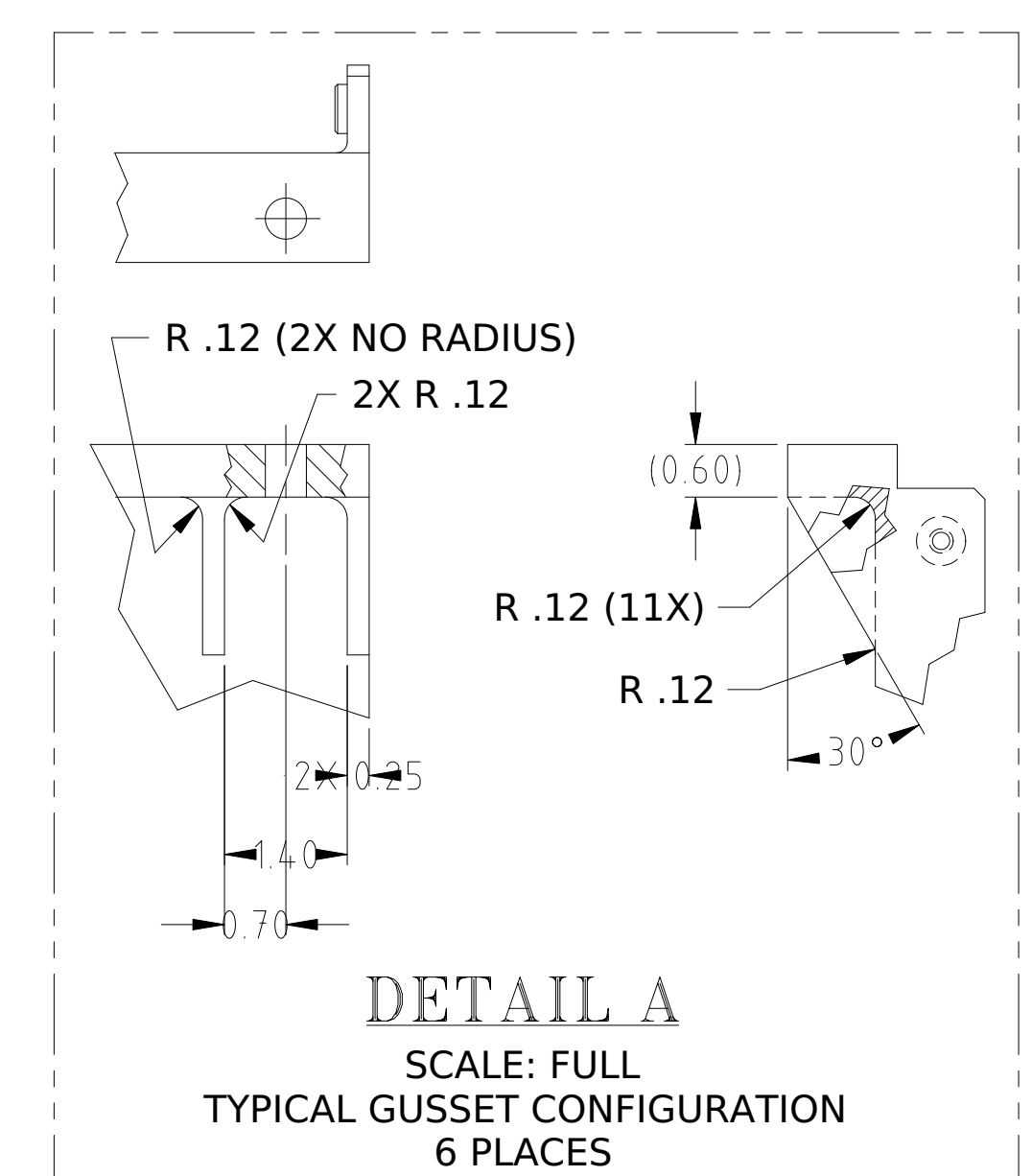
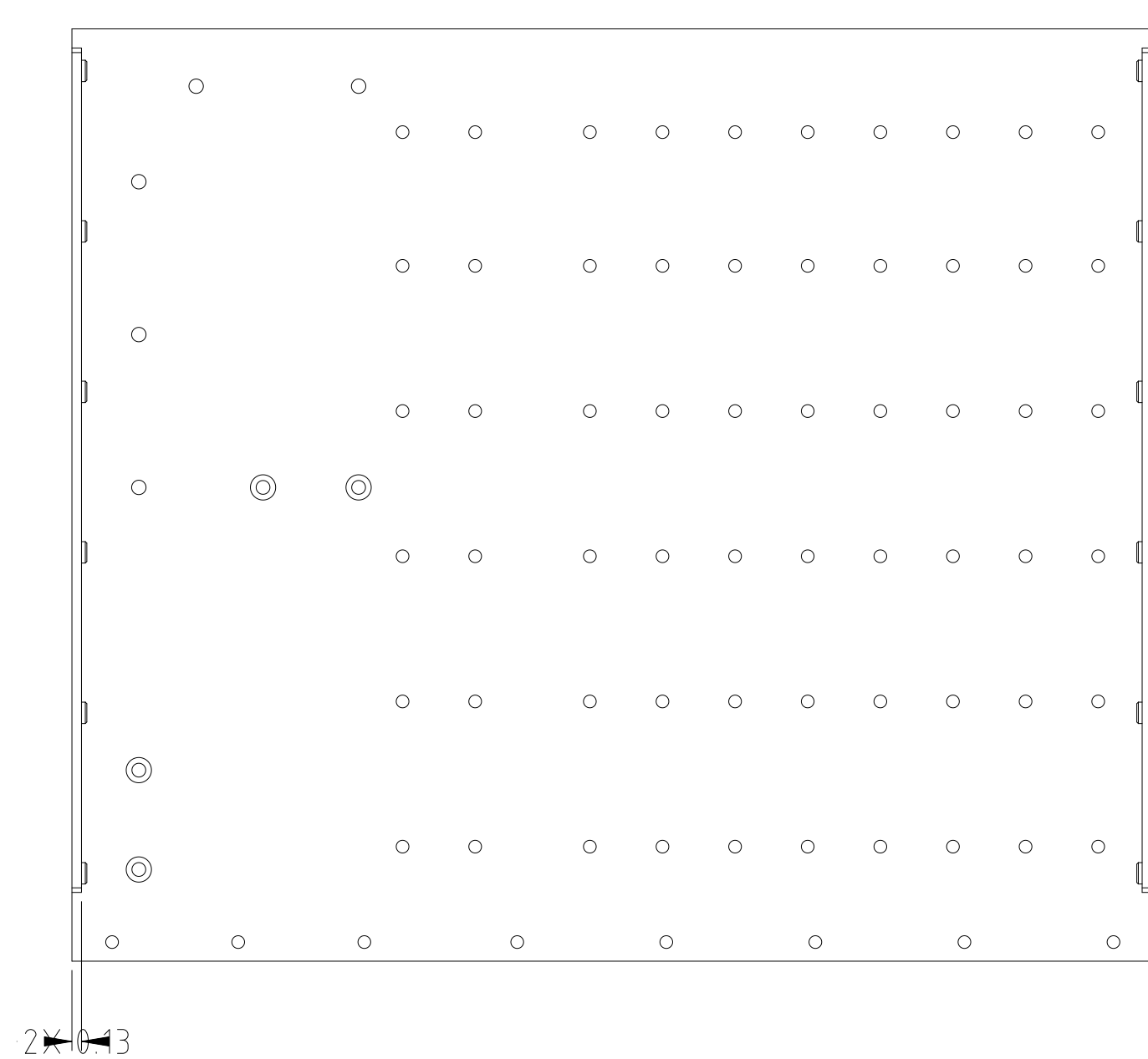
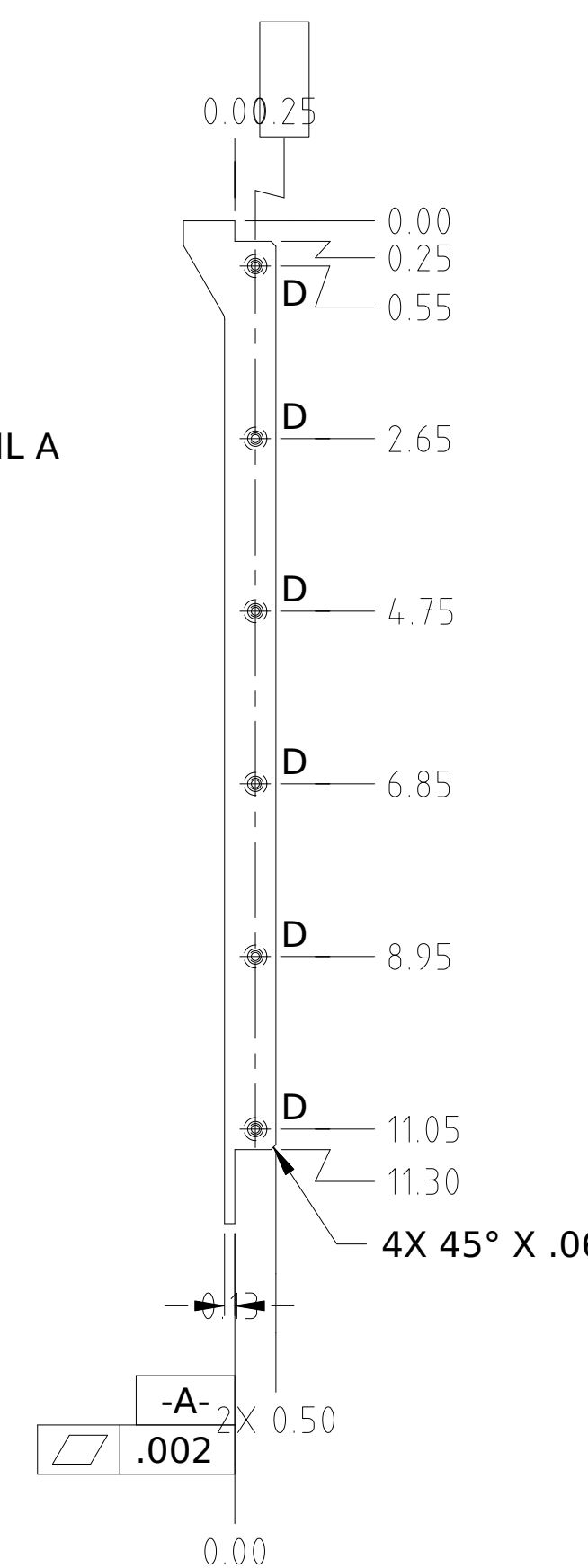
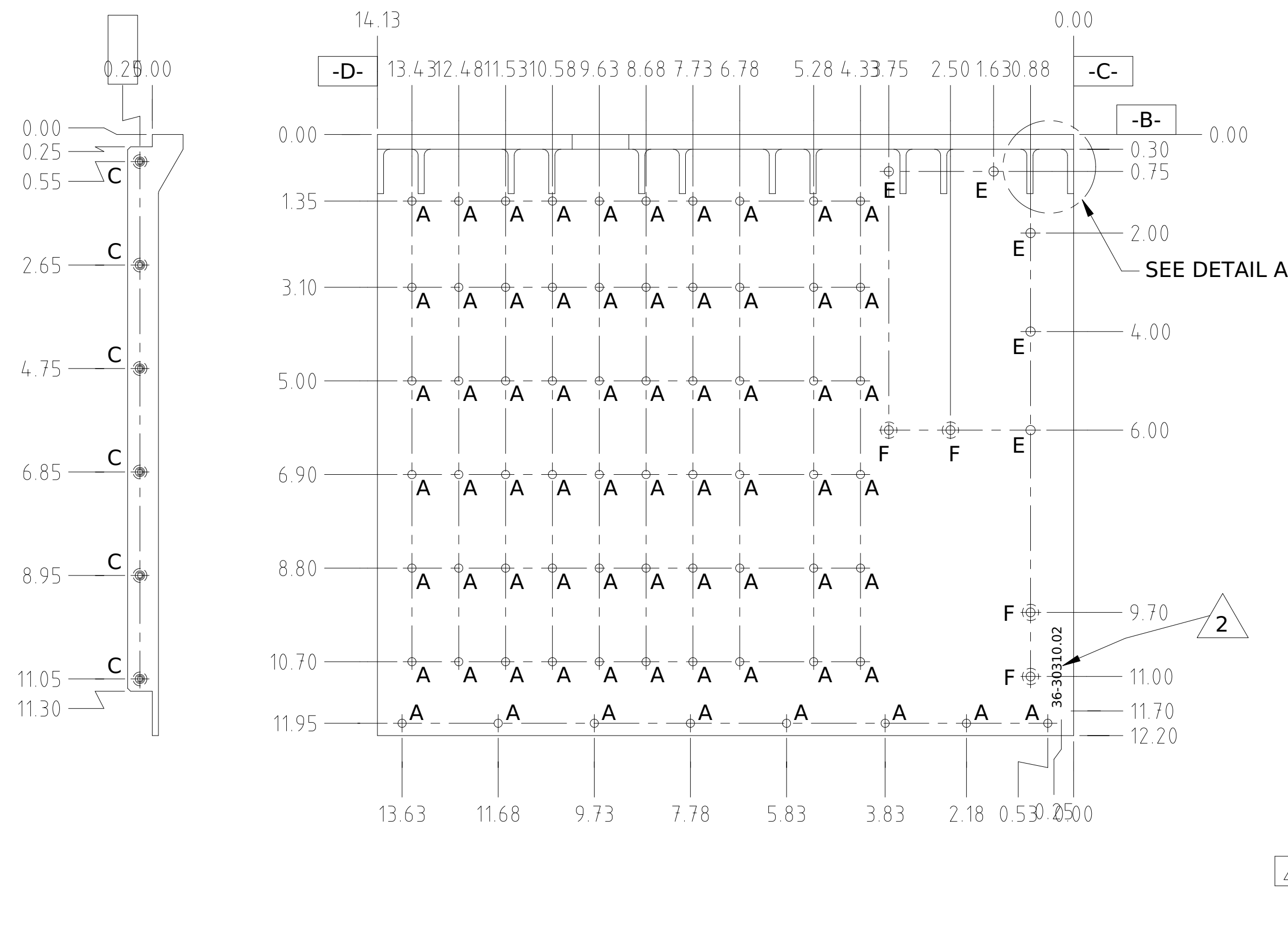
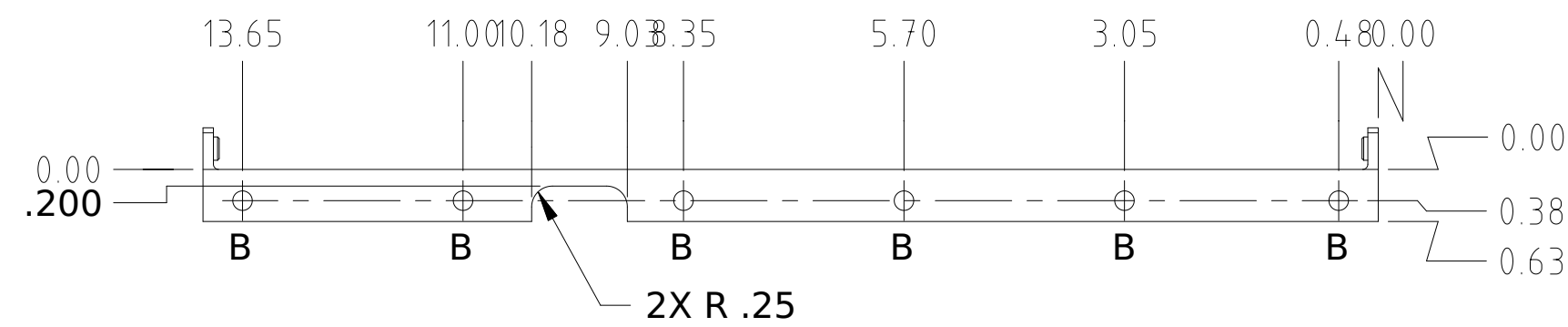


REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A	36-556	INITIAL RELEASE	FJK	RFG	4/12/96
B	36-705	ADD F HOLES - SVRL HTR			

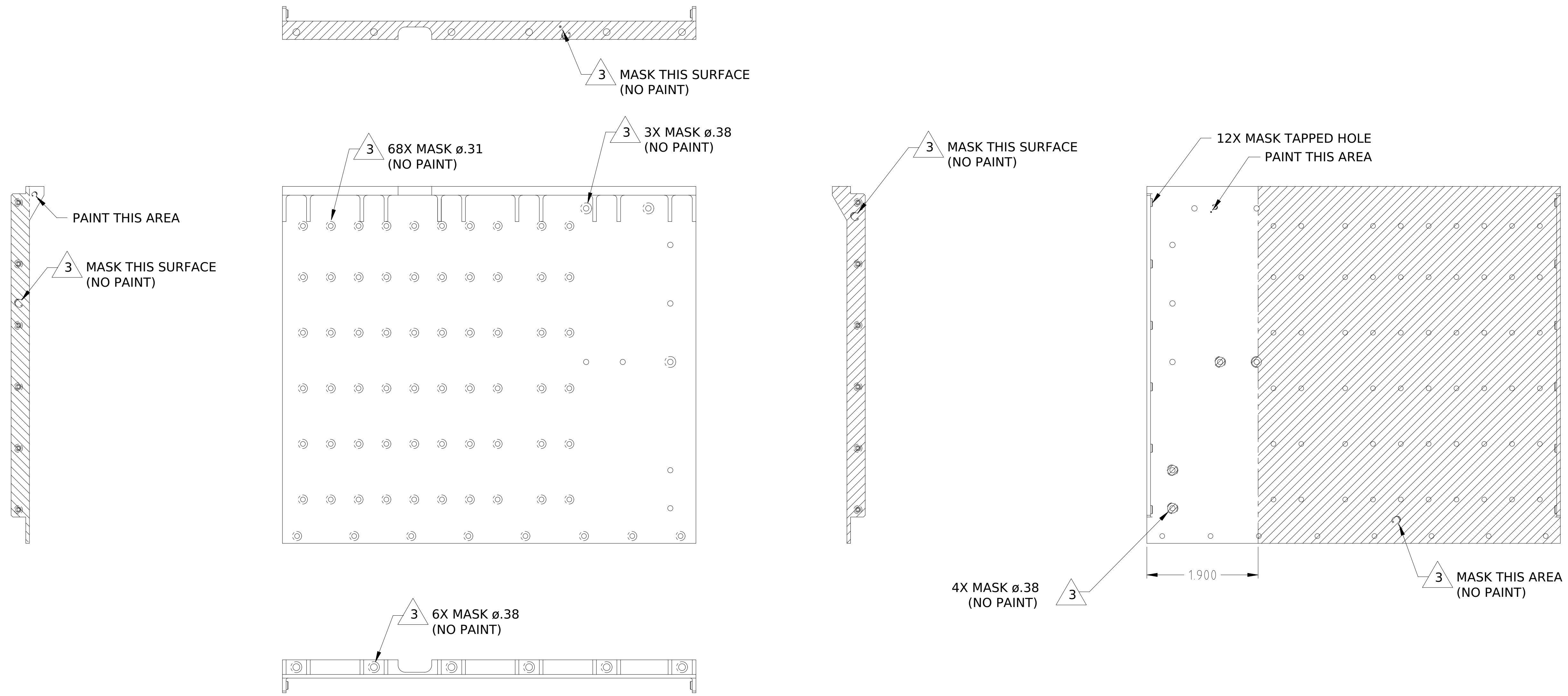
HOLE CHART				
HOLE	QTY	TOLERANCE	DESCRIPTION	
A	68	$\varnothing .010$ (M) A B C	$\varnothing .166 \pm .003$ THRU	
B	6	$\varnothing .010$ (M) B A C	$\varnothing .234 \pm .003$ THRU	
C	6	$\varnothing .010$ (M) D A B	$\varnothing .1875 \pm .0030$ THRU, INSTALL 6-32 UNC SELF-CLINCHING NUT (FN 1) FROM FAR SIDE. INSTALL NUT AFTER FINISH	
D	6	$\varnothing .010$ (M) C A B		
E	5		$\varnothing .188$ THRU	
F	4		$\varnothing .175-.180$ THRU, $\sphericalangle \varnothing .33 \times 82^\circ$ FAR SIDE	



- NOTES:**
- REMOVE ALL BURRS AND SHARP EDGES R .010 MAXIMUM.
 - ENGRAVE OR METAL STAMP USING .19 HIGH CHARACTERS LOCATED APPROXIMATELY AS SHOWN, PRIOR TO FINISH.
 - FINISH: CHEMICAL CONVERSION COAT ALL OVER PER MIL-C-5541, CLASS 3. MASK PART PER SHEET 2 OF THIS DRAWING AND PRIME AND PAINT REMAINING SURFACES USING AEROGLAZE 9924 (PRIMER) AND AEROGLAZE Z306, BLACK (PAINT).
 - HANDLE WITH CONTAMINATION FREE, POWDER FREE GLOVES DURING ALL POST-FINISH OPERATIONS.

NAME		DATE		MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
DRAWN M. LYONS		26MAR96		CENTER FOR SPACE RESEARCH	
CHECKED F. Kasparian		4/12/96		CAMBRIDGE, MA 02139	
APPROVED R. Goeke		4/12/96		PANEL, +Z, DPA	
RELEASED D. Gage		4/15/96			
MATERIAL ALUMINUM 6061-T6		SIZE D	CAGE CODE 80230	DWG. NO. 36-30310.02	REV. B
NEXT ASSEMBLY USED ON		SCALE 1/2			SHEET 1 OF 2
APPLICATION		WEIGHT		INTERPRET DIMENSIONS AND TOLERANCES IAW ANSI Y14.5M-1982	

REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
		SEE SHEET 1			



PAINT AND MASKING INFORMATION

SIZE	CAGE CODE	DWG. NO.	REV.
D	80230	36-30310.02	B
SCALE	SHEET		2 OF 2
1/2			