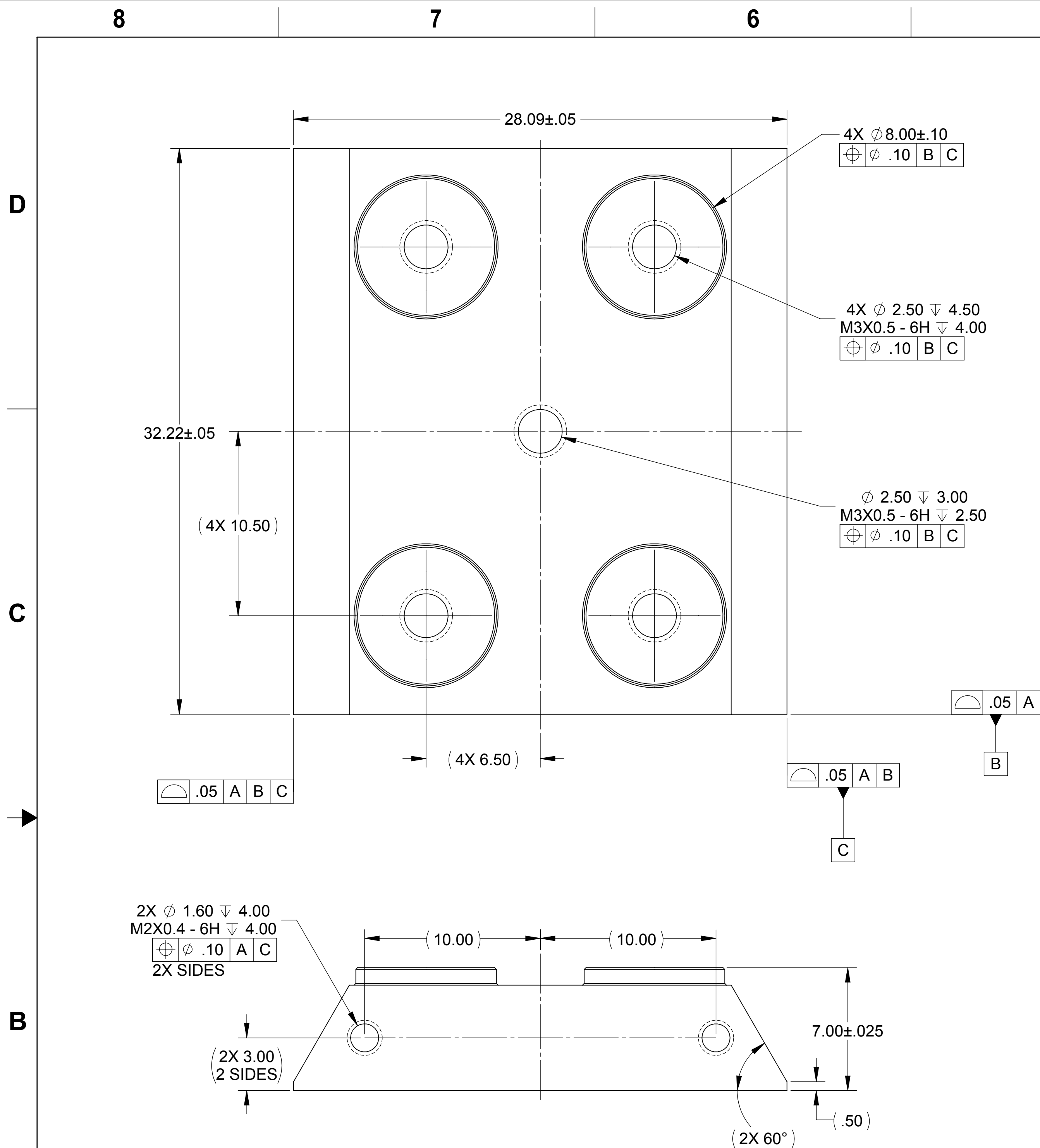
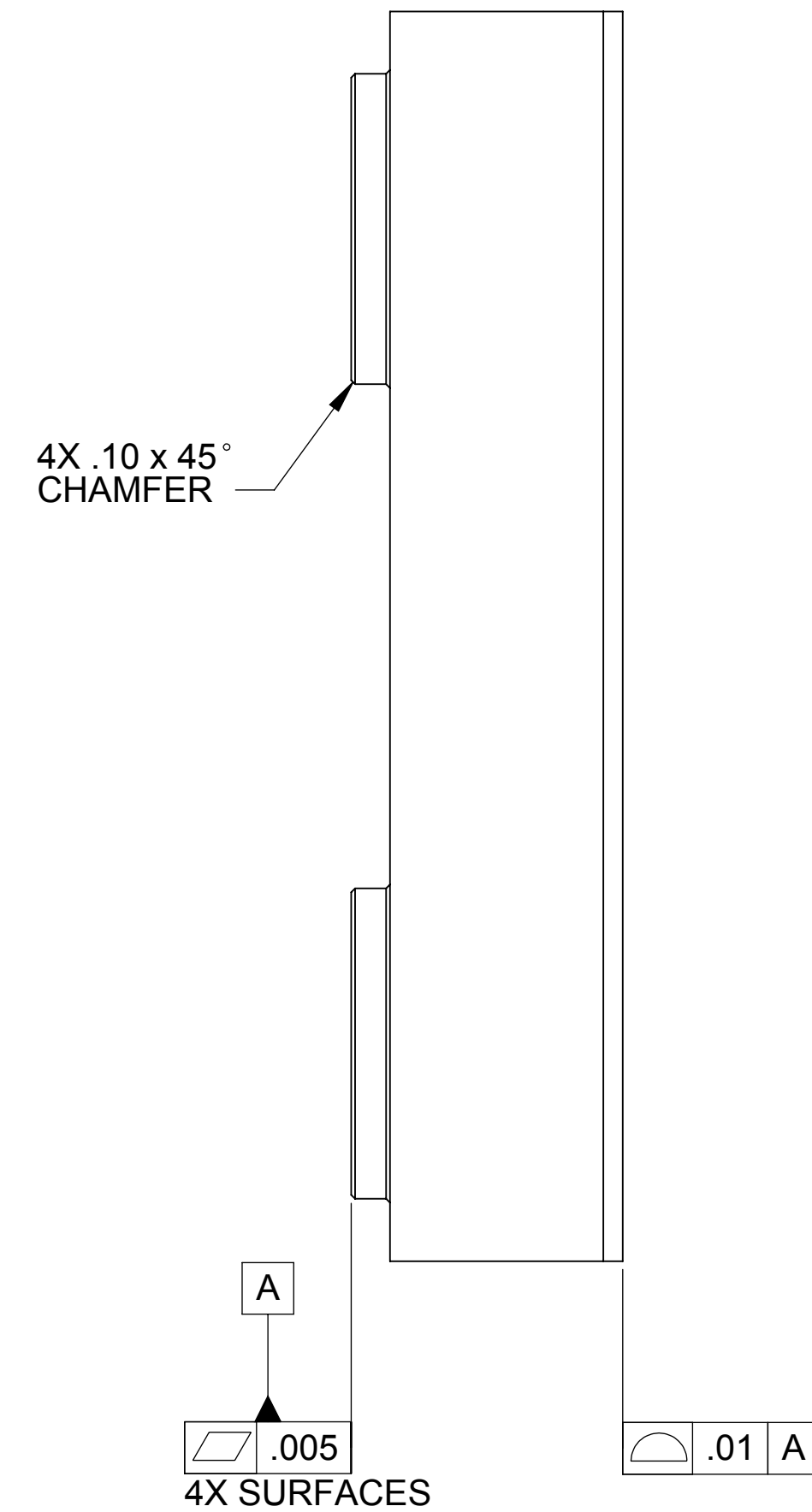
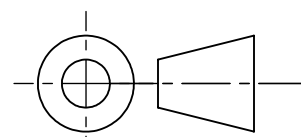




1. DIMENSIONS APPLY AFTER PLATING
2. ROUGH MACHINE TO WITHIN .25 MM OF FINAL DIMENSIONS
3. STRESS RELIEF ANNEAL AND CRYOGENIC SOAK
4. ELECTROLESS NICKLE PLATE PER MIL-C-26074 TO 2.5-4 MICRONS
5. GOLD PLATE PER MIL-G-45204C TYPE 1 GRADE A CLASS-1 1. 3 MICRONS MINIMUM THICKNESS
6. STABILIZE FOLLOWING PLATING AT 93C FOR 48 HOURS. ALLOW FURNACE TO COOL TO ROOM TEMPERATURE. RAMP RATE FOR HEATING OR COOLING SHALL NOT EXCEED 111C PER HOUR

REVISION HISTORY																				
LTR	ZONE	DESCRIPTION					CLASS	DWN	CHK	STRUCT	MATL	THRM	SUPV			ENGR	DSGN	DATA	RELEASE DATE	
A	-	INITIAL RELEASE					E	SEE PRODUCT DATA MANAGEMENT SYSTEM (PDMS) FOR APPROVAL SIGNATURES AND DATES												
B		EDITED SIZE OF BOSSES IN ZONE "D7"					E													



		ITEM NO	REF DES	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	SPECIFICATION	MATERIAL OR NOTE	ZONE	
PARTS LIST										
MATERIAL:		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MM			CONTRACT NO _____		JET PROPULSION LABORATORY CALIFORNIA INSTITUTE OF TECHNOLOGY PASADENA, CA 91109			
INVAR 36 PER ASTM-F-1684 UNS										
THIRD ANGLE PROJECTION					APPD _____ DATE _____					
					SEE PDMS FOR APPROVAL SIGNATURES AND DATES					
							DWN			
		CHK								
		STRUCT		PACKAGE BASE						
		MATL								
		THIRM								
		CONT								
		ENGR								
		SUPV		SIZE D		CAGE CODE 23835		10371432		REV B
				SCALE: 4:1				SHEET 1 OF 1		

[illegible]

REV 2011/06