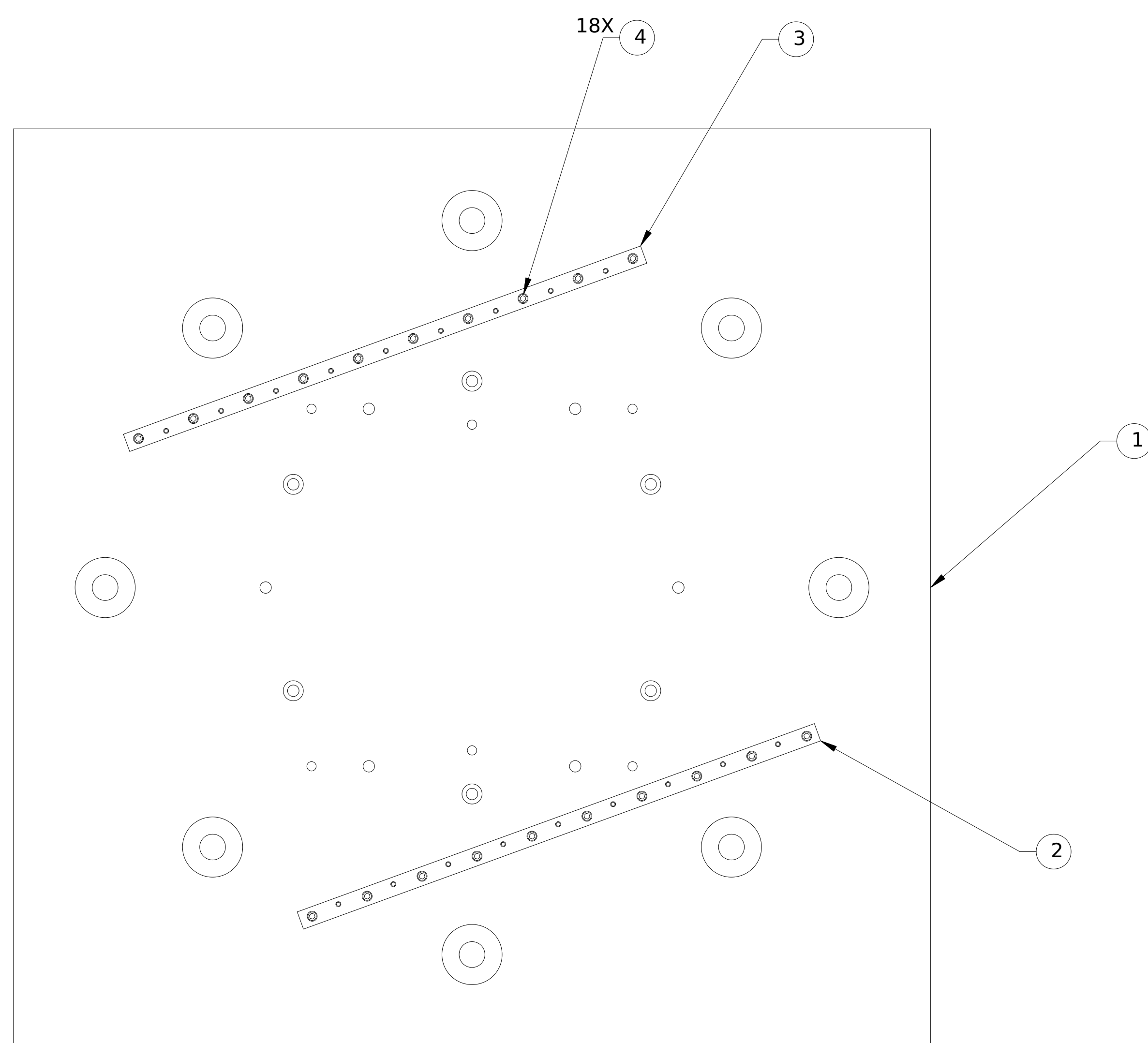


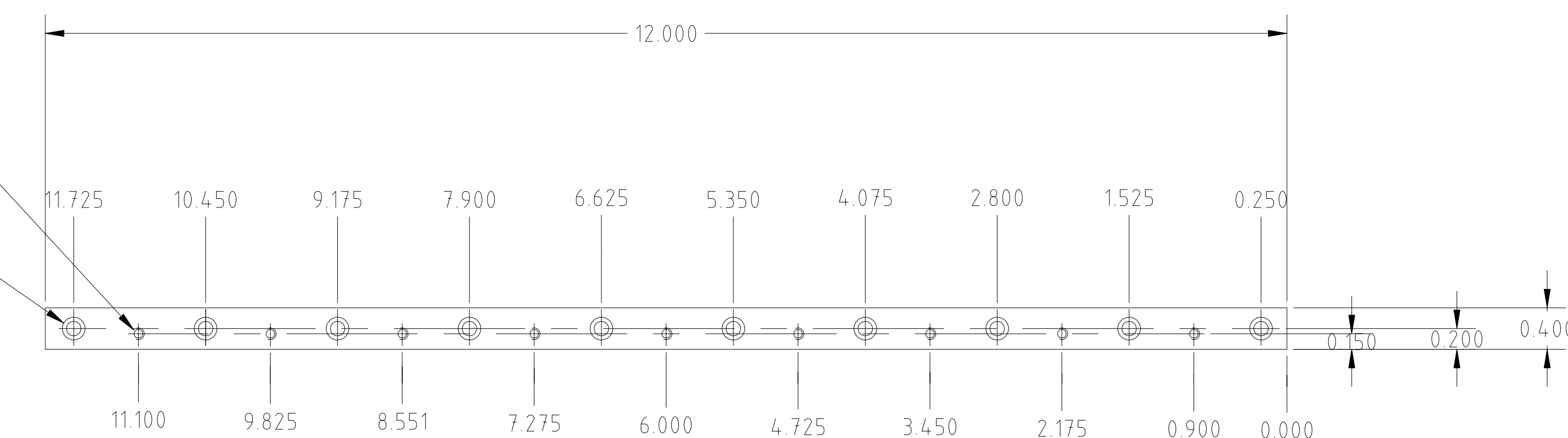
REVISIONS					
REV.	ECO NO.	DESCRIPTION	CHECKED	APPROVED	DATE
01	36-776	RELEASE FOR FABRICATION			



**ASSEMBLY**

9X DRILL  $\phi$  .120  $\begin{matrix} +.003 \\ -.002 \end{matrix}$ ,  $\phi$ .16  $\pm$ .015 X 120°  $\pm$ 5°  
 TAP .140 DP. MIN. FOR #4-40 UNC HELICOIL STI.  
 INSTALL INSERT (F/N 6) 3/4 - 1 1/2 PITCH BELOW SURFACE.

9X DRILL  $\phi$ .134-.139 THRU,  
 C'BORE  $\phi$ .219 X .13 DEEP

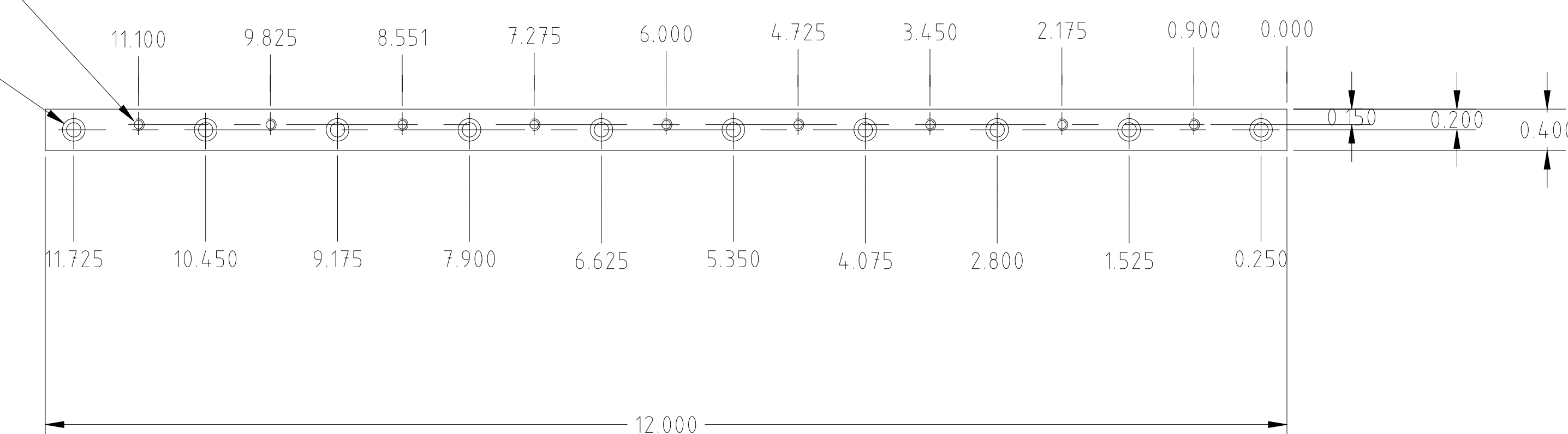


**UPPER RAIL (F/N 3)**

MAT'L: ALUMINUM, 6061-T6 .50 SQUARE BAR

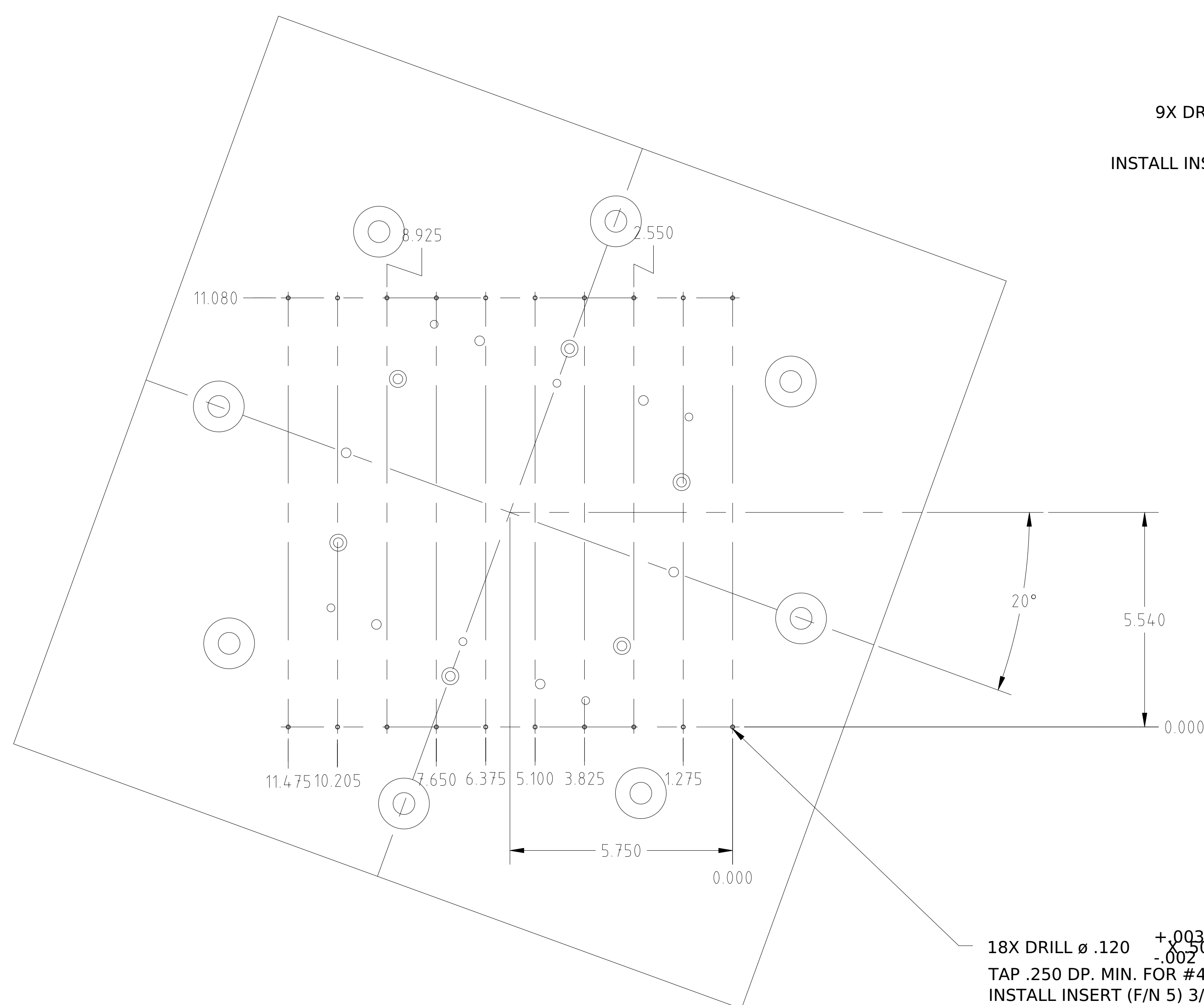
9X DRILL  $\phi$  .120  $\begin{matrix} +.003 \\ -.002 \end{matrix}$ ,  $\phi$ .16  $\pm$ .015 X 120°  $\pm$ 5°  
 TAP .140 DP. MIN. FOR #4-40 UNC HELICOIL STI.  
 INSTALL INSERT (F/N 6) 3/4 - 1 1/2 PITCH BELOW SURFACE.

9X DRILL  $\phi$ .134-.139 THRU,  
 C'BORE  $\phi$ .219 X .13 DEEP



**LOWER RAIL (F/N 2)**

MAT'L: ALUMINUM, 6061-T6 .50 SQUARE BAR



**FIXTURE MODIFICATION**

18X DRILL  $\phi$  .120  $\begin{matrix} +.003 \\ -.002 \end{matrix}$  X .500 DEEP,  $\phi$ .16  $\pm$ .015 X 120°  $\pm$ 5°  
 TAP .250 DP. MIN. FOR #4-40 UNC HELICOIL STI.  
 INSTALL INSERT (F/N 5) 3/4 - 1 1/2 PITCH BELOW SURFACE.

INTERPRET DIMENSIONS AND TOLERANCES IN ACCORDANCE WITH ANSI Y14.5M-1982		NAME F. KASPARIAN	DATE 9/27/96	MASSACHUSETTS INSTITUTE OF TECHNOLOGY CENTER FOR SPACE RESEARCH CAMBRIDGE, MA 02139
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE $\pm$ 1/3 PLACE DECIMALS = .005 2 PLACE DECIMALS = .01		CHECKED	APPROVED	
MATERIAL XTE		RELEASED	WEIGHT	FEP CCA VIBRATION TEST FIXTURE
NEXT ASSEMBLY	USED ON	SCALE 1/1	SIZE CAGE CODE E 80230	
APPLICATION		SHEET 1 OF 1		REV. 01