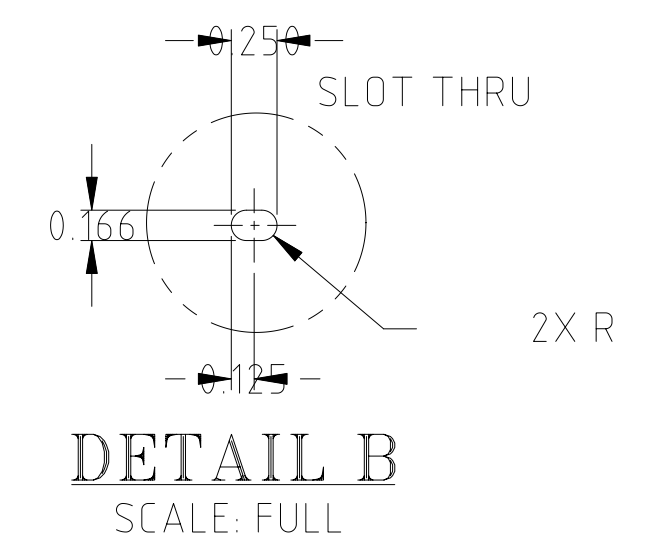
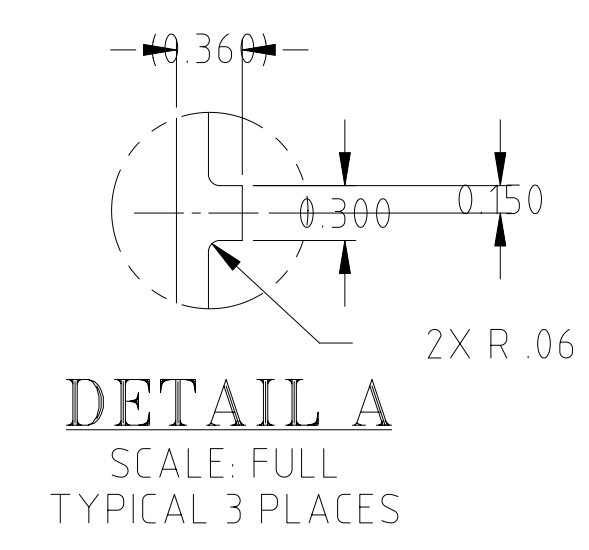
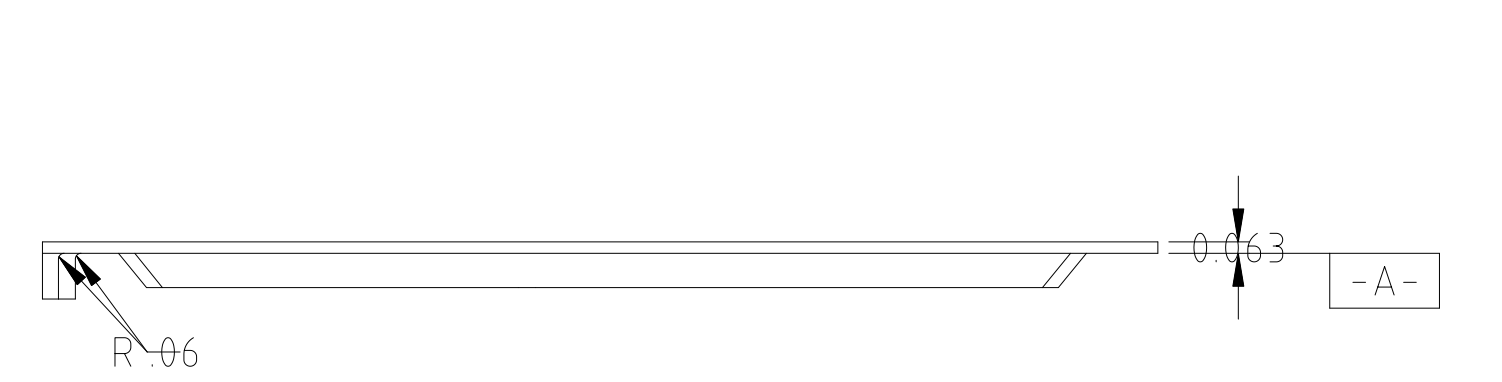
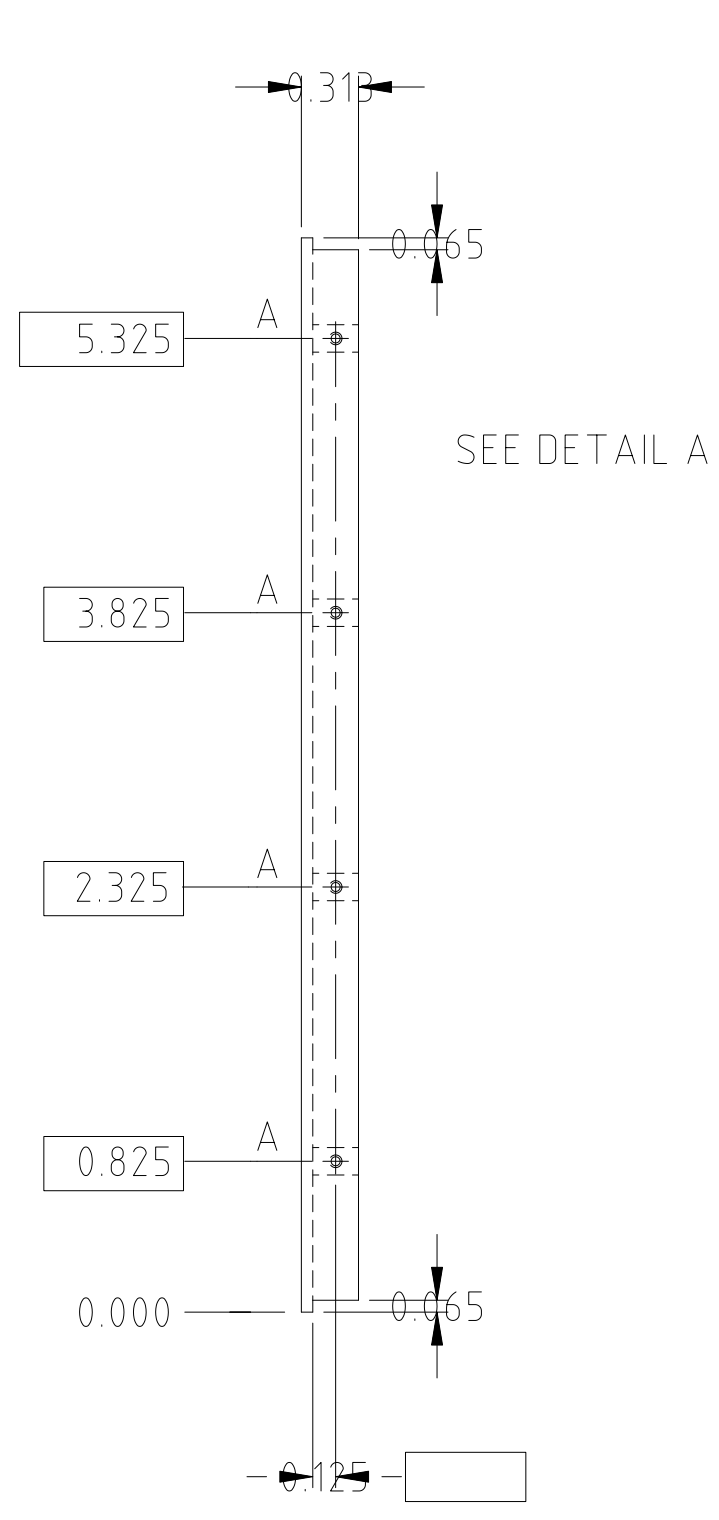


REVISIONS					
REV	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A	36-556	INITIAL RELEASE			

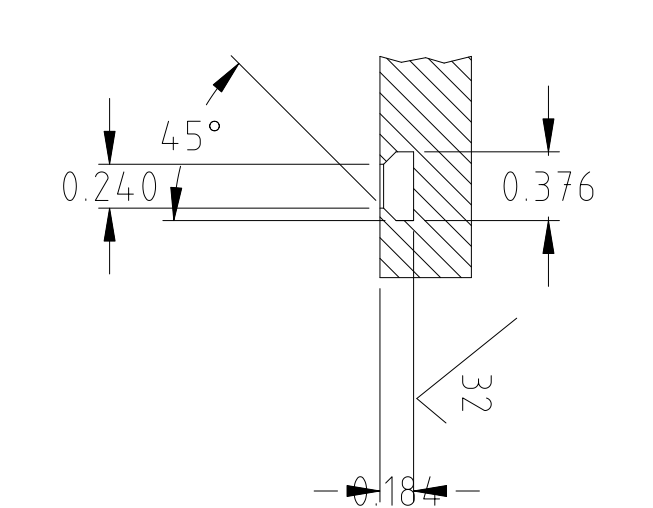
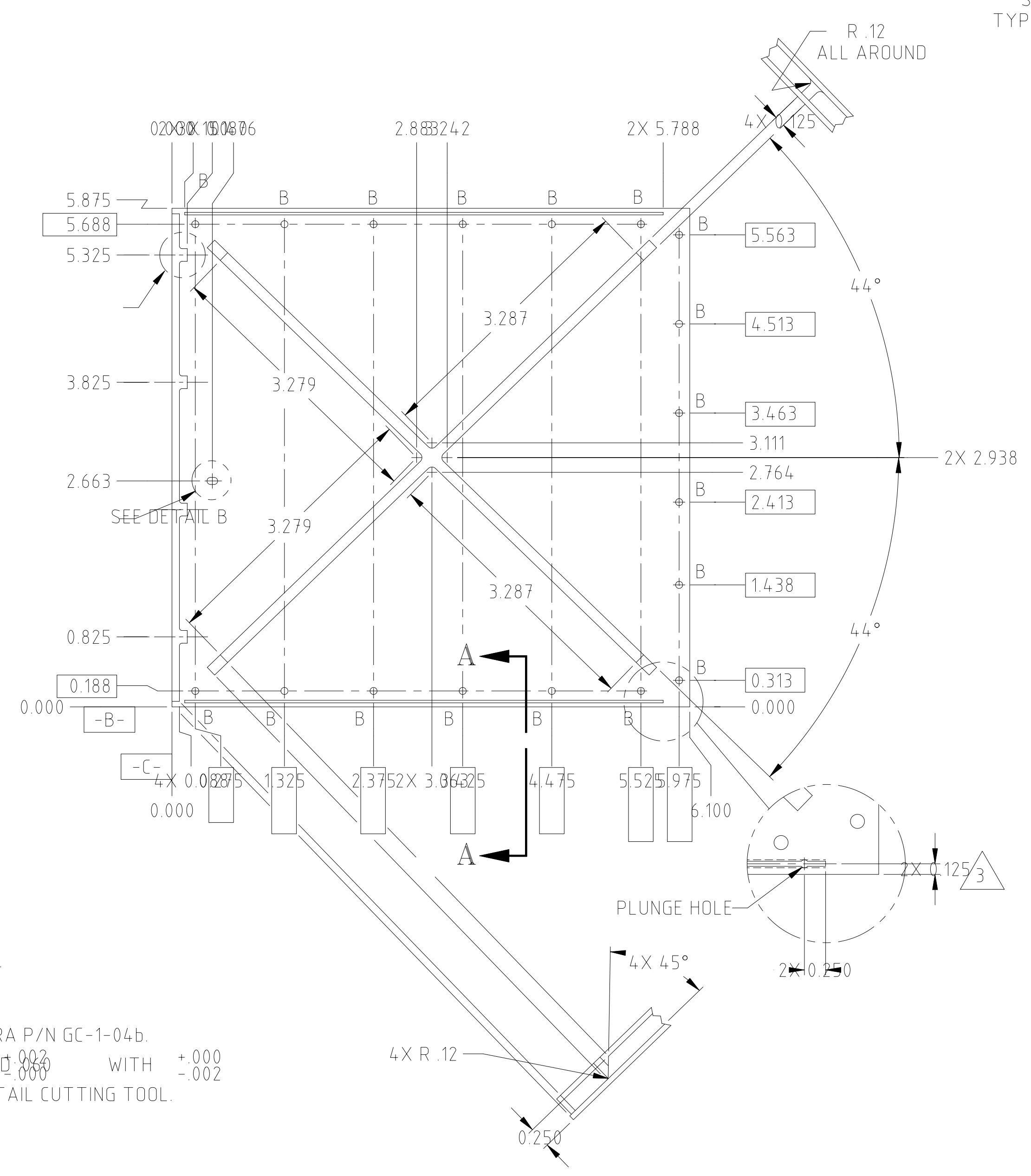


DETAIL A
SCALE: FULL
TYPICAL 3 PLACES

DETAIL B
SCALE: FULL



SEE DETAIL A



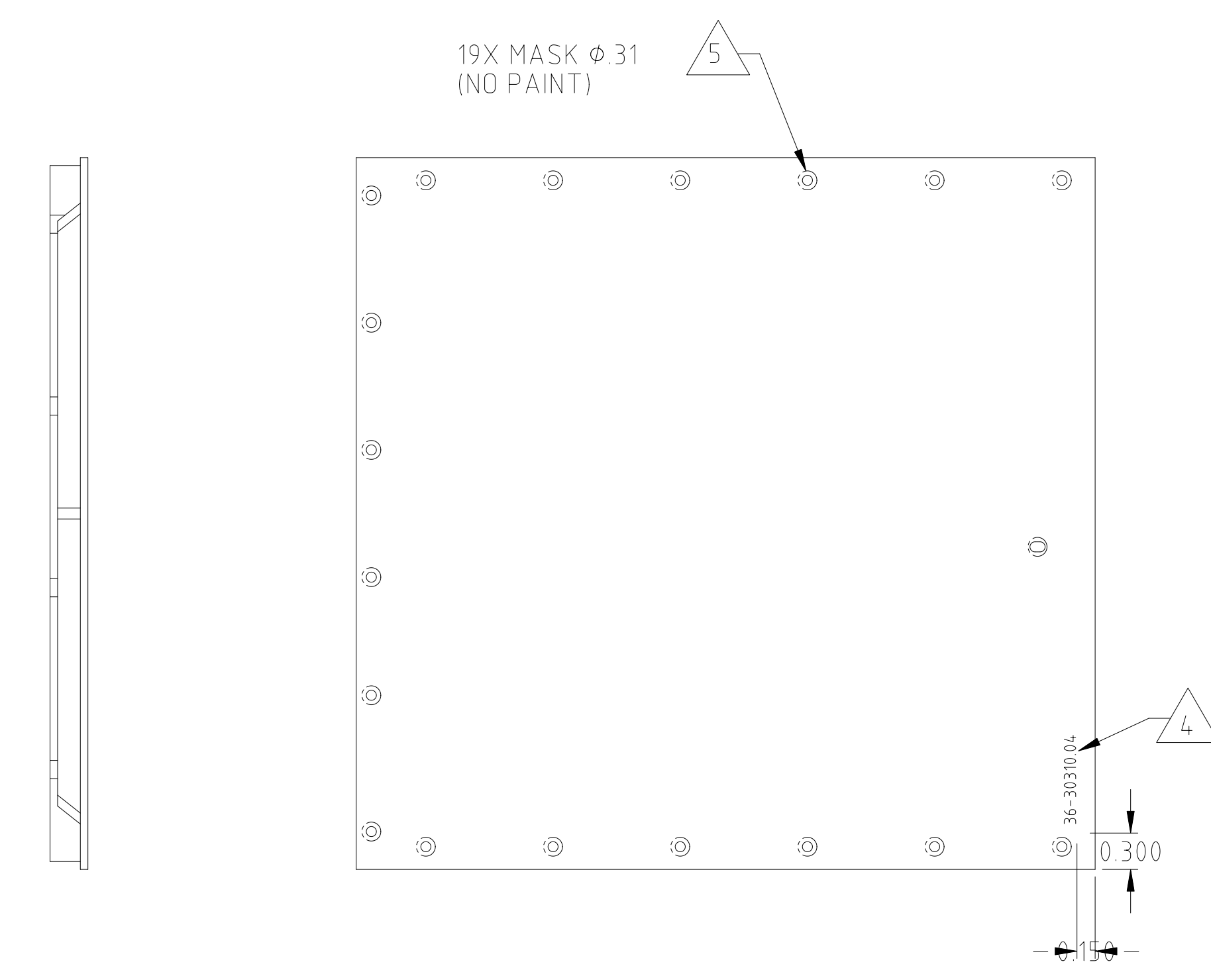
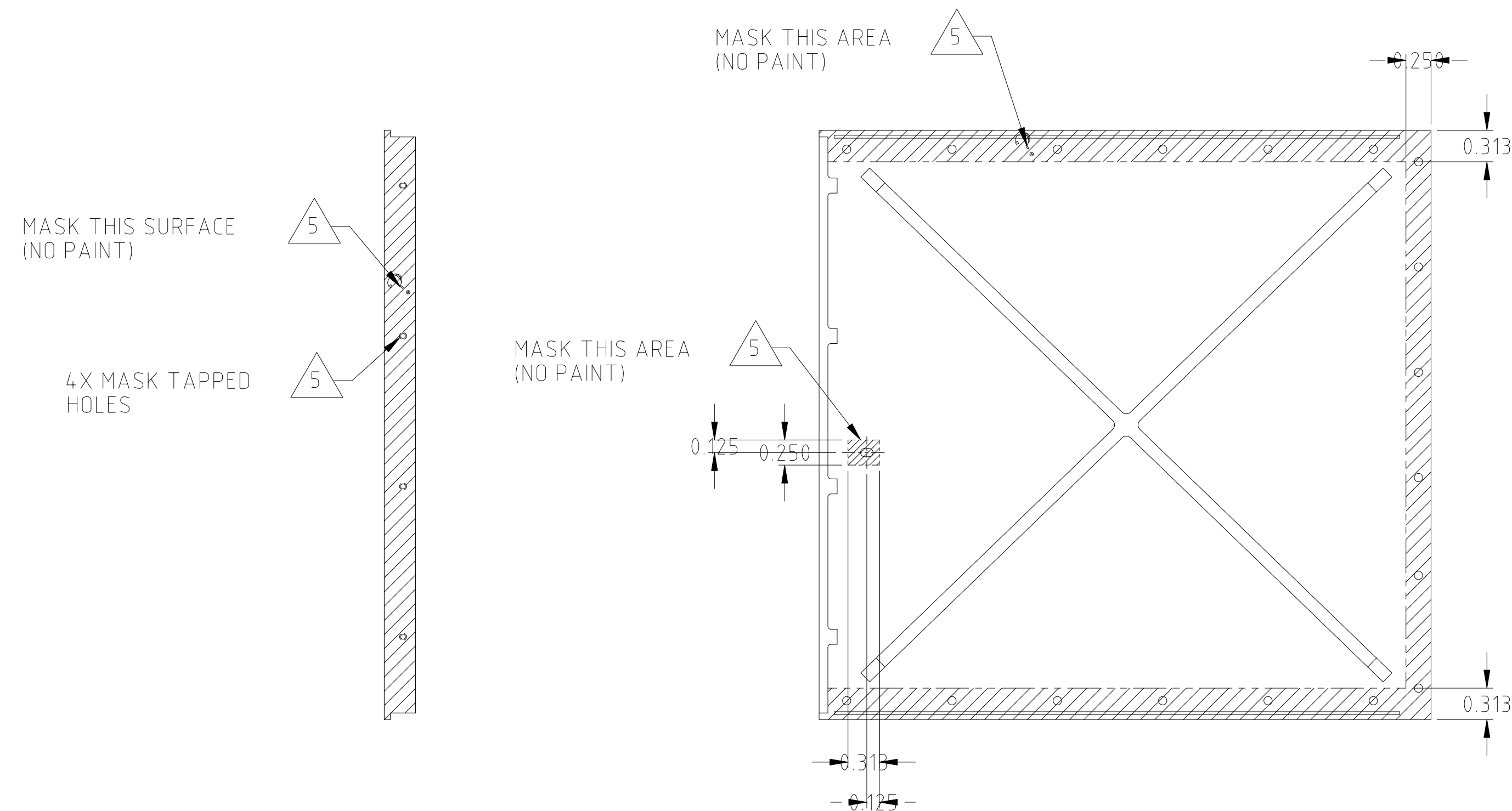
SECTION A-A
SCALE: 4/1
2 PLACES
3

- NOTES:
1. REMOVE BURRS AND SHARP EDGES R .010 MAXIMUM.
 2. UNLESS OTHERWISE SPECIFIED ALL RADII R .12.
 3. SUGGESTED DOVETAIL GROOVE CUTTING TOOL: SPIRA P/N GC-1-04b.
MANUFACTURER SUGGESTS MILLING .046 AND $\frac{.002}{.000}$ WITH $\frac{+.000}{-.002}$ STANDARD TOOL FIRST, THEN FINISH WITH DOVETAIL CUTTING TOOL.
SPIRA MANUFACTURING CORP.
12721 SATICOY STREET SOUTH, UNIT B
NORTH HOLLYWOOD, CA 91605
(818) 764-8222
 4. ENGRAVE OR METAL STAMP USING .19 HIGH CHARACTERS LOCATED APPROXIMATELY SHOWN, PRIOR TO FINISH.
 5. 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).
 6. HANDLE WITH CONTAMINATION FREE, POWDER FREE GLOVES DURING ALL POST-FINISH OPERATIONS.

HOLE CHART		
HOLE	DESCRIPTION	QTY
A	$\phi .147 \begin{smallmatrix} +.003 \\ -.002 \end{smallmatrix}$ THRU, TAP THRU FOR No. 6-32 UNC HELICAL STI. DO NOT INSTALL STI. $\phi .010 \text{ (M) C A B}$	4
B	$\phi .166 \begin{smallmatrix} +.003 \\ -.002 \end{smallmatrix}$ THRU $\phi .010 \text{ (M) A B C}$	18

NAME		DATE		MASSACHUSETTS INSTITUTE OF TECHNOLOGY			
DRAWN M.LYONS		ZEMAR06		CENTER FOR SPACE RESEARCH			
CHECKED				CAMBRIDGE, MA 02139			
APPROVED				COVER, -X, DPA			
RELEASED							
MATERIAL ALUMINUM 6061-T6		SIZE D		CAGE CODE 80230		DWG NO. 36-30310.04	
NEXT ASSEMBLY USED ON		WEIGHT		SCALE 1/2		REV. A	
APPLICATION		INTERPRET DIMENSIONS AND TOLERANCES IAW ANSI Y14.5M-1982		SHEET 1 OF 2			

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



PAINT AND MASKING INFORMATION

SIZE	CAGE CODE	DWG. NO.	REV.
D	80230	36-30310.04	A
SCALE	SHEET		
1/2	2 OF 2		