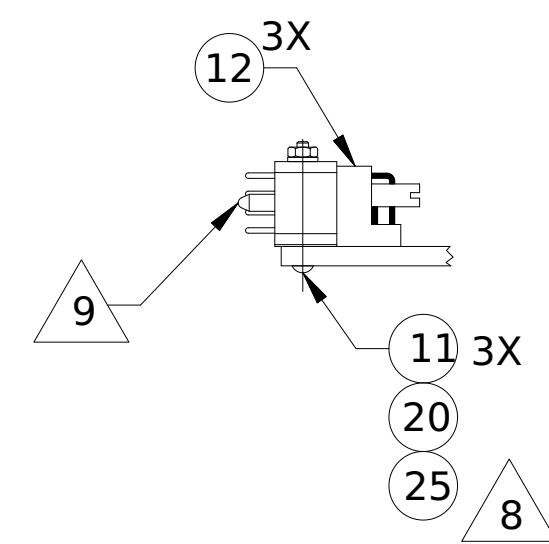
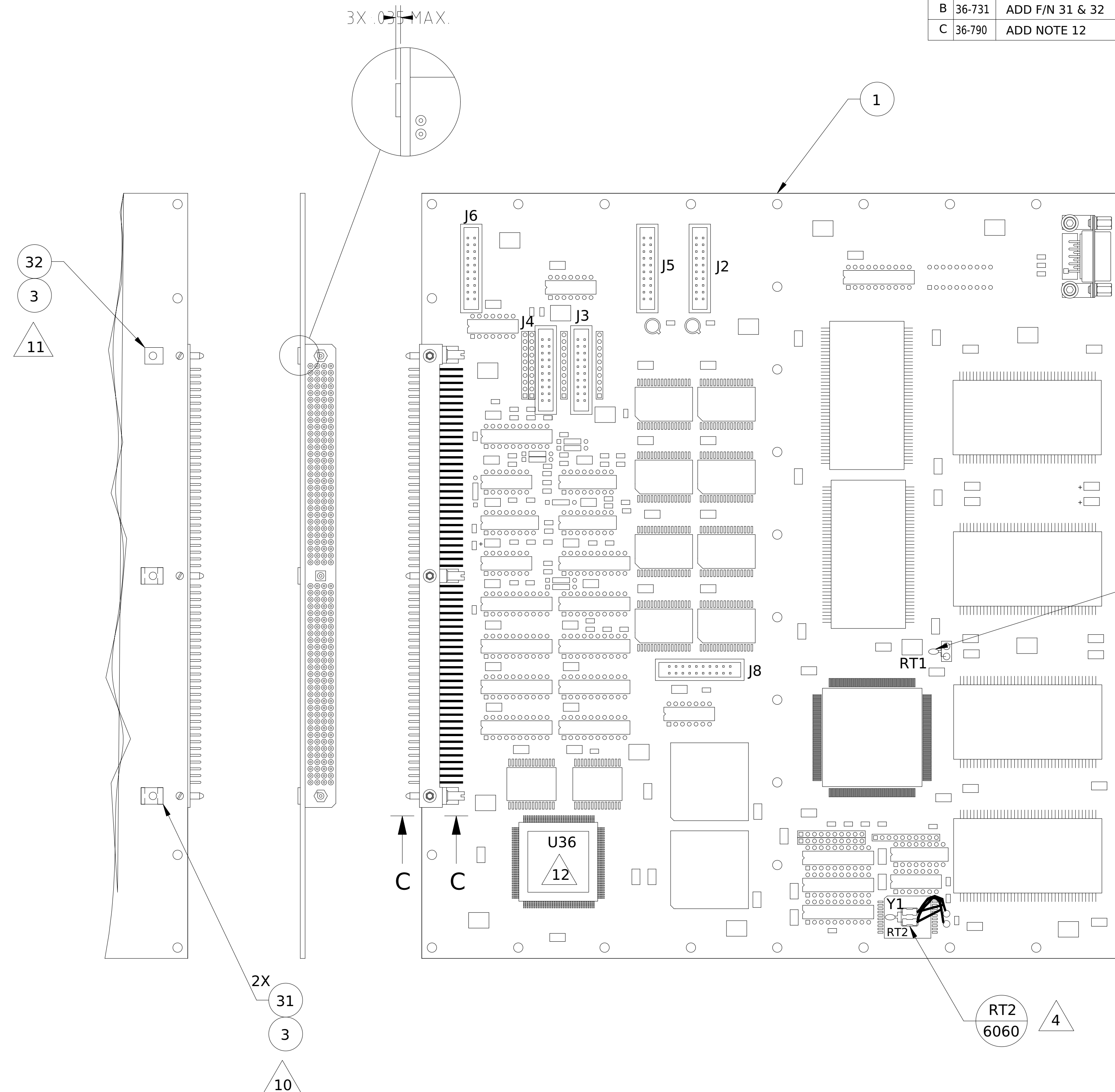


REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A	36-621	INITIAL FLIGHT RELEASE	FJK	RFG	5/17/96
B	36-731	ADD F/N 31 & 32	FJK	RFG	8/30/96
C	36-790	ADD NOTE 12			



VIEW C-C



NOTES:

1. RECORD EPOXIES USED, MIX RATIO, EXPIRATION DATES, ETC. ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF A.W.O.
2. SOLDERING TO BE IAW NASA SPECIFICATION NHB5300.4(3A-1).
3. ATTACH PROTECTIVE COVER, F/N 27, TO J1 FOR ALL NON-TESTING OPERATIONS.
4. INSTALLATION OF RT2
 -MOUNT F/N 26 USING F/N 3 APPROX. AS SHOWN.
 -SOLDER F/N'S 16 & 6060 TO PADS ON F/N 26.
 -ROUTE WIRES (F/N 16) FROM Y1 TO PADS MARKED RT2.
 -SPOT BOND WIRING AND THERMISTOR BEAD USING F/N 18 IAW NASA SPECIFICATION NHB5300.4(3J).
5. INSTALLATION OF RT1
 -SOLDER THE LEADS OF F/N 6060 TO HOLES MARKER RT1.
 -SPOT BOND WIRING AND THERMISTOR BEAD USING F/N 18 IAW NASA SPECIFICATION NHB5300.4(3J).
6. AFTER TESTING, INSERT F/N 23 INTO J2-6,8. COVER WITH KAPTON TAPE, F/N 22. SPOTBOND WITH F/N 3.
7. CLEAN TEMPORARY HARDWARE IAW MIT PROCEDURE 36-02027 PRIOR TO ASSEMBLY.
8. TORQUE TO 16 IN-OZ. SPOTBOND WITH F/N 15.
9. SET KEYS TO B-2. TORQUE FINGER TIGHT.
10. ADHERE F/N 31 TO F/N 1 USING F/N 3.
11. ADHERE F/N 32 TO F/N 1 USING F/N 3.
12. SPOT BOND CORNERS OF U36 USING F/N 15. PROTECT LEADS OF U36 FROM F/N 15.

INTERPRET DIMENSIONS AND TOLERANCES IAW ANSI Y14.5M-1982		NAME DRAWN Applied CAD		DATE 28Feb96	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		17May96	
MATERIAL SEE DATABASE		APPROVED R. F. Goetze		17May96	
36-30301 ACIS		RELEASED D. Gage		17May96	
NEXT ASSEMBLY USED ON		WEIGHT		SCALE 2:1	SIZE D 80230 CAGE CODE 36-30301.98 DWG. NO. 36-30301.98 REV. C
APPLICATION				SHEET 1 OF 1	