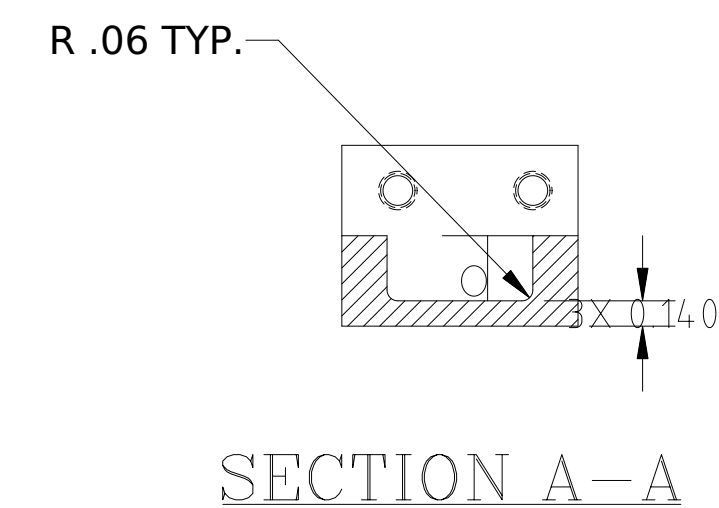
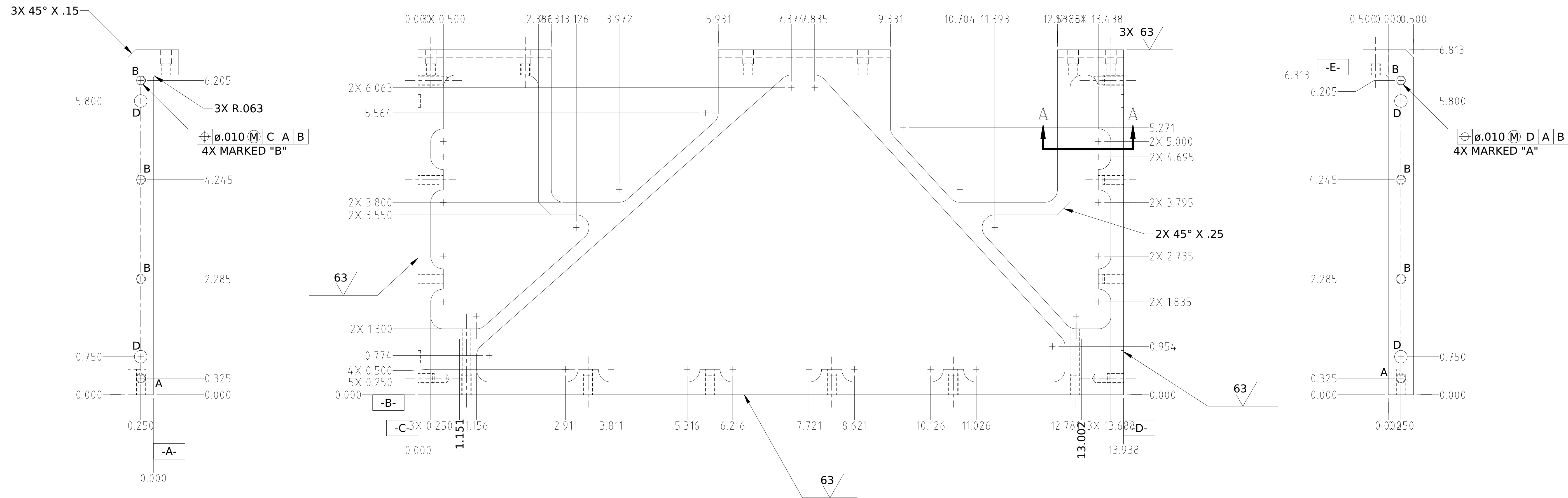
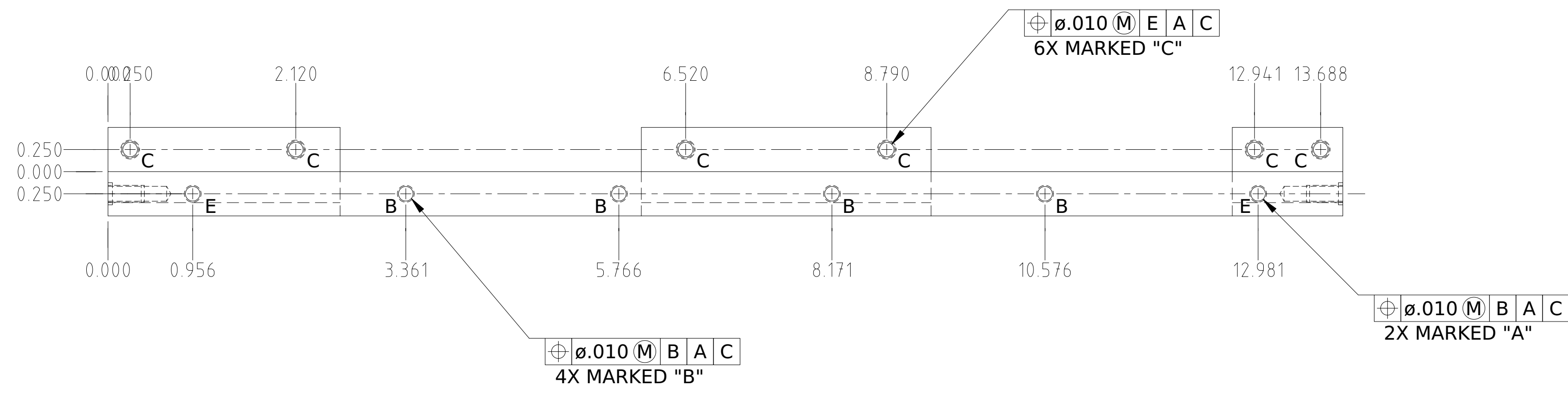


REVISIONS					
REV.	ECO NO.	DISCRPTION	CHECKED	APPROVED	DATE
A	36-452	INITIAL RELEASE	P.C.T.	R.F.G.	04/26/95
B	36-611	REVISED PER ECO 36-611			
C	36-690	REVISED PER ECO 36-690			



- 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.

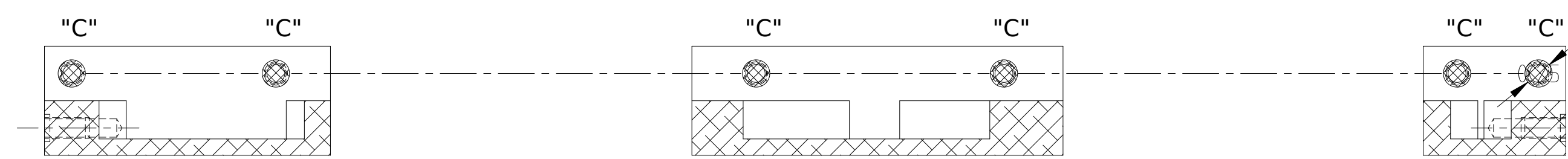
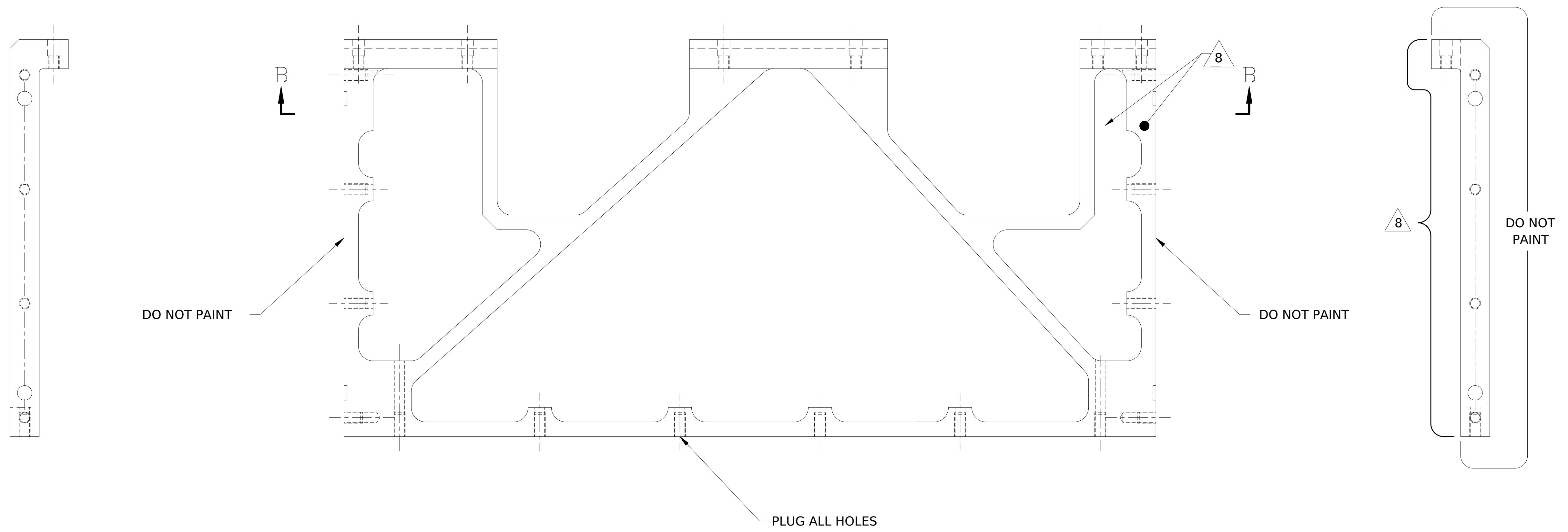


HOLE CHART		
HOLE	DESCRIPTION	QTY
A	Ø.199-.204 X .662, 120±5° X Ø.23-.26 HELICAL COIL TAP .410, #10-32UNF-3B COUNTERSINK & INSTALL FN2 FROM NEARSIDE	2
B	Ø.199-.204 X THRU, 120±5° X Ø.23-.26 HELICAL COIL TAP THRU, #10-32UNF-3B COUNTERSINK & INSTALL FN2 FROM NEARSIDE	10
C	TAP THRU, #10-32UNF-3B L Ø.211-.216 X .280 FROM FAR SIDE	6
D	L Ø.250 X .05	4
E	Ø.199-.204 X THRU, 120±5° X Ø.23-.26 HELICAL COIL TAP .410, #10-32UNF-3B COUNTERSINK & INSTALL FN2 FROM NEARSIDE	2

36-30100	ACIS	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE: ANGLES ± 1° 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .01
NEXT ASSEMBLY	USED ON	
APPLICATION		MATERIAL
		ALUMINUM 6061-T651

NAME		DATE		MASSACHUSETTS INSTITUTE OF TECHNOLOGY CENTER FOR SPACE RESEARCH CAMBRIDGE, MA 02139	
DRAWN	J.COOK	4/25/95		<b>SUPPORT STRUCTURE +Z CUTOUT SECTION</b>	
CHECKED	P.C.TAPPAN	02/1/96			
APPROVED	R.F.GOEKE	02/1/96			
RELEASED	D.GAGE	02/1/96			
SIZE	FSCM NO.	DWG. NO.	REV.		
D	80230	36-30111	C		
SCALE	1/1	SHEET	1 OF 2		

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



MASKING DETAIL  
SECTION B-B

SIZE	FSCM NO.	DWG. NO.	REV.
D	80230	36-30111	C
SCALE	1/1	SHEET	2 OF 2