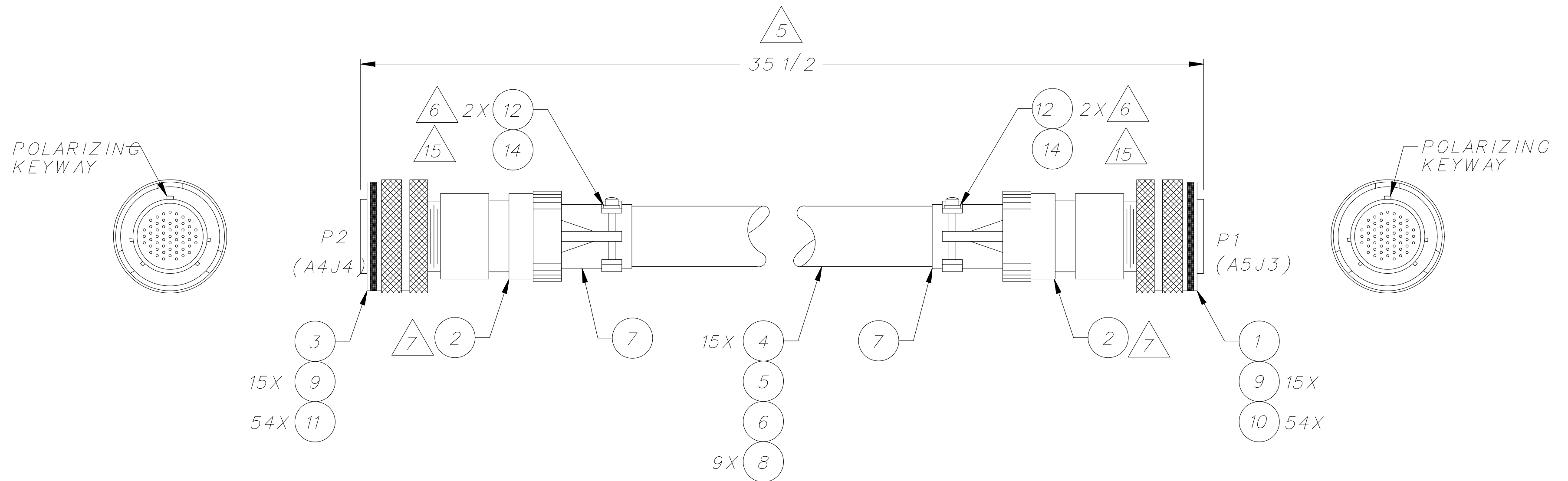


REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
A	36-758	INITIAL RELEASE	FJK	RFG	9/20/96
B	36-899	AS BUILD CONFIGURATION			



NOTES:

- REFER TO MIT DRAWING 36-03020.01 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 HARDWARE SUPPLIED WITH F/N 2 AND SUBSTITUTE F/N 12 AND 14. HAND TIGHTEN AND SPOTBOND WITH F/N 13.
- SECURELY HAND TIGHTEN AND SPOTBOND WITH F/N 13.
- 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.
- BAG AND TAG WITH MIT DRAWING NUMBER AND LATEST REVISION.

NOTES (CONTINUED):

- CLEAN AND VACUUM BAKE F/N 1, 3, 5 AND 6 IAW MIT SPECIFICATION 36-02027 PRIOR TO ASSEMBLY.
- VACUUM BAKE ASSEMBLY AT 100°C FOR 120 HOURS MINIMUM.
- RECORD EPOXIES USED, MIX RATIOS AND EXPIRATION DATES ON "MATERIALS PROCESSING MIXING RECORD" SECTION OF AWO.
- REF DES ON BACK SHELL CLAMP USING F/N 15.

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE: ANGLES ? 1° 3 PLACE DECIMALS ? .005 2 PLACE DECIMALS ? .01	NAME DRAWN M. LYONS	DATE 15 AUG 96	MASSACHUSETTS INSTITUTE OF TECHNOLOGY CENTER FOR SPACE RESEARCH CAMBRIDGE, MA 02139	
			CHECKED F. Kasparian	9/20/96	CABLE ASSEMBLY, SUPPORT STRUCTURE, DIGITAL DATA 1, W5	
		MATERIAL SEE DATABASE	APPROVED R. Goeke	9/20/96	SIZE CAGE CODE C 80230	
36-30400	ACIS		RELEASED D. Gage	9/20/96	DWG. NO. 36-30403	REV. B
NEXT ASSEMBLY	USED ON	INTERPRET DIMENSIONS AND TOLERANCES IAW ANSI Y14.5M-1982	WEIGHT		SCALE NONE	SHEET 1 OF 1
APPLICATION						