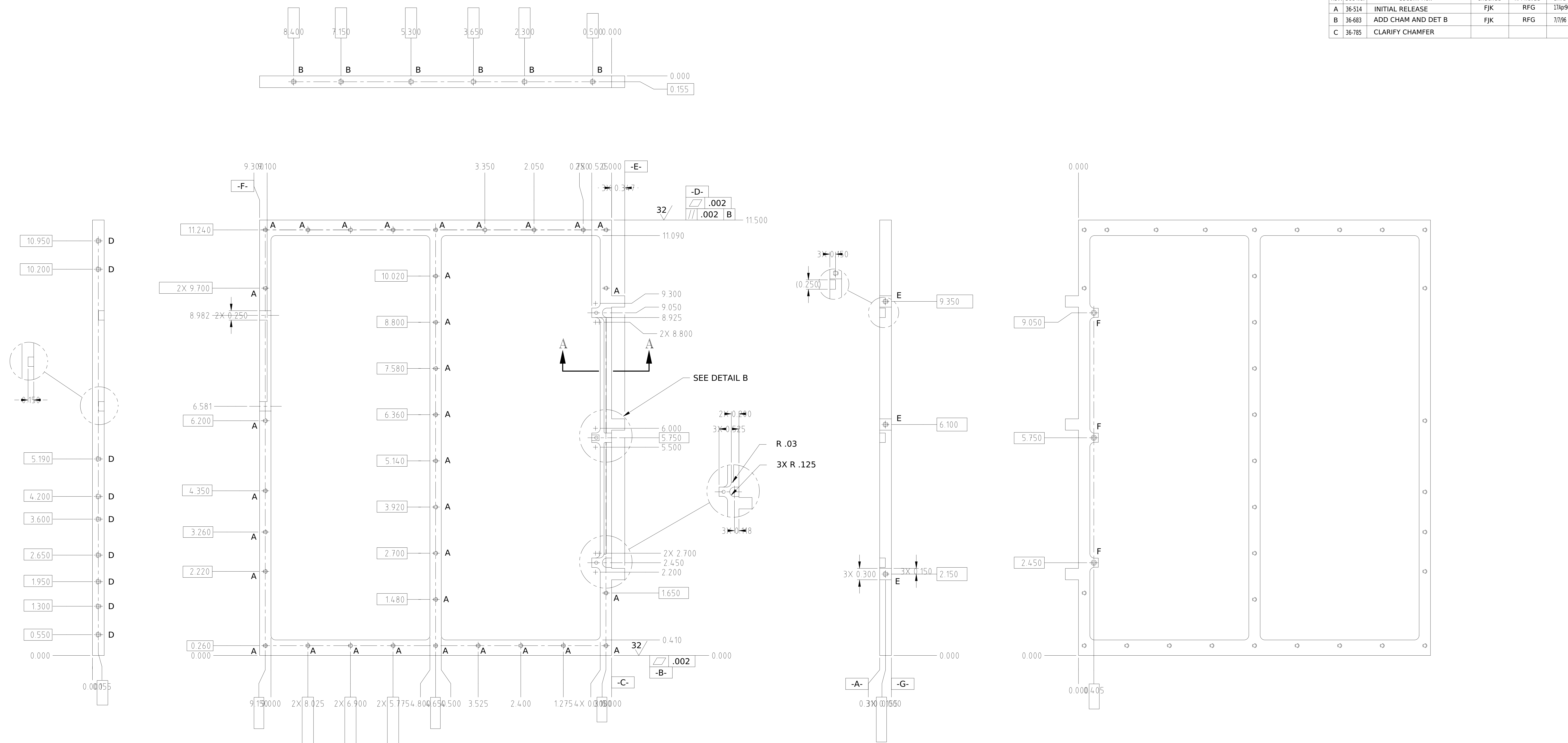
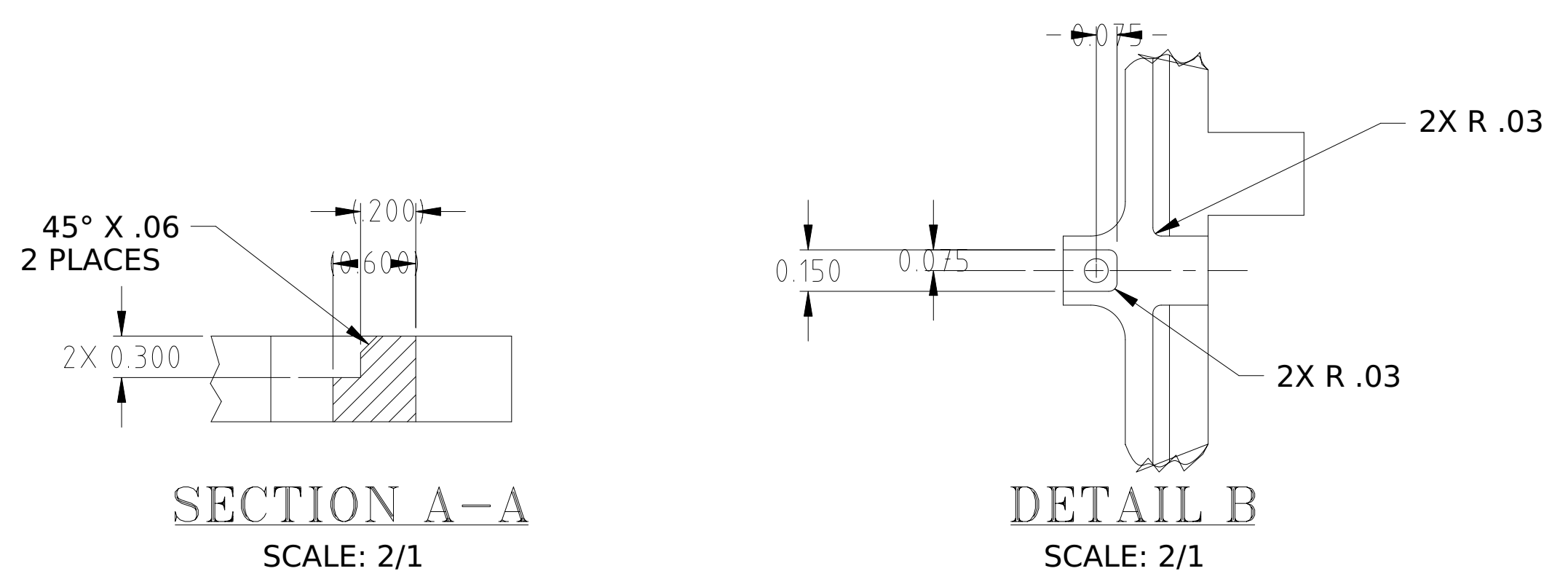


REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A	36-514	INITIAL RELEASE	FJK	RFG	17Apr96
B	36-683	ADD CHAM AND DET B	FJK	RFG	7/7/96
C	36-785	CLARIFY CHAMFER			



- NOTES:
1. MATERIAL: BERYLLIUM, STRUCTURAL GRADE, VACUUM HOT PRESSED, S-200F.
 2. ALL DIMENSIONS APPLY AFTER MACHINING AND FINAL CHEMICAL MILLING.
 3. ALL SURFACES TO BE COMPLETELY FREE OF MACHINING DAMAGE, INCLUDING MICROCRACKS AND TWINNING.
 4. FINISH: PASSIVATE WITH BERYLCOAT "D".
 5. SURFACE ROUGHNESS: 63 MICRO INCHES UNLESS OTHERWISE SPECIFIED.
 6. UNLESS OTHERWISE SPECIFIED, ALL RADII R .12.
 7. BAG AND TAG WITH MIT DRAWING NUMBER AND LATEST REVISION. THE WORDS "BERYLLIUM PART" MUST APPEAR ON BAG.

HOLE	QTY	TOLERANCE	DESCRIPTION
A	33	± 0.010 M A B C	$\phi.0935^{+0.0030}_{-0.0020}$ DRILL THRU, TAP #4-40 UNC-2B THRU
B	6	± 0.010 M D A C	$\phi.111^{+0.0030}_{-0.0020}$ DRILL THRU, TAP #6-32 UNC-2B THRU
C	6	± 0.010 M B A C	$\phi.111^{+0.0030}_{-0.0020}$ DRILL THRU, TAP #6-32 UNC-2B THRU
D	9	± 0.010 M F A B	$\phi.111^{+0.0030}_{-0.0020}$ DRILL THRU, TAP #6-32 UNC-2B THRU
E	3	± 0.010 M E A B	$\phi.111^{+0.0030}_{-0.0020}$ DRILL THRU, TAP #6-32 UNC-2B THRU ▽ .400 MINIMUM
F	3	± 0.010 M G B C	$\phi.086^{+0.0030}_{-0.0020}$ DRILL THRU, $\phi.141$.10



NAME	DATE	MASSACHUSETTS INSTITUTE OF TECHNOLOGY			
DRAWN M.LYONS	01/18/96	CENTER FOR SPACE RESEARCH			
CHECKED F. Kasparian	11/29/96	CAMBRIDGE, MA 02139			
APPROVED R. F. Goeke	11/29/96	FRAME, PCB MOUNTING, DEA HEATER CONTROL			
RELEASED J. Repec	11/29/96				
MATERIAL	SEE NOTE 1	SIZE	CAGE CODE	DWG. NO.	REV.
36-30202	ACIS	E	80230	36-30202.04	C
NEXT ASSEMBLY	USED ON	WEIGHT	SCALE	1:1	SHEET
APPLICATION	INTERPRET DIMENSIONS AND TOLERANCES (ANSI AND Y14.5M-1992)				1 OF 1