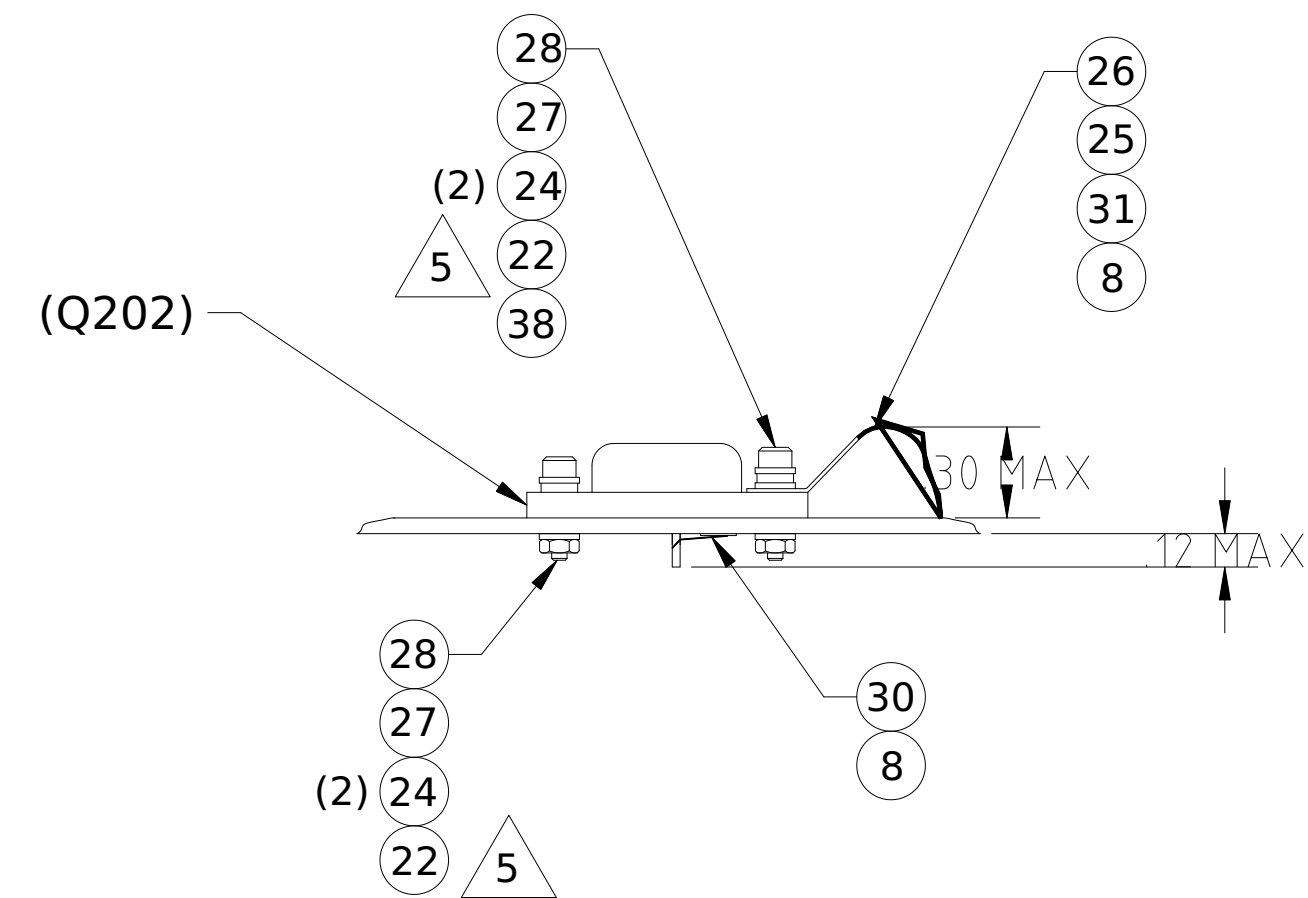


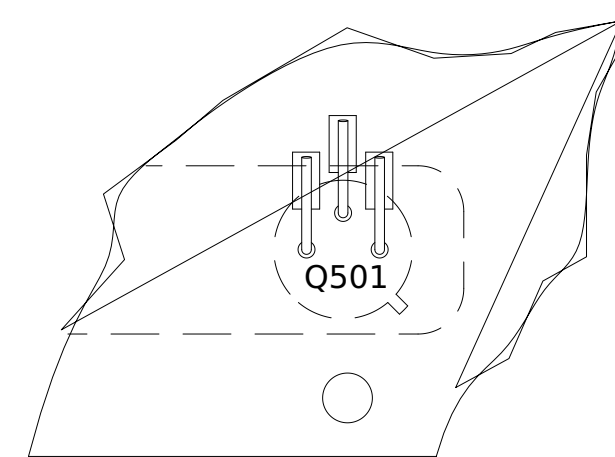
REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A	36-684	INITIAL FLIGHT RELEASE	FJK	RFG	7/8/96
B	36-717	DESIGN UPDATE	FJK	RFG	8/9/96
C	36-739	DESIGN UPDATE	FJK	RFG	9/4/96
D	36-898	AS BUILD CONFIGURATION			



VIEW A-A

SCALE 2/1

Q202-203 ATTACHMENT



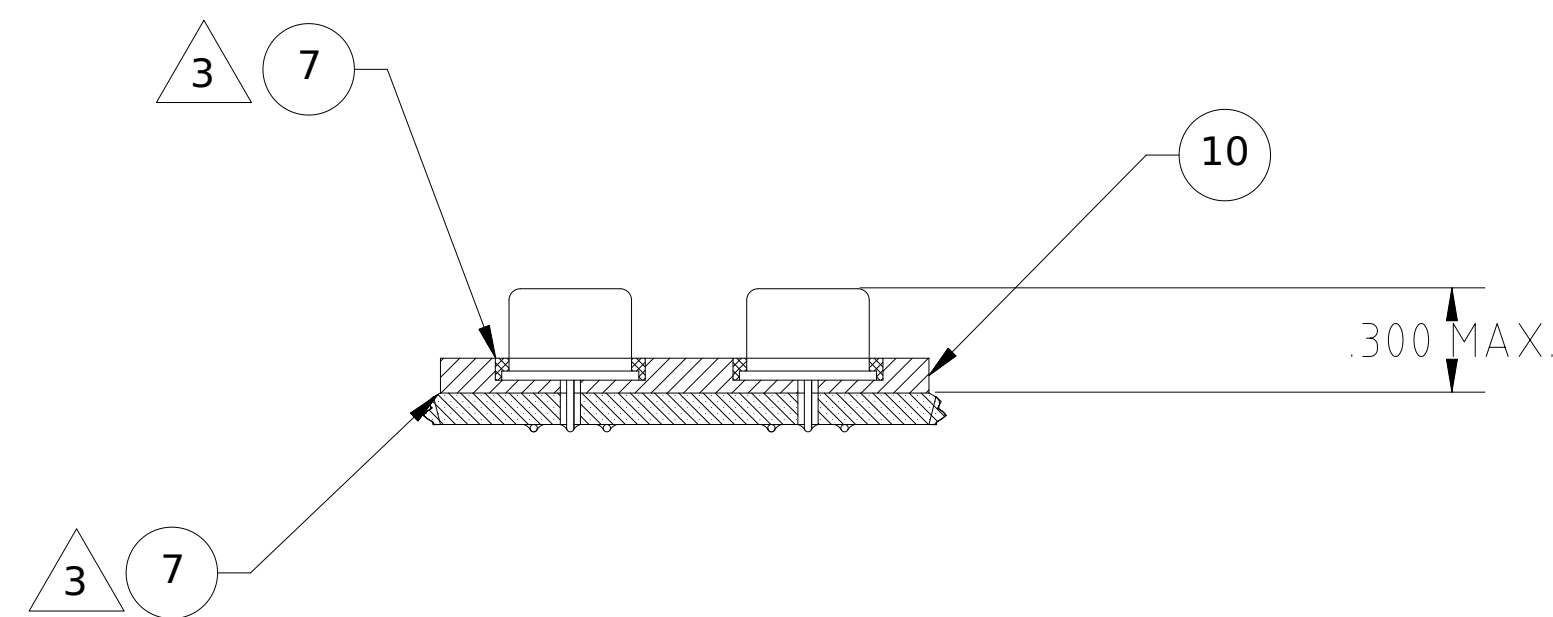
DETAIL D

SOLDER SIDE ATTACHMENT

SCALE 2/1

NOTES:

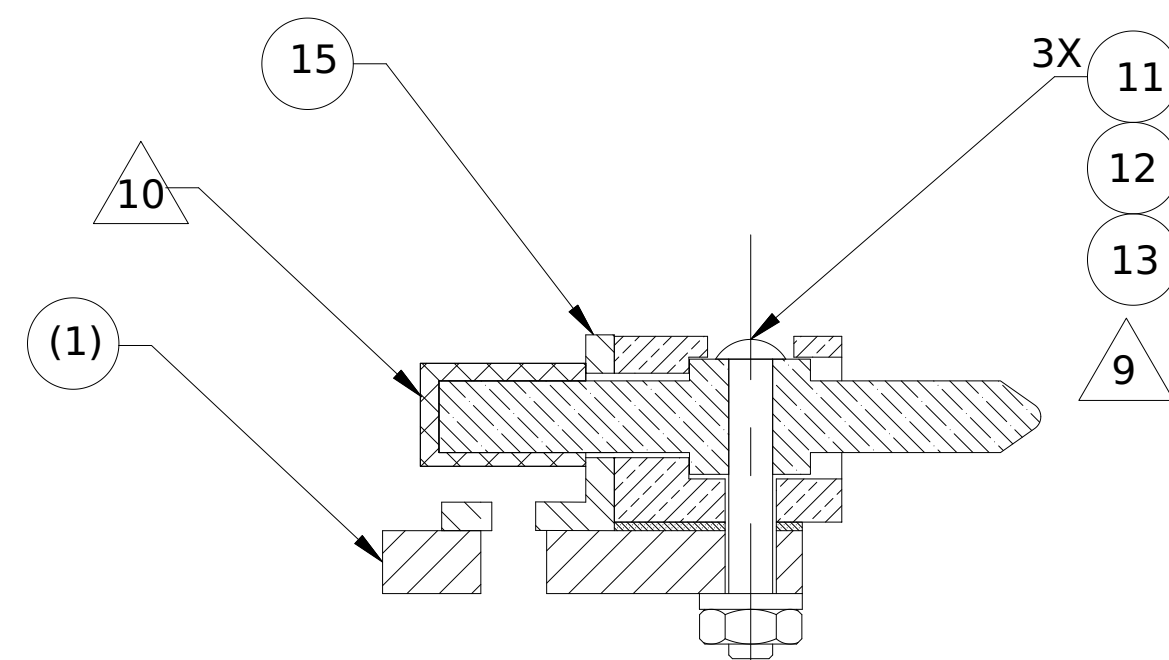
- RECORD EPOXIES USED, MIX RATIO, EXPIRATION DATES, ETC. ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF A.W.O.
- SOLDERING TO BE IAW NASA SPECIFICATION NHB5300.4(3A-1).
- ADHERE F/N 10 TO F/N 1 Q500 AND Q501 USING F/N 7.
- SPOTBOND EACH CORNER OF U109 AND U301 WITH F/N 18. IAW NASA SPECIFICATION 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 C-4. TORQUE HARDWARE TO 16 IN-OZ. SPOT BOND WITH F/N 21.
- TORQUE FINGER TIGHT.
- HANDLE IAW 99-01003.
- HANDLE WITH LPA 104 GLOVES DURING ALL OPERATIONS.
- FOR PWB 36-30202.01 REV C ONLY
 - JUMPER R324-1 TO R325-2 USING F/N 35 ON THE COMPONENT SIDE. SPOTBOND WITH F/N 18.
 - JUMPER U302-6 TO U302-7 ON THE SOLDER SIDE USING F/N 35. SPOTBOND WITH F/N 18.
 - JUMPER R311-1 TO J2-4 ON THE COMPONENT SIDE USING F/N 35. SPOTBOND WITH F/N 18.
- TORQUE TO 16 IN-Oz. SPOT BOND WITH F/N 21.



SECTION B-B

SCALE 4/1

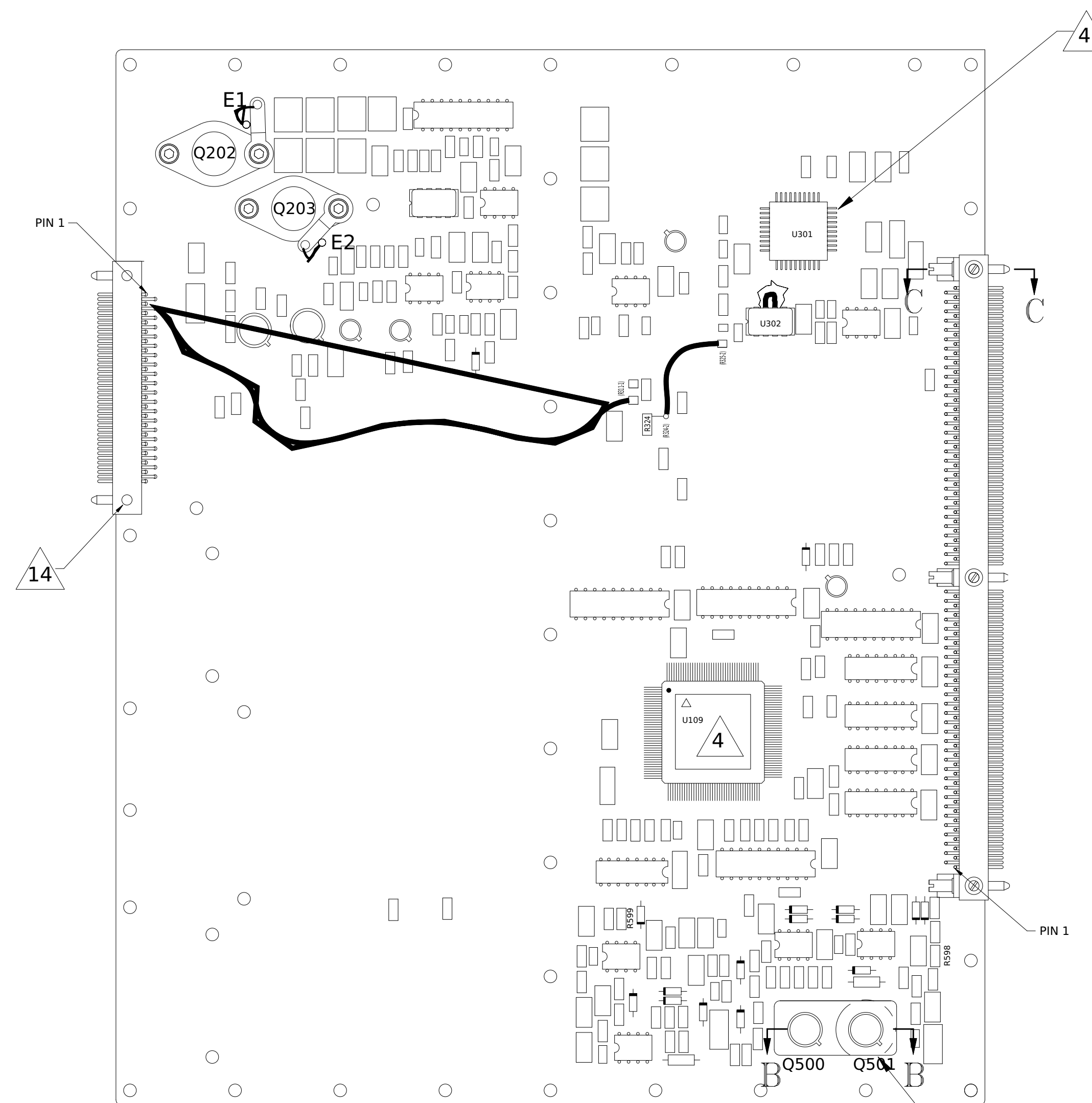
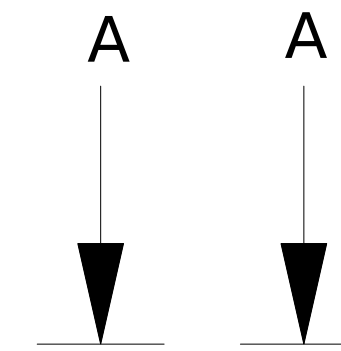
HEATSINK ATTACHMENT



SECTION C-C

SCALE 4/1

CONNECTOR ATTACHMENT



SEE DETAIL D

INTERPRET DIMENSIONS AND TOLERANCES IAW ANSI Y14.5M-1982		NAME Applied CAD		DATE 14 MAY 96	MASSACHUSETTS INSTITUTE OF TECHNOLOGY CENTER FOR SPACE RESEARCH CAMBRIDGE, MA 02139
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE ANGLES ± 1° 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .01		CHECKED F. Kasparian	8 Jul 96		
MATERIAL SEE DATABASE		APPROVED R. Goeke	8 Jul 96		
NEXT ASSEMBLY USED ON		RELEASED D. Gage	8 Jul 96		
36-30262	ACIS	WEIGHT			SIZE D
APPLICATION		SCALE 1:1			CAGE CODE 80230
		DWG. NO. 36-30262.98			REV. D
		SHEET 1 OF 1			