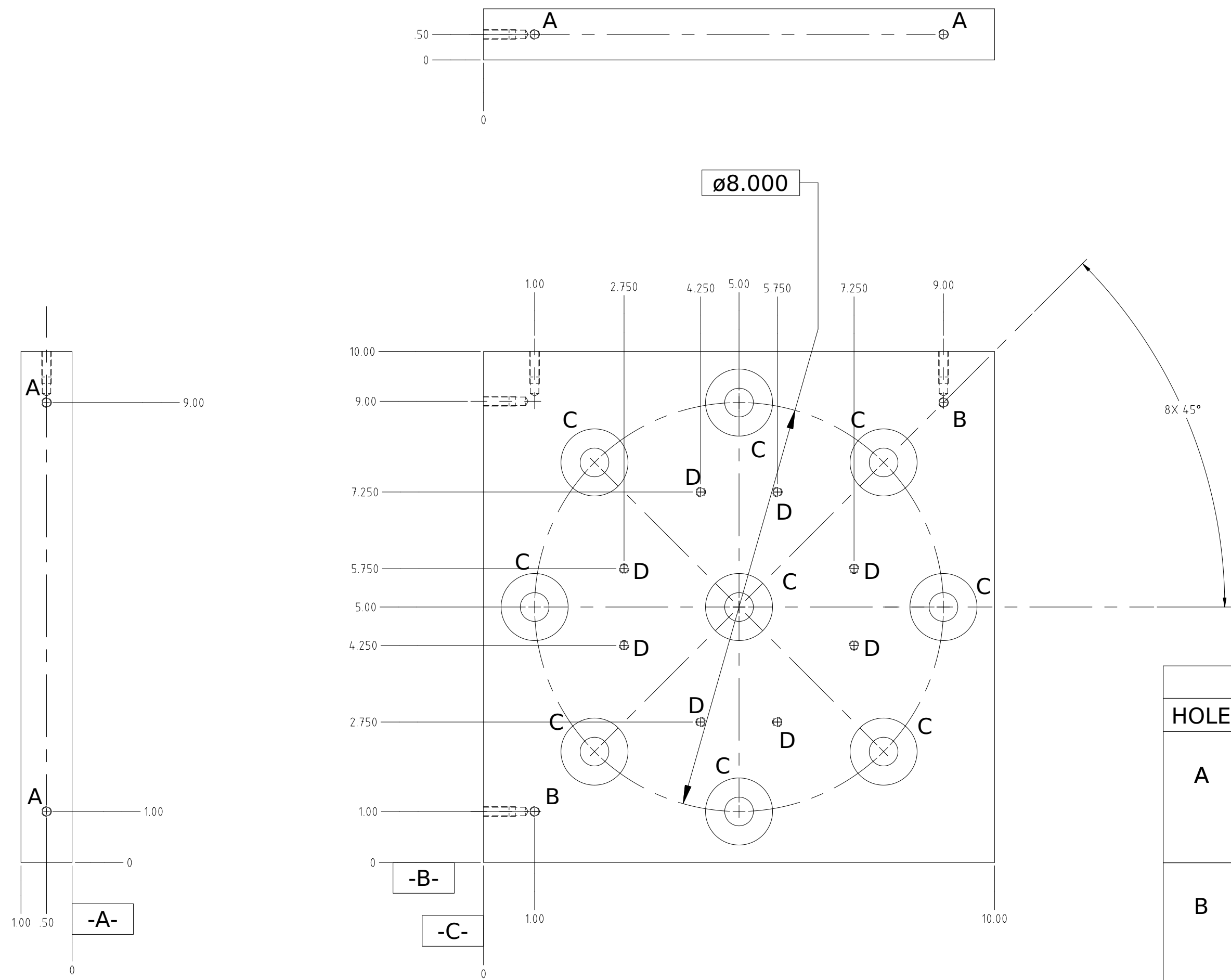


REVISIONS					
REV.	ECO NO.	DISCRIPTION	CHECKED	APPROVED	DATE



HOLE CHART		
HOLE	DESCRIPTION	QTY
A	$\varnothing.199-.204 \times .662$, $120 \pm 5^\circ \times \varnothing.23-.26$ TAP .190-32UNC-2B HELICOIL STI THREAD $\nabla.410$ MIN FULL THREAD DEPTH. INSTALL FN2.	4 3
B	$\varnothing.199-.204 \times$ THRU, $120 \pm 5^\circ \times \varnothing.23-.26$ TAP .190-32UNC-2B HELICOIL STI THREAD $\nabla.410$ MIN FULL THREAD DEPTH. INSTALL FN2.	2 3
C	$\varnothing.560-.565 \times$ THRU, $\varnothing.010$ (M) A B C $\varnothing.1.312 \times .650$	9
D	$\varnothing.199-.204 \times$ THRU, $120 \pm 5^\circ \times \varnothing.23-.26$ TAP .190-32UNC-2B HELICOIL STI THREAD $\nabla.410$ MIN FULL THREAD DEPTH. INSTALL FN2. $\varnothing.010$ (M) A B C	8 3

NOTES:

1. DEBURR AND BREAK SHARP EDGES.
2. MACHINED SURFACES 125 MAX. EXCEPT AS NOTED.
3. AFTER FINISH AND CLEANING, INSTALL INSERTS .75-1.50 PITCH BELOW THE SURFACE. REMOVE THE TANG.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE: ANGLES $\pm 1^\circ$ 3 PLACE DECIMALS $\pm .005$ 2 PLACE DECIMALS $\pm .01$		NAME	DATE	MASSACHUSETTS INSTITUTE OF TECHNOLOGY CENTER FOR SPACE RESEARCH CAMBRIDGE, MA 02139	
MATERIAL		DRAWN	P.C.Tappan	EXTERNAL CAL. SOURCE LOWER SHAKE FIXTURE	
AZ31B MAGNESIUM		CHECKED		SIZE	C
NEXT ASSEMBLY		APPROVED		FSCM NO.	80230
ACIS		RELEASED		DWG. NO.	36-60404
USED ON		WEIGHT		REV.	01
APPLICATION				SCALE	1/2
				SHEET	1 OF 1