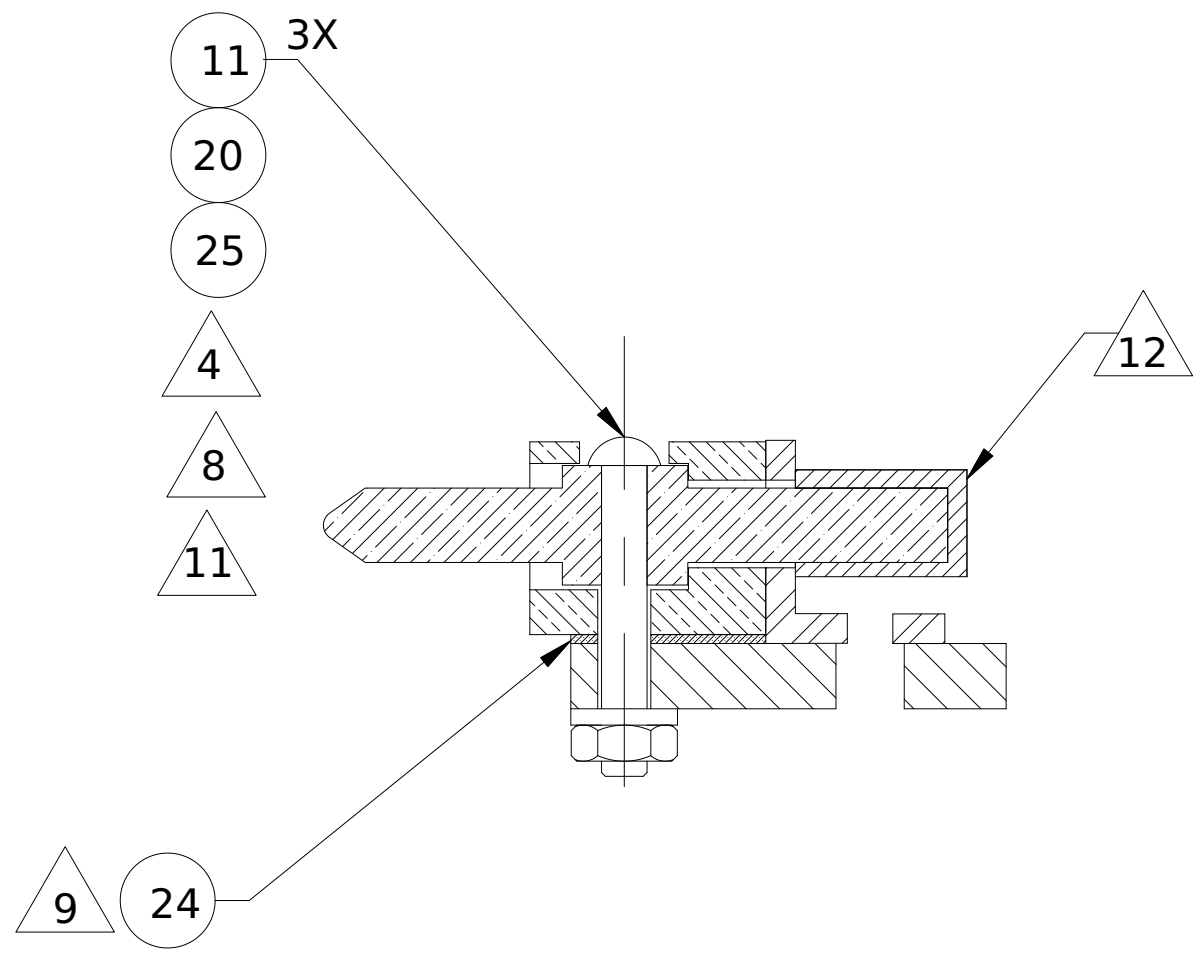
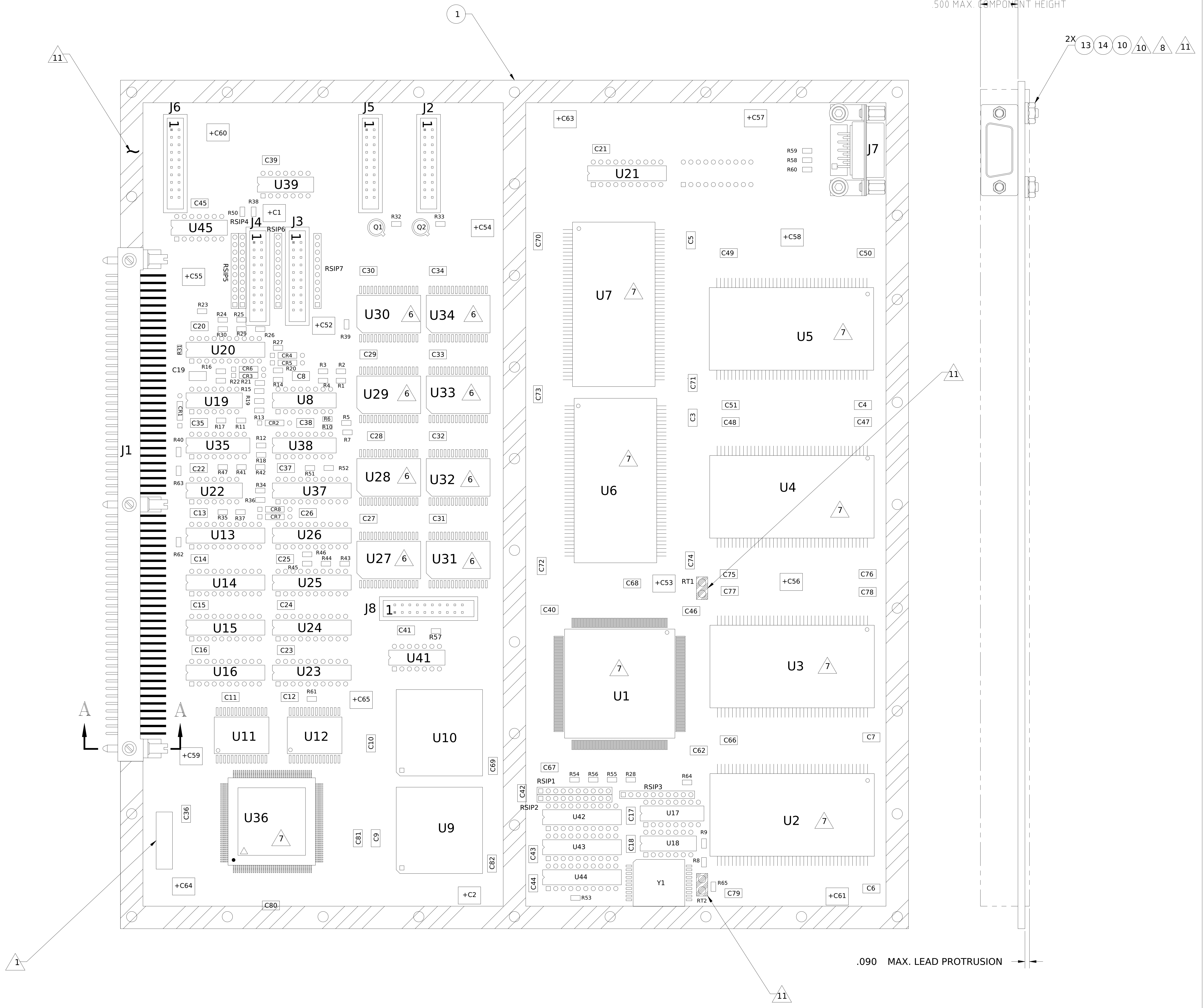


REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A	36-621	INITIAL FLIGHT RELEASE	FJK	RFG	17 Aug 95
B	36-659	MAX HEIGHT WAS .300			



**SECTION A-A
CONNECTOR ATTACHMENT**



NOTES:

1. LABEL ASSEMBLY SERIAL NUMBER IN LOCATION SHOWN PER A.W.O. USING F/N 17.
2. RECORD EPOXIES USED, MIX RATIO, EXPIRATION DATES, ETC.
3. SOLDERING TO BE IAW NASA SPECIFICATION NHB5300.4(3A-1).
4. TORQUE HARDWARE TO 16 IN-OZ PRIOR TO SOLDERING. CENTER CONNECTOR PRIOR TO TORQUING. SET KEYS TO B-2.
5. FORM LEADS IAW 36-02106.
6. INSTALL KAPTON TAPE (F/N 22) UNDER U27-34 (F/N 7005).
7. APPLY EPOXY (F/N 19) UNDER U1 (F/N 7001), U2-7 (F/N 7002), U36 (F/N 7010).
8. SPOTBOND WITH F/N 15. MIX RATIO: 4g 828V140/2g ALUMINA POWDER. DE-GAS BEFORE APPLYING.
9. SHIM CONNECTOR IAW MIT PROCEDURE 36-02025.
10. TORQUE HARDWARE TO 4 IN-LB PRIOR TO SOLDERING.
11. MASK FOR SOLDER AS INDICATED:
 - RT1&2 BOTH SIDES.
 - CONNECTOR MOUNTING HARDWARE.
 - PLATED MOUNTING HOLES NEAR SIDE.
 - PLATED BAND FAR SIDE.
12. DO NOT SPOTBOND.
13. ATTACH PROTECTIVE COVER, F/N 27, TO J1 PRIOR TO SHIPMENT.
14. CLEAN F/N'S 10, 11, 13, 14, 20, 25 AND TEMPORARY HARDWARE IAW MIT PROCEDURE 36-02027 PRIOR TO ASSEMBLY.

INTERPRET DIMENSIONS AND TOLERANCES IAW ANS Y14.5M 1982		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE ANGLES ± 1° 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .01		MATERIAL SEE DATABASE		SIZE E 80230	DATE 28 Feb 95	SCALE 2:1
36-30301	ACIS	SEE DATABASE						
APPLICATOR	USED ON							

MASSACHUSETTS INSTITUTE OF TECHNOLOGY CENTER FOR SPACE RESEARCH CAMBRIDGE, MA 02139		DRAWN Applied CAD		CHECKED F. Kasparian		APPROVED R. F. Goeke		RELEASED D. Gage	
		DATE 28 Feb 95		DATE 17 Aug 95		DATE 17 Aug 95		DATE 17 Aug 95	
BACK END PROCESSOR SANDERS SUBASSY				CAGE CODE 36-30301.97		REV. B		SHEET 1 OF 1	