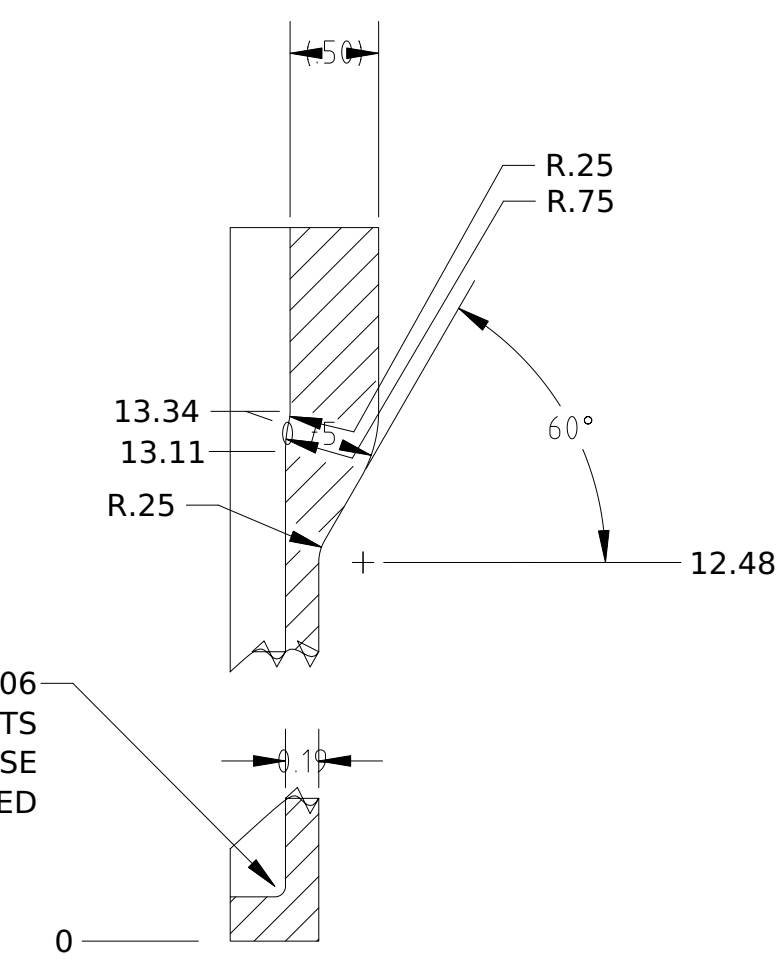
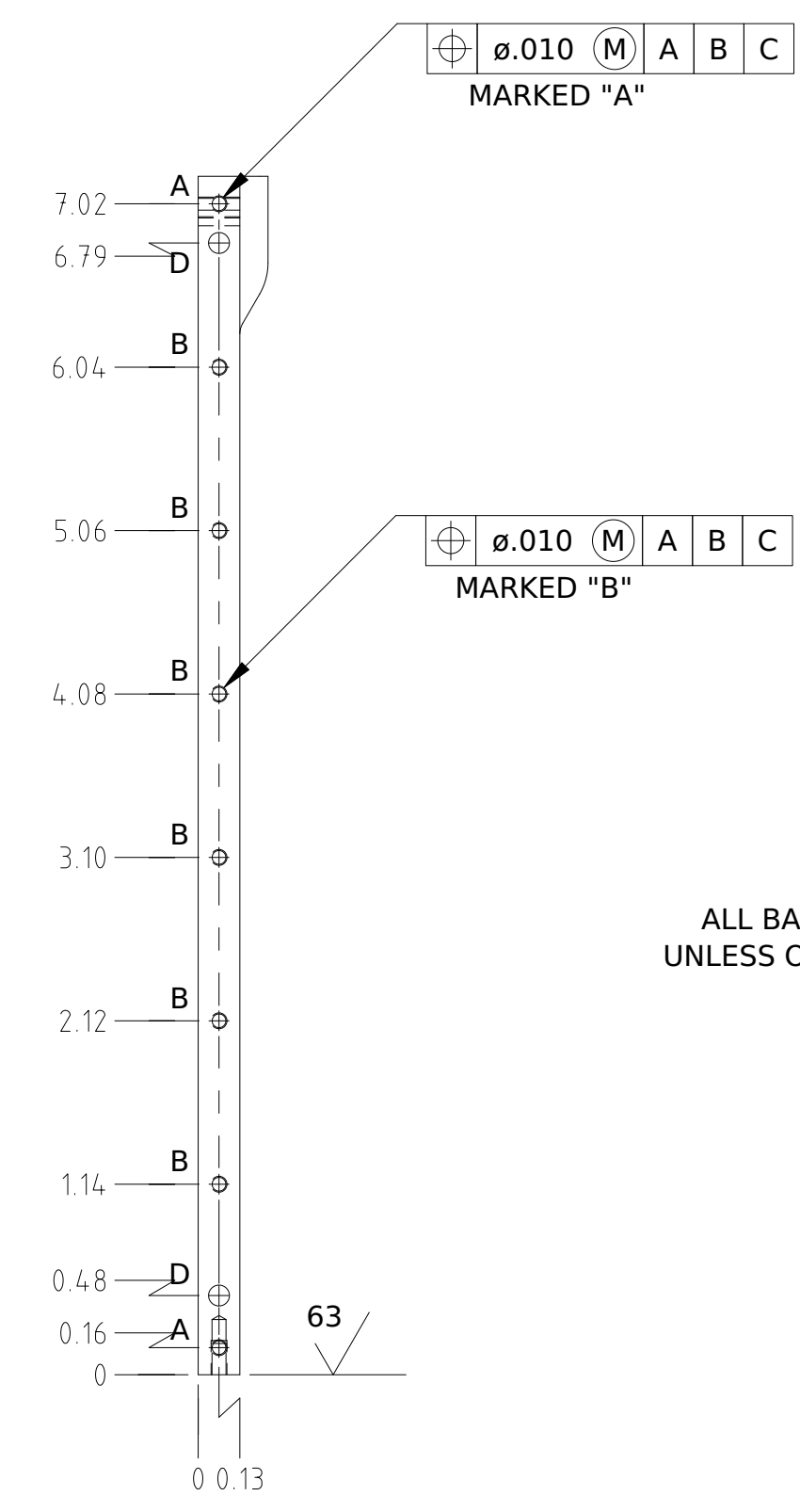
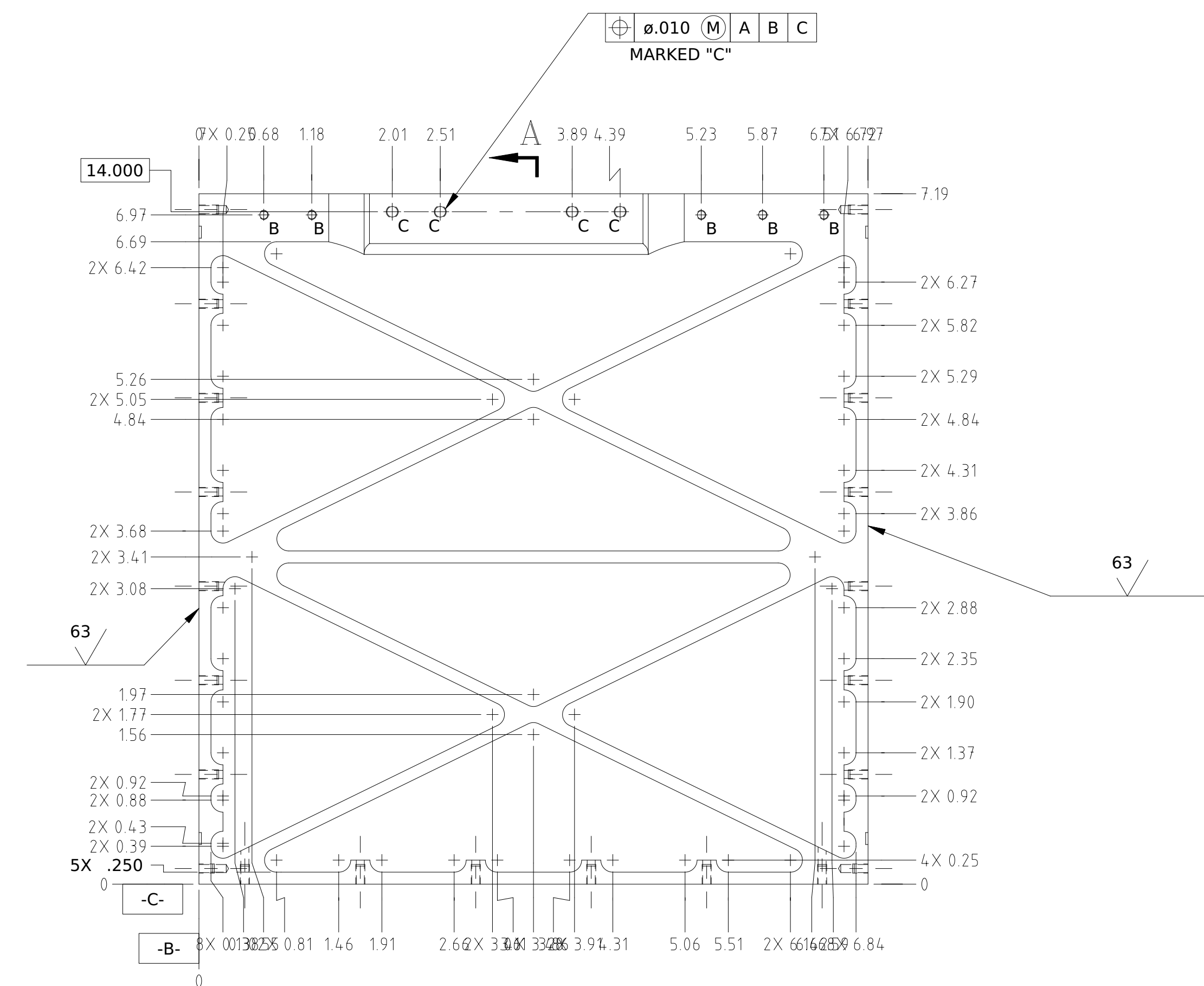
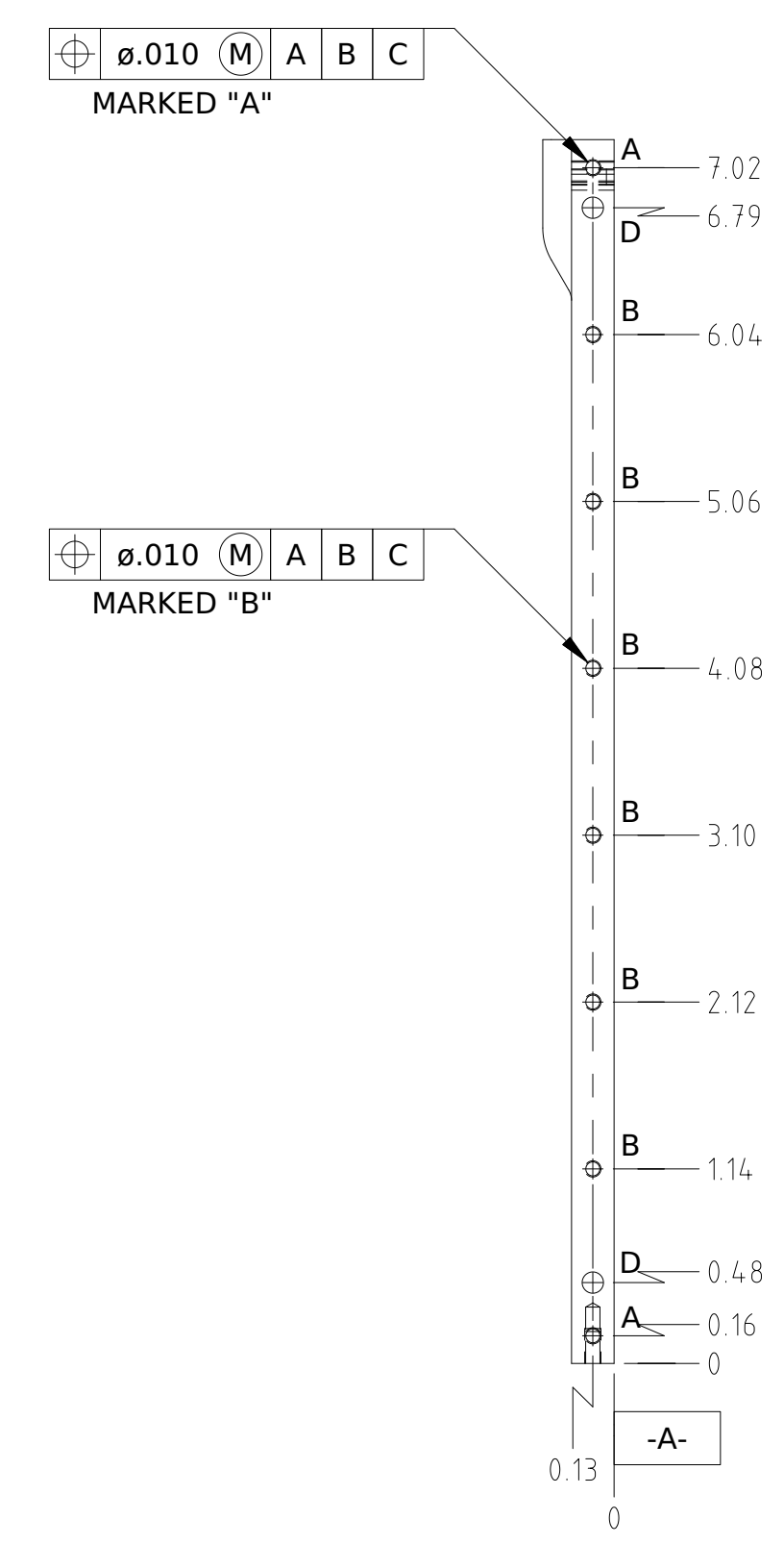
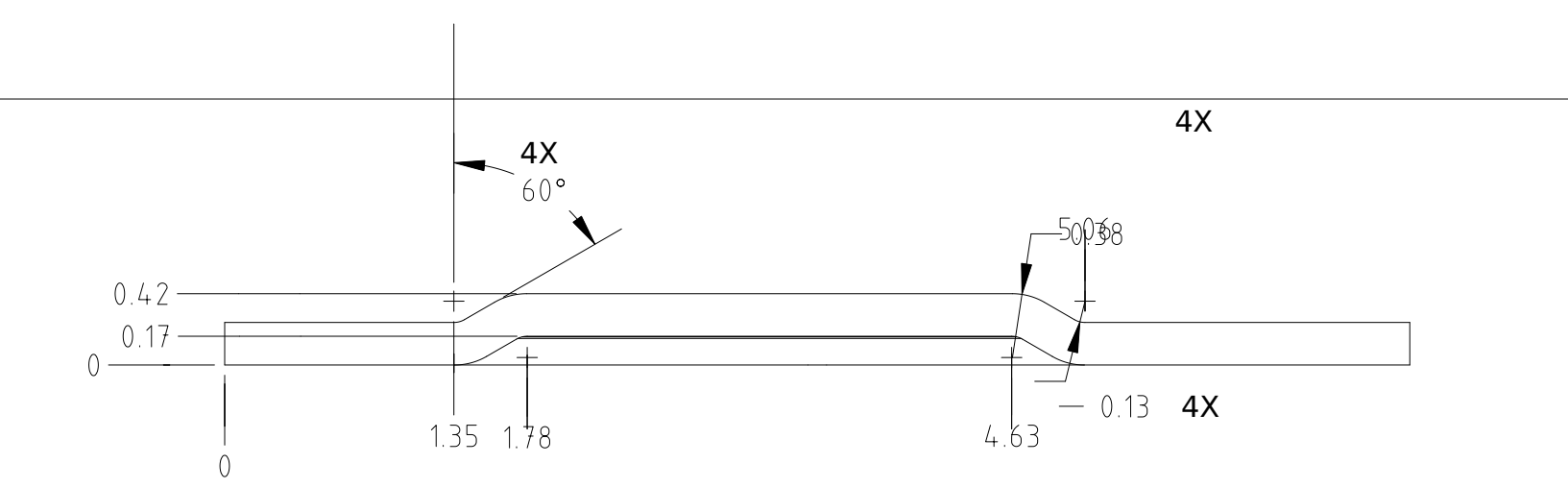
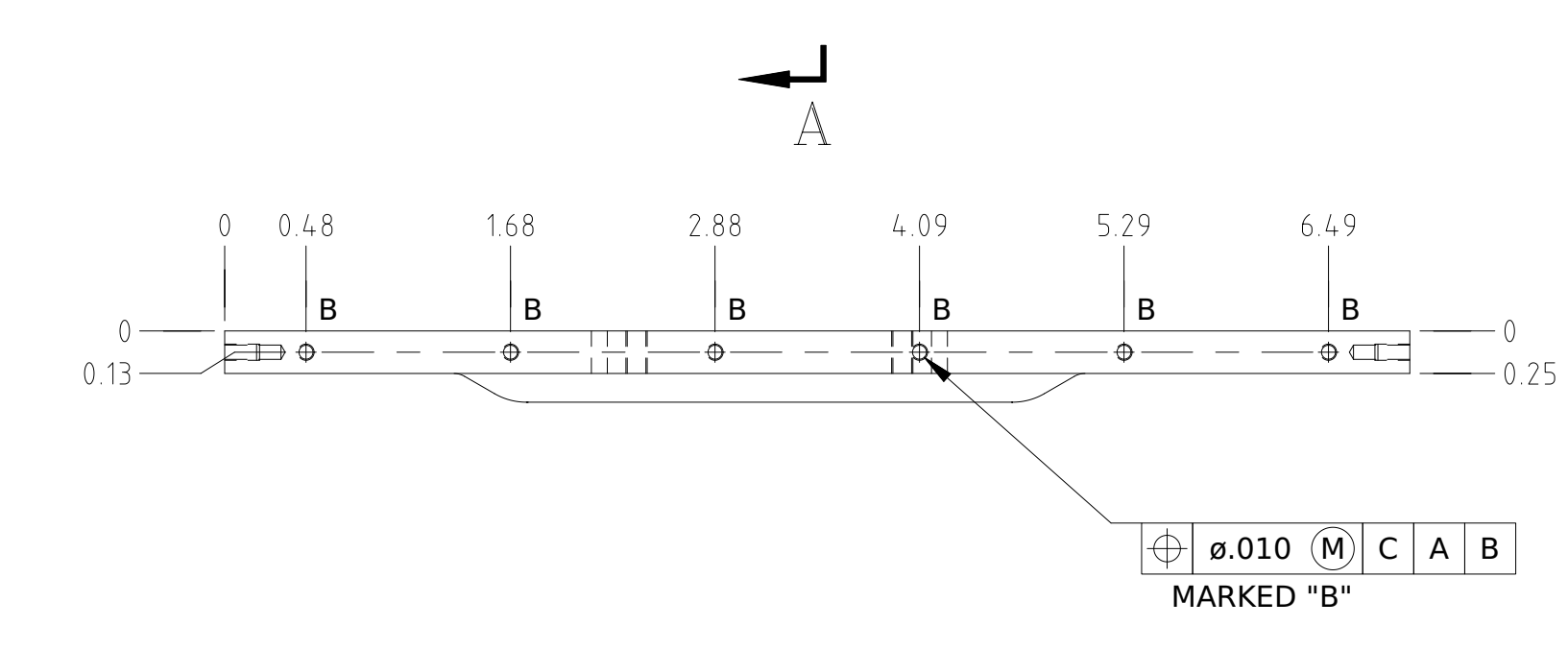


REVISIONS			
REV.	ECO NO.	DISCRIPTION	DATE
A	36-452	INITIAL RELEASE	2/1/96
B	36-569	REVISED PER ECO 36-569	5/3/96
C	36-677	REVISED PER ECO 36-677	



SECTION A-A
SCALE: 1/1



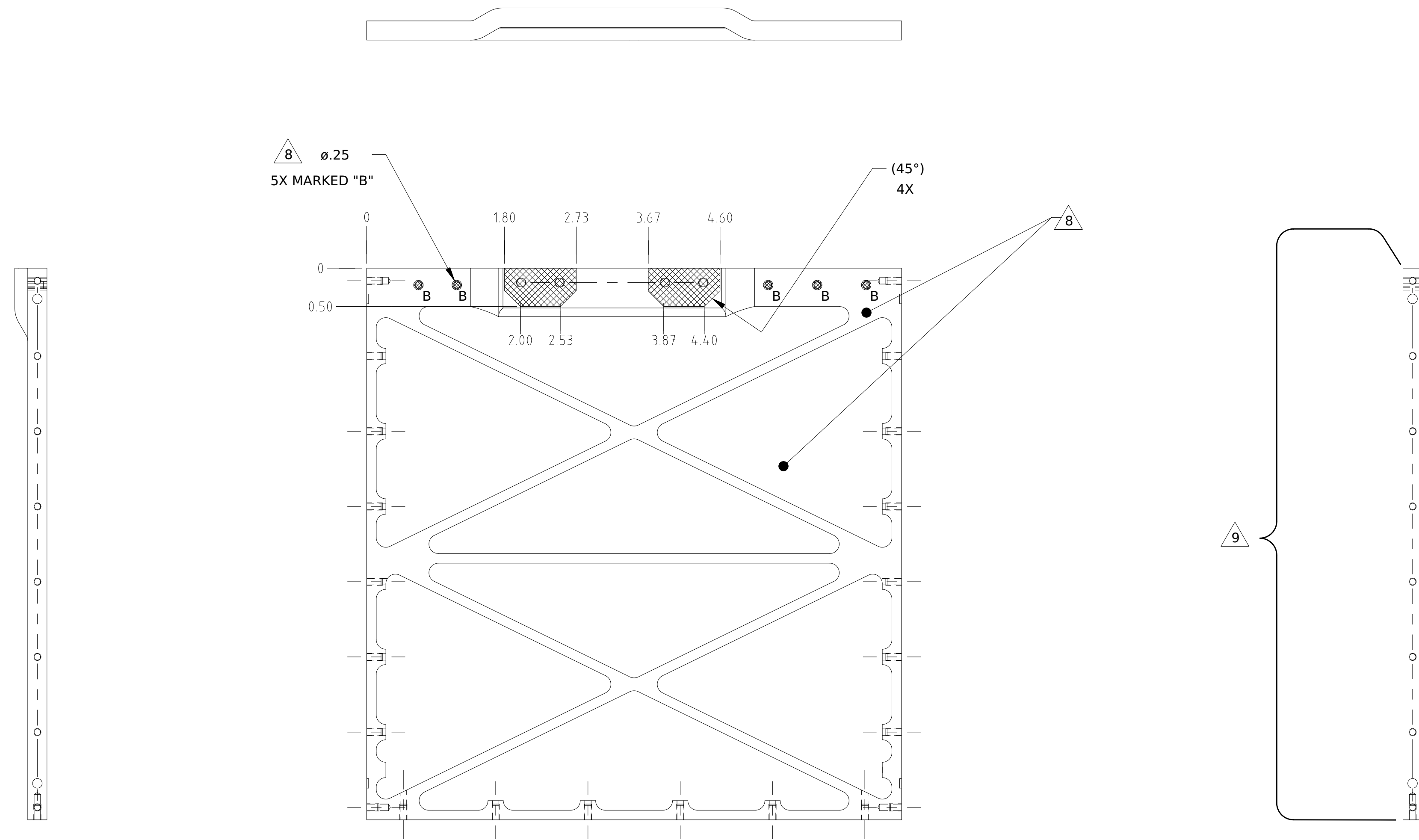
HOLE CHART		
HOLE	DESCRIPTION	QTY
A	Ø.199-.205 X .662, 120±5° X Ø.23-.26 HELICAL COIL TAP .410, #10-32UNF-3B COUNTERSINK & INSTALL FN2 FROM NEARSIDE	4
B	Ø.199-.205 THRU, 120±5° X Ø.23-.26 HELICAL COIL TAP THRU, #10-32UNF-3B COUNTERSINK & INSTALL FN2 FROM NEARSIDE	23
C	Ø.259-.265 THRU, 120±5° X Ø.29-.32 HELICAL COIL TAP THRU, #1/4-28UNF-3B COUNTERSINK & INSTALL FN3 FROM NEARSIDE	4
D	Ø.250 X .05	4

- 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. SPECIFIED.
 - 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.

NAME		DATE	MASSACHUSETTS INSTITUTE OF TECHNOLOGY			
DRAWN J. COOK		4/19/95	CENTER FOR SPACE RESEARCH			
CHECKED P.C. TAPPAN		2/1/96	CAMBRIDGE, MA 02139			
APPROVED R.F. GOEKE		2/1/96	SUPPORT STRUCTURE -Z			
RELEASED D. GAGE		2/1/96				
36-30100	ACIS	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE: ANGLES ± 1° 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .01	SIZE D	FSCM NO. 80230	DWG. NO. 36-30105	REV. C
NEXT ASSEMBLY	USED ON	MATERIAL ALUMINUM 6061-T651	SCALE 1/2	SHEET 1 OF 2		
APPLICATION		INTERPRET DIMENSIONS AND TOLERANCES IAW ANSI Y14.5M-1982	25 Jun 1996 ** /amd/loblolly/h1/hcw/eco/30105_s1_r_c.dwg			

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



MASKING DETAIL

SIZE	FSCM NO.	DWG. NO.	REV.
D	80230	36-30105	C
SCALE	SHEET		
1/2	2 OF 2		