUNTERSINK & INSTALL FN3 FROM FAR SIDE	4
D	Ø.199-.204 X THRU, 120±5° X Ø.23-.26 HELICAL COIL TAP THRU, #10-32UNF-3B COUNTERSINK & INSTALL FN4 FROM NEARSIDE	3

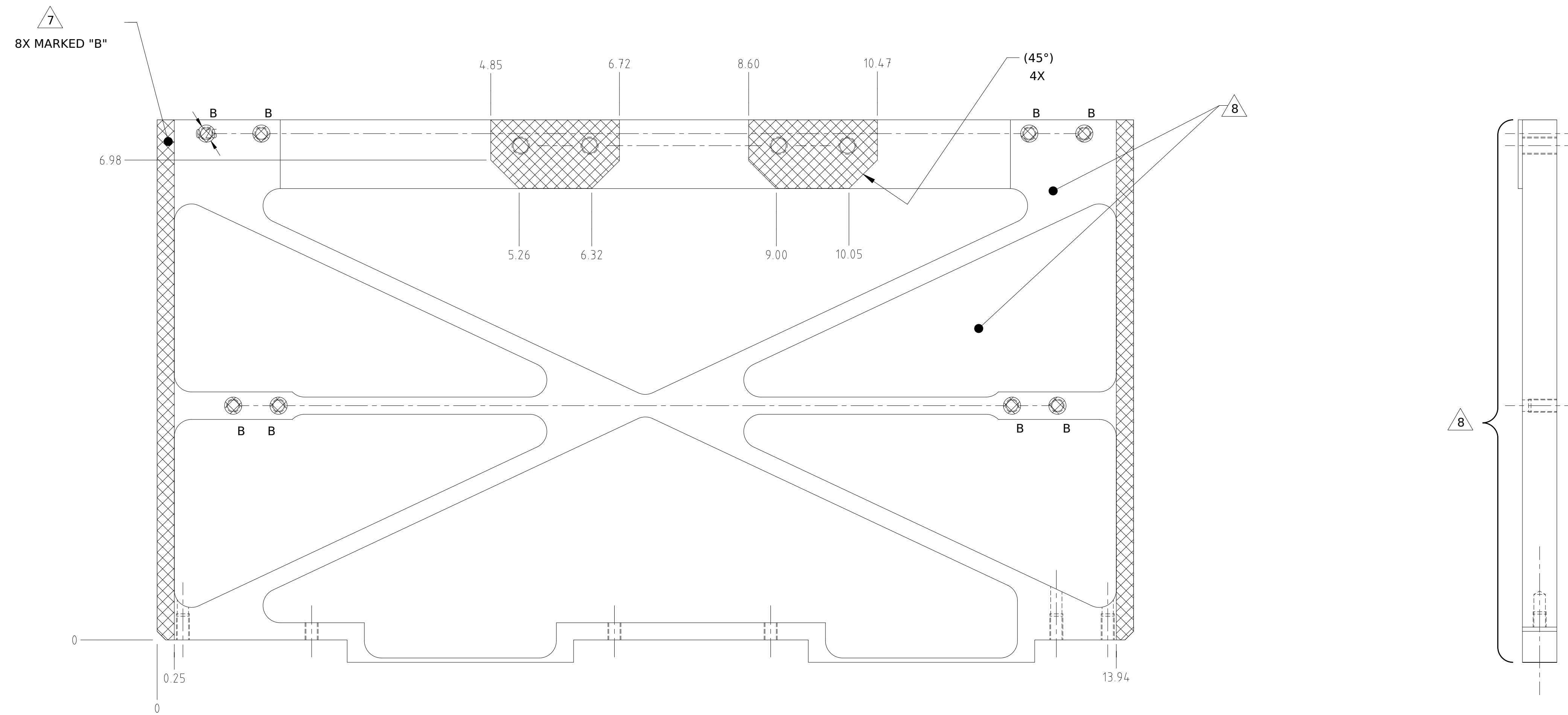
- NOTES:
- ALL FILLETS SHOWN TO BE R.25 UNLESS OTHERWISE SPECIFIED.
  - MACHINED SURFACES 125 MAX. EXCEPT AS NOTED.
  - DEBURR AND BREAK SHARP EDGES.
  - CONVERSION COAT PER MIL-C-5541, CLASS 3.
  - PRIOR TO INSTALLATION, CLEAN INSERTS PER 36-020027
  - AFTER FINISH, INSTALL INSERTS .75-1.50 PITCH BELOW THE SURFACE. REMOVE AND DISCARD THE TANG IF APPLICABLE.

- MASK HOLES AND MOUNTING SURFACE AS INDICATED. EDGES NOT DIMENSIONED ARE TO CONFORM TO PART OUTLINE.
- PREPARE INDICATED SURFACE WITH AEROGLAZE WASH PRIMER 9924. PAINT WITH AEROGLAZE Z306 BLACK PER 36-02028.
- HANDLE WITH POWDER FREE, CONTAMINATION FREE GLOVES DURING ALL POST PAINTING OPERATIONS.

36-30100	ACIS	MATERIAL	ALUMINUM 6061-T651
NEXT ASSEMBLY	USED ON	INTERPRET DIMENSIONS AND TOLERANCES	IAW ANSI Y14.5M-1982
APPLICATION			

NAME		DATE		MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
DRAWN J.COOK		4/25/95		CENTER FOR SPACE RESEARCH	
CHECKED P.C.TAPPAN		2/1/96		CAMBRIDGE, MA 02139	
APPROVED R.F.GOEKE		2/1/96		SUPPORT STRUCTURE +Z FLEXURE SECTION	
RELEASED D.GAGE		2/1/96			
SIZE	FSCM NO.	DWG. NO.	REV.		
D	80230	36-30104	D		
SCALE	1/1			SHEET 1 OF 2	

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



**MASKING DETAIL**

