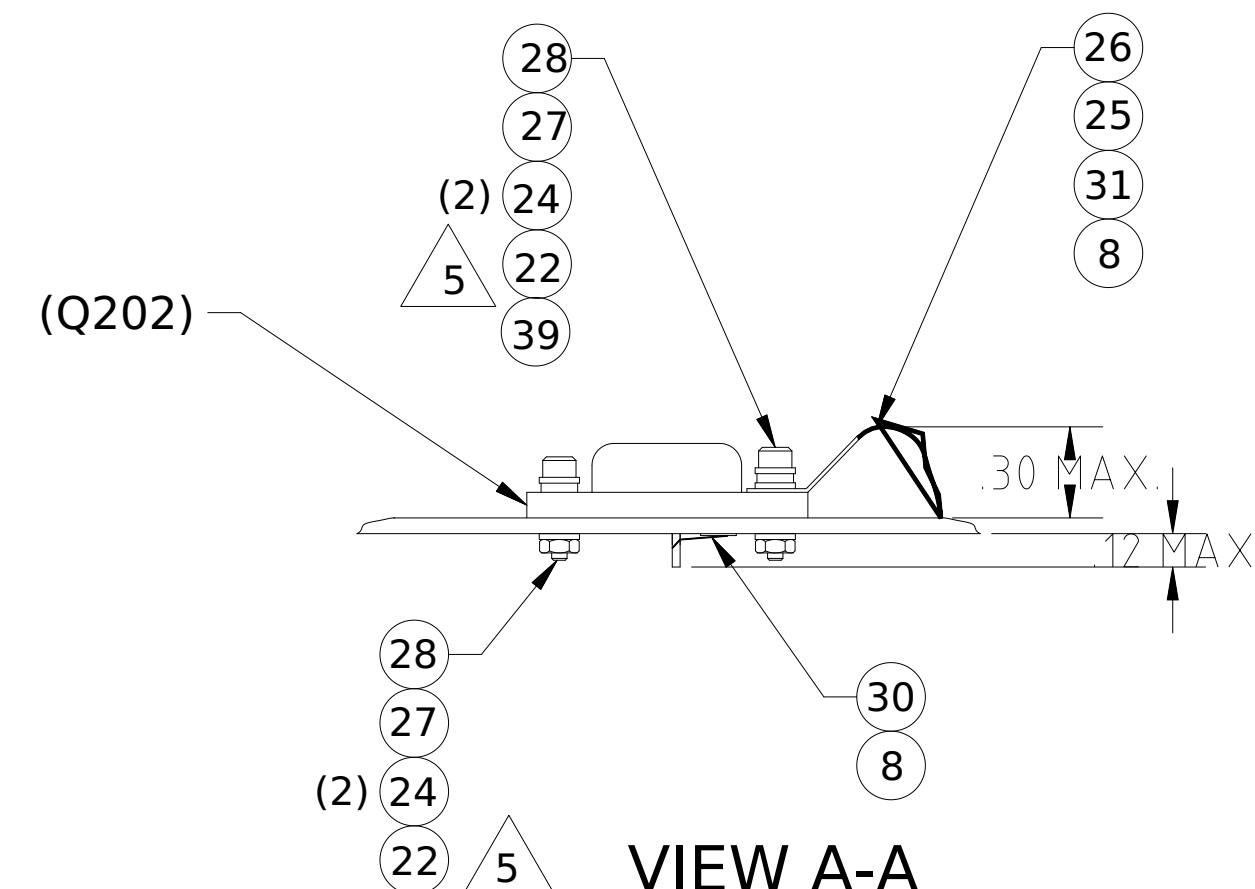
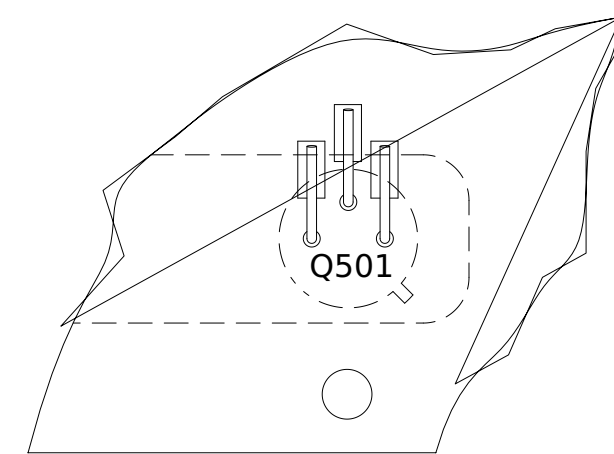


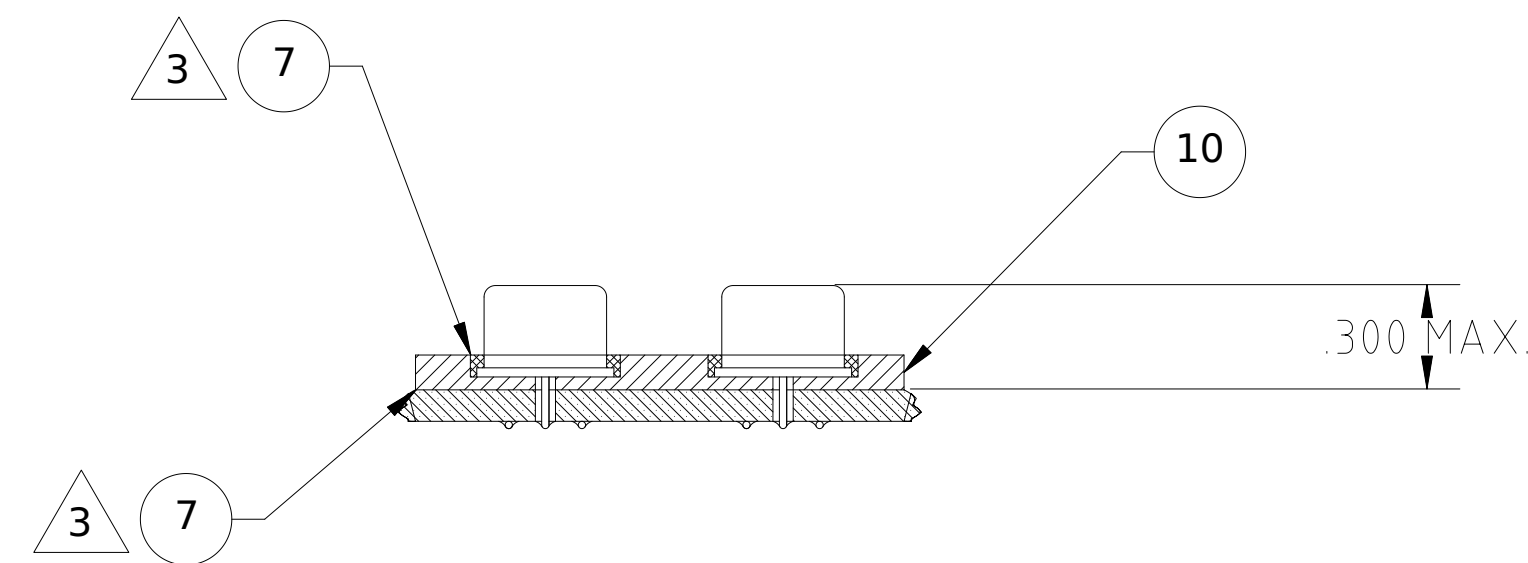
REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A	36-642	INITIAL FLIGHT RELEASE	FJK	RFG	6/5/96
B	36-678	MAJOR DESIGN UPDATE	FJK	RFG	7/1/96
C	36-717	DESIGN UPDATE	FJK	RFG	8/9/96
D	36-738	DESIGN UPDATE	FJK	RFG	9/4/96
E	36-898	AS BUILT CONFIG			



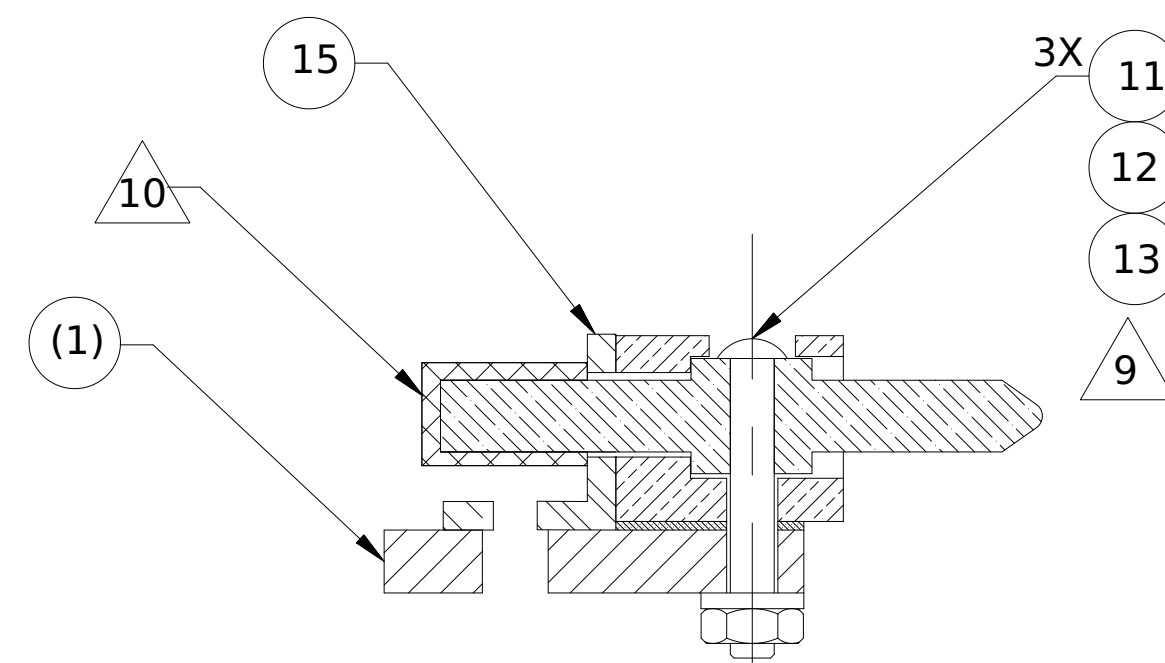
VIEW A-A
SCALE 2/1
Q202-203 ATTACHMENT



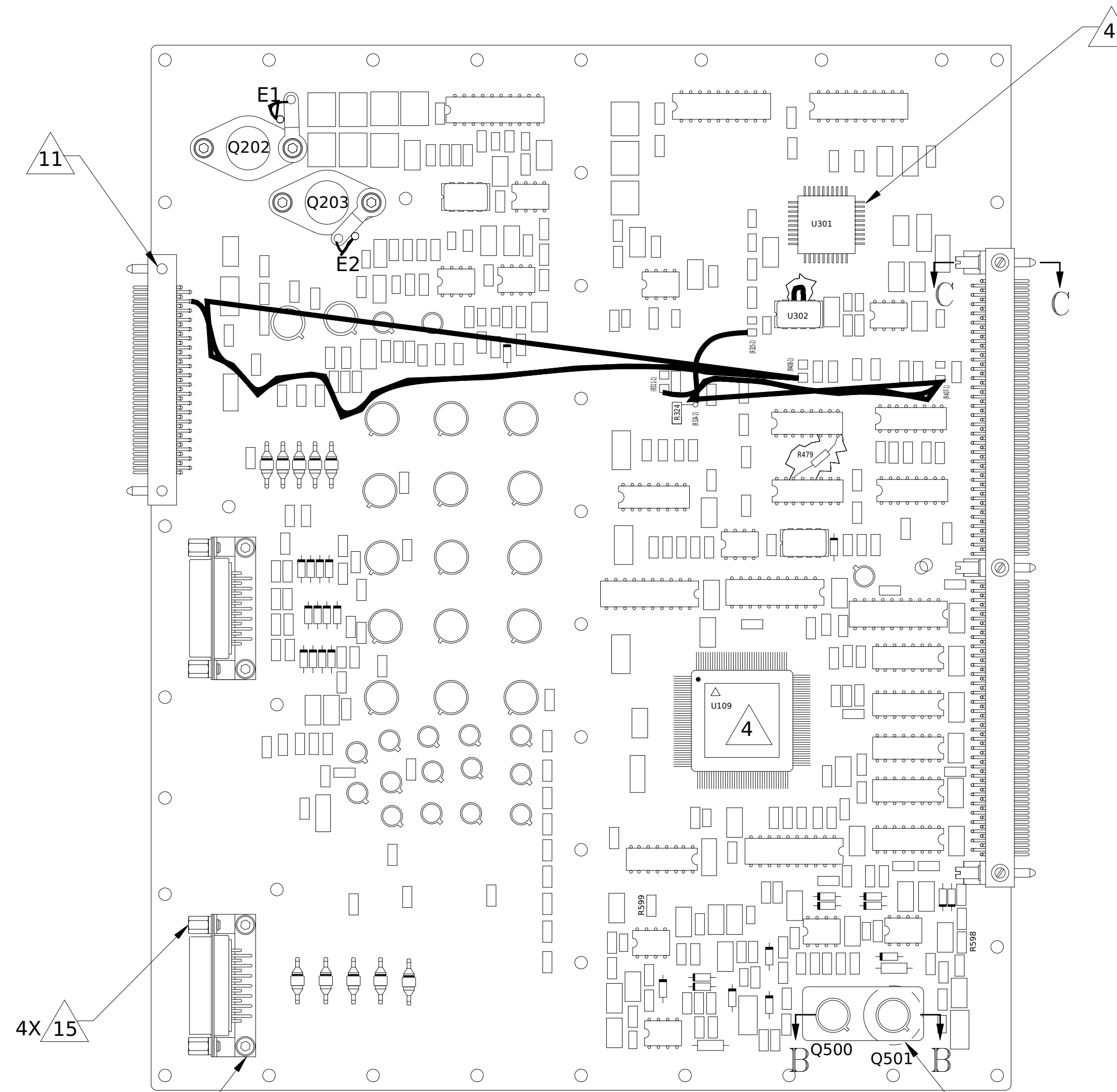
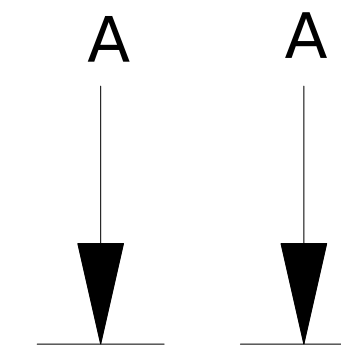
DETAIL D
SOLDER SIDE ATTACHMENT
SCALE 2/1



SECTION B-B
SCALE 4/1
HEATSINK ATTACHMENT



SECTION C-C
SCALE 4/1
CONNECTOR ATTACHMENT



NOTES:

- RECORD EPOXIES USED, MIX RATIO, EXPIRATION DATES, ETC. ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF A.W.O.
- SOLDERING TO BE IAW NASA SPECIFICATION NHB5300.4(3A-1).
- ADHERE F/N 10 TO F/N 1 Q500 AND Q501 USING F/N 7.
- SPOTBOND EACH CORNER OF U109 AND U301 WITH F/N 18. IAW NASA SPECIFICATION NHB5300.4(3J).
- TORQUE TO 4 IN-LB. SPOT BOND WITH F/N 21.
- INSTALL PROTECTIVE COVER, F/N 32, ON J1 DURING ALL NON-TESTING OPERATIONS.
- CLEAN ALL HARDWARE IAW MIT PROCEDURE 36-02027 PRIOR TO ASSEMBLY.
- INSTALL PROTECTIVE COVER, F/N 33, ON J2 DURING ALL NON-TESTING OPERATIONS.
- SET KEYS OF J1 TO B-3. TORQUE HARDWARE TO 16 IN-OZ. SPOT BOND WITH F/N 21.
- TORQUE FINGER TIGHT.
- TORQUE HARDWARE TO 16 IN-OZ. SPOTBOND WITH F/N 21.
- HANDLE WITH LPA 104 GLOVES DURING ALL OPERATIONS.
- HANDLE IAW 99-01003.
- FOR PWB 36-30202.01 REV C ONLY
 - JUMPER R324-2 (VIA AS SHOWN) TO R325-2 USING F/N 36 ON THE COMPONENT SIDE. SPOTBOND WITH F/N 18.
 - JUMPER U302-6 TO U302-7 ON THE SOLDER SIDE USING F/N 36. SPOTBOND WITH F/N 18.
 - JUMPER R401-1 TO R311-1 USING F/N 36 ON THE COMPONENT SIDE. SPOTBOND WITH F/N 18.
 - JUMPER R408-1 TO J2-4 USING F/N 36 ON THE COMPONENT SIDE. SPOTBOND WITH F/N 18.
 - CONNECT R479 TO U406-8 TO U405-14 ON THE SOLDER SIDE. SPOTBOND WITH F/N 18.
- TORQUE TO 32 IN-Oz. SPOT BOND WITH F/N 21.

INTERPRET DIMENSIONS AND TOLERANCES IAW ANSI Y14.5M-1982		NAME Applied CAD		DATE 14 MAY 96	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE ANGLES ± 1° 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .01		CHECKED F. Kasparian		6/5/96	
MATERIAL 36-30202 ACIS		APPROVED R. Goeke		6/5/96	
NEXT ASSEMBLY USED ON		RELEASED D. Gage		6/5/96	
APPLICATION		WEIGHT		SEE DATABASE	
SIZE D 80230		CAGE CODE 80230		DWG. NO. 36-30202.98	
SCALE 1:1		SHEET 1 OF 1		REV. E	

MASSACHUSETTS INSTITUTE OF TECHNOLOGY
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CAMBRIDGE, MA 02139

MIT SUBASSY - HEATER CONTROL & INTERFACE A