










-  REMOVE TOP COVER AND RETAIN HARDWARE. REINSTALL AFTER FINAL ASSEMBLY. TORQUE HARDWARE TO 48 IN OZ AFTER FINAL ACCEPTANCE TESTING. SPOT BOND USING F/N 14.
-  FEED CONNECTOR FROM F/N 1 THROUGH OPENING IN F/N 2. SECURE F/N 1 TO F/N 2 USING F/N'S 3,4 AND 15. ENSURE F/N 16 IS IN BETWEEN F/N'S 1 AND 2 PRIOR TO ASSEMBLY. MATE CONNECTOR FROM F/N 1 TO THE ANALOG BOARD IN F/N 2 AND SECURE WITH HARDWARE SHOWN. SECURE CABLE TO THE EXISTING CABLE BLOCK USING F/N 10.
-  TORQUE #2-56 HARDWARE TO 48 IN-OZ. DO NOT SPOT BOND.
-  TORQUE 4-40 HARDWARE TO 5 IN-LBS. SPOT BOND USING F/N 14.
-  TORQUE 6-32 HARDWARE TO 25 IN-LBS. SPOT BOND USING F/N 14.

-  CHECK ELECTRICAL ISOLATION BETWEEN F/N 1 AND 2 FOR RESISTANCE GREATER THAN 1 MEGAOHM.
-  TORQUE NUT FROM F/N 11 TO 35 IN-LBS. SPOT BOND USING F/N 14.
-  INSTALL F/N 13 AND 18 DURING STORAGE AND SHIPPING. REMOVE F/N 17, 13 AND 18 DURING TEST AND UPON INTEGRATION.
-  CUT F/N 12 TO FIT. TORQUE SWAGelok FITTING ON F/N 12 TO __ IN-LBS. SPOT BOND BOTH ENDS.

DETAIL D
SCALE 2 : 1

SECTION A-A
SCALE 1 : 2

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UNLESS OTHERWISE SPECIFIED:		NAME	DATE	MIT/BU CRATER PROJECT
DIMENSIONS ARE IN INCHES		M. SMITH		TITLE:
TOLERANCES:				CRATER ASSEMBLY
FRACTIONAL: \pm				SIZE DWG. NO. D 32-10000 REV 01
ANGULAR: MATCH BEND \pm				SCALE: 1:10 WEIGHT: SHEET 1 OF 1
TWO PLACE DECIMAL: \pm				
THREE PLACE DECIMAL: \pm				
INTERPRET GEOMETRIC TOLERANCING PER:				
MATERIAL:				
DATE				
APPRECIATION				
USED ON				
FINISH				
COMMENTS:				