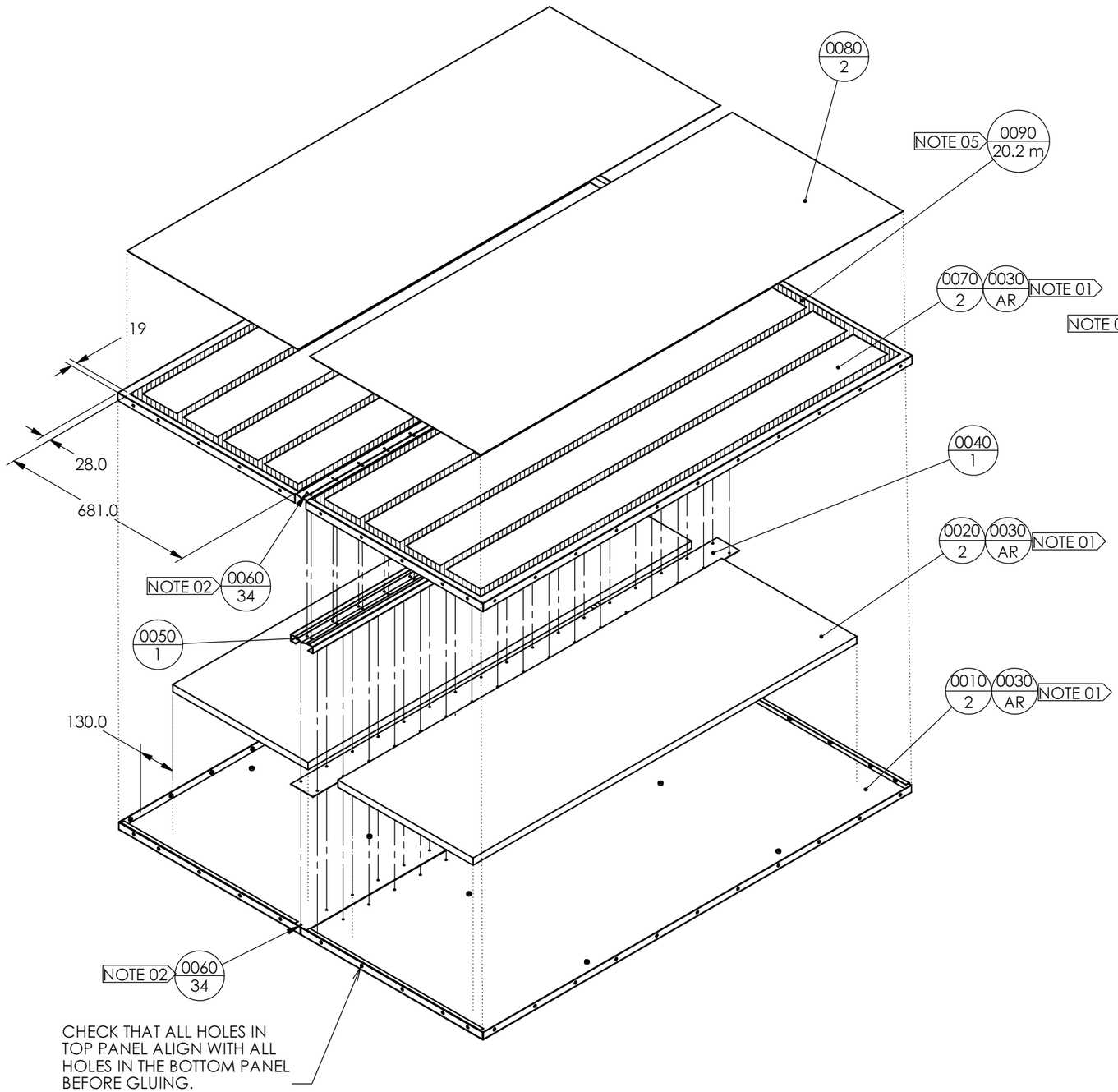
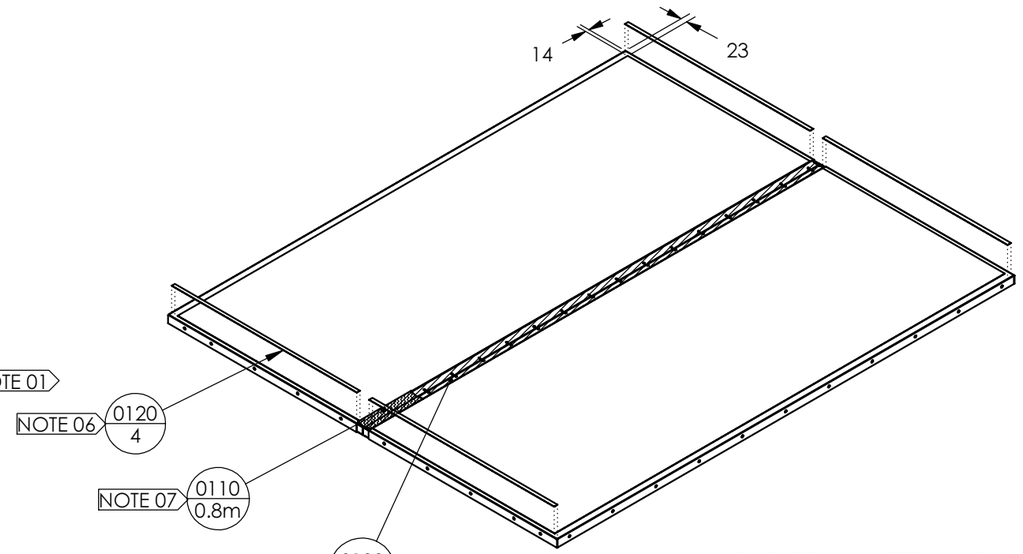
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ASSEMBLED ISOMETRIC VIEW
SCALE 1:16

ASSEMBLY NOTES:

1. CLEAN ALL MATING SURFACES WITH ISOPROPYL ALCOHOL. APPLY CEMENT [ITEM 0030] TO INNER SURFACES OF UPPER AND LOWER SKIN PANELS AND MATCHING FACE OF STYROFOAM SHEETS. ALLOW TO SET FOR 30 - 40 MINUTES BEFORE BRINGING PIECES TOGETHER. CENTER FOAM VERTICALLY AND POSITION FOAM OUTER EDGE 130mm FROM OUTSIDE EDGE OF BASE. APPLY 9 Kg (20 IB) ROLLING PRESSURE FROM THE OUTSIDE INWARDS OVER THE METAL SURFACE TO ENSURE PROPER CONTACT ADHESION.
2. RIVET CENTER SPLICE SECTION TOGETHER. INSERT TWO SCREWS ON EACH SIDE OF THE ASSEMBLED PANEL TO PREVENT DELAMINATION STRESSING.
3. NOTE THAT THE ASSEMBLY IS SYMETRIC.
4. CUT UHMW ANTISTATIC TAPE [ITEM 0100] TO LENGTH AND APPLY OVER RIVETS TO INNER EDGE OF SPLICE PANEL.
5. CUT DOUBLE SIDED TAPE [ITEM 90] AND APPLY AS SHOWN. THE 5 VERTICAL PIECES ARE EQUALLY SPACED.
6. CUT SCALES AT 23mm AND 725mm. AFFIX SCALES TO TOP AND BOTTOM MARGINS (OFF ARBORITE) SUCH THAT THE 23mm MARK IS 23mm FROM THE CASSETTE CENTERLINE, FOUR PLACES.
7. CUT REFLECTIVE TAPE INTO TWO 200mm PIECES AND APPLY TO SIDES OF CENTER GROOVE AS SHOWN.

INTERPRET GD&T PER ANSI Y14.5M - 1994

FINISH
NONE REQ'D

MATERIAL
AS PER ASSY.

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B	PR	1999:JULY:09	N/A	N/A
REV	ECO	DATE	DRAWING CHANGES BY	APPROVED BY

UNLESS SPECIFIED ALL MACHINED SURFACES TO BE 3.2

TOLERANCES UNLESS NOTED

LINEAR		ANGULAR °	
X.	±	X.	±
X.X	±	X.X	±
X.XX	±	X.XX	±
X.XXX	±	90°	±

THIRD ANGLE PROJECTION

CREO

5467 CASSETTE BASE ASSY.
VAL

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DESIGNED BY: NITA
DRAWN BY: M.HERBERT
MILLIMETERS UNLESS SPECIFIED
DATE: 2000:FEB:02
SIZE: B
SCALE: 1:1
PART NO.: 50-1807A — B
REV: AD
DOC
SHEET: 1
OF: 1