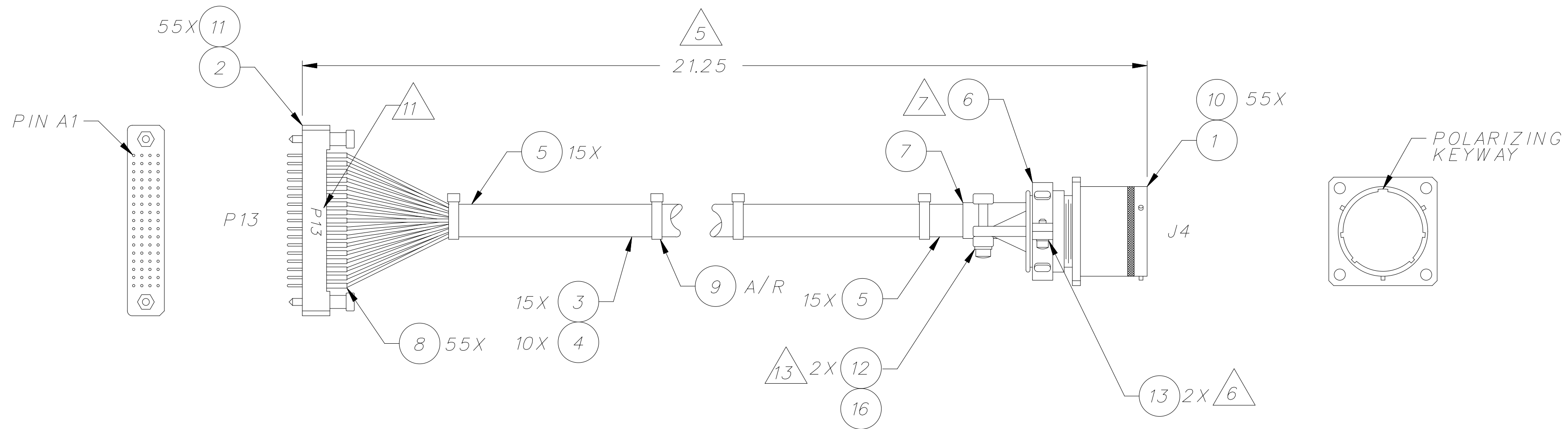


REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A	36-756	INITIAL RELEASE	FJK	RFG	9/19/96
B	36-901	AS BUILD CONFIGURATION			



NOTES:

- REFER TO MIT DRAWING 36-03021.01 FOR SCHEMATIC CONNECTION AND WIRE ASSIGNMENTS.
- HANDLE ITEM WITH POWDER FREE, CONTAMINATION FREE GLOVES.
- CLEAN ITEM IAW MIT SPECIFICATION 36-02027.
- FABRICATE IAW NASA SPEC NHB5300.4(3G)
- LENGTH TO BE VERIFIED DURING INSTALLATION AT NEXT HIGHER ASSEMBLY.
- DISCARD SPLIT LOCKWASHER SUPPLIED WITH F/N 6 AND SUBSTITUTE F/N 13. HAND TIGHTEN AND SPOTBOND WITH F/N 14.
- SECURELY HAND TIGHTEN AND SPOTBOND WITH F/N 14.
- DO NOT INSTALL CONTACTS IN UNUSED POSITIONS.
- PERFORM CONTACT RETENTION TEST ON ALL CONTACTS PER MSFC-STD-781. RECORD RESULTS IN A.W.O.
- ELECTRICAL TESTS (CONTINUITY, DISCONTINUITY, IR, DWV) ARE TO BE PERFORMED IAW NHB5300.4(3G). RECORD RESULTS IN A.W.O.

NOTES (CONTINUED):

- LABEL AS SHOWN USING F/N 15.
- BAG AND TAG WITH MIT DRAWING NUMBER AND LATEST REVISION.
- DISCARD HARDWARE SUPPLIED WITH F/N 6 AND SUBSTITUTE F/N 12 AND 16. HAND TIGHTEN AND SPOTBOND WITH F/N 14.
- CLEAN AND VACUUM BAKE F/N 1, 2 AND 9 IAW MIT SPECIFICATION 36-02027 PRIOR TO ASSEMBLY.
- VACUUM BAKE ASSEMBLY AT 100°C FOR 120 HOURS MINIMUM.
- INSTALL PROTECTIVE COVER, F/N 17, ON P13. REMOVE PRIOR TO INSTALLATION AT NEXT HIGHER ASSEMBLY.
- RECORD EPOXIES USED, MIX RATIOS AND EXPIRATION DATES ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF AWO.

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE: ANGLES ? 1° 3 PLACE DECIMALS ? .005 2 PLACE DECIMALS ? .01	NAME	DATE	MASSACHUSETTS INSTITUTE OF TECHNOLOGY CENTER FOR SPACE RESEARCH CAMBRIDGE, MA 02139
			DRAWN M. LYONS	14AUG96	
			CHECKED F. Kasparian	9/18/96	
			APPROVED R. Goetze	9/19/96	
			RELEASED D. Gage	9/19/96	
36-30300	ACIS	SEE DATABASE			CABLE ASSEMBLY, DPA INTERNAL DIGITAL DATA 2, W13
NEXT ASSEMBLY	USED ON	INTERPRET DIMENSIONS AND TOLERANCES IAW ANS Y14.5M-1982	WEIGHT		SIZE CAGE CODE C 80230
APPLICATION					DWG. NO. 36-30308 SCALE NONE
					REV. B SHEET 1 OF 1