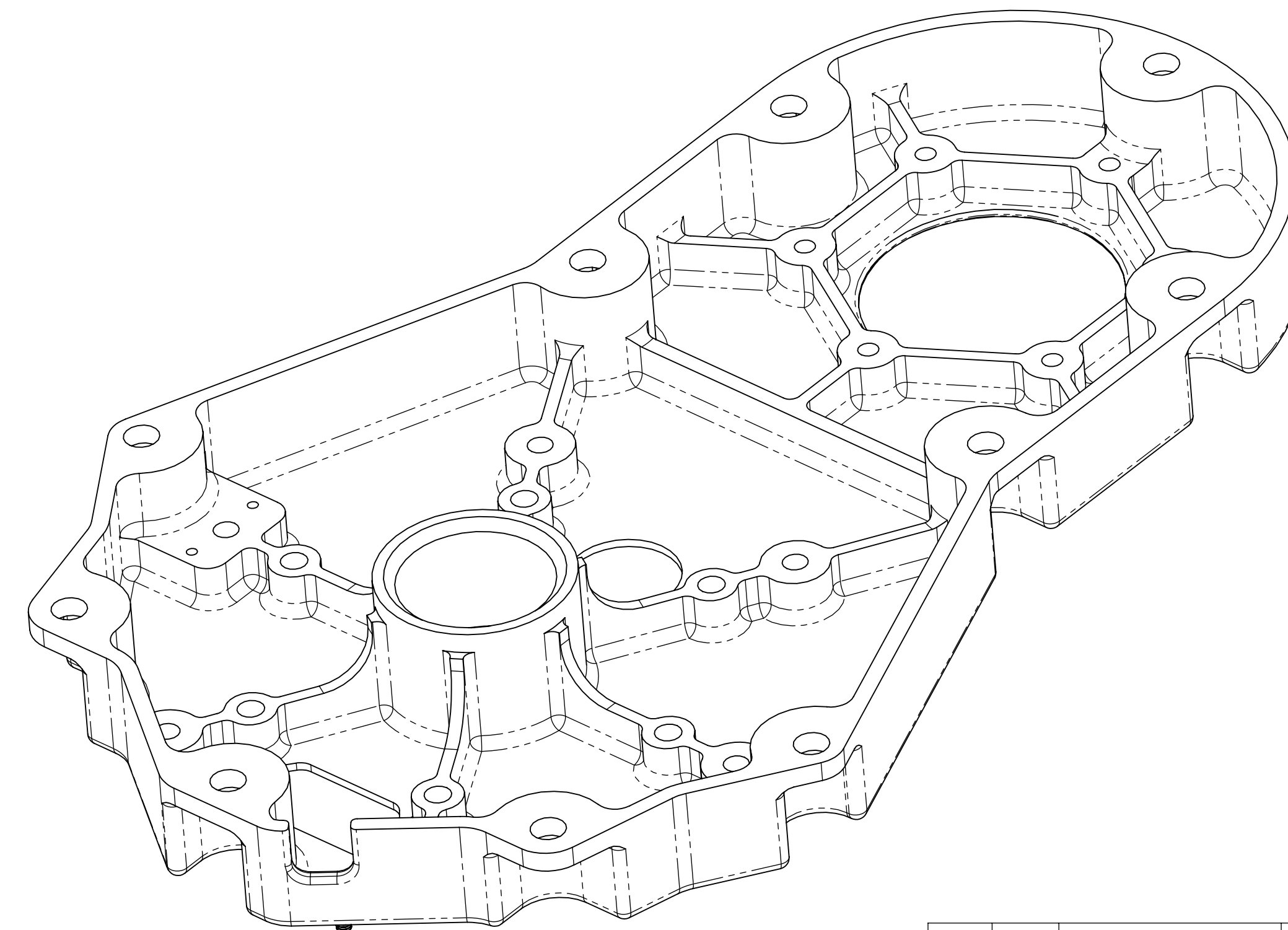
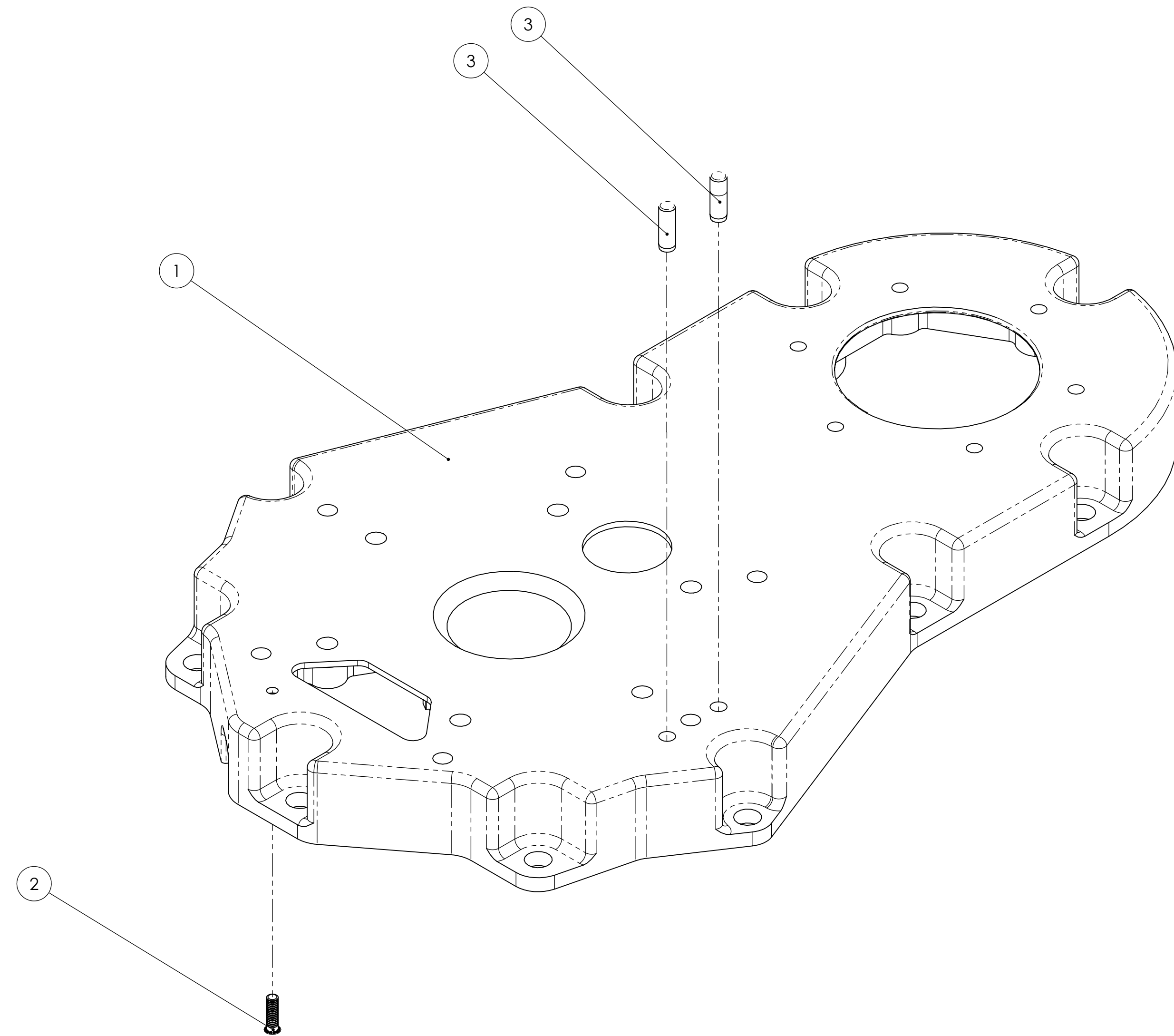


REVISIONS				
REV.	DESCRIPTION	DWN	CHK	DATE
-	INITIAL RELEASE PER ECO #02072.	JBF		12/19/08
A	DECREASED STRUT ARCH RADIUS FROM .330 TO .313. REPLACED Ø.150 THRU HOLE WITH 6TH #6-32 HELICOIL. ADDED PEM STUD FOR GROUNDING ELECTRICAL HARNESS SHIELD. ALL PER ECO #02280.	JBF		2/4/09
B	CHANGED PINS FROM NAS607-2-4 (.500" LONG, INCORRECTLY LABELED AS .250") TO NAS607-2-3 (.375" LONG) PER ECO #02509.	JBF		4/8/09



NOTES

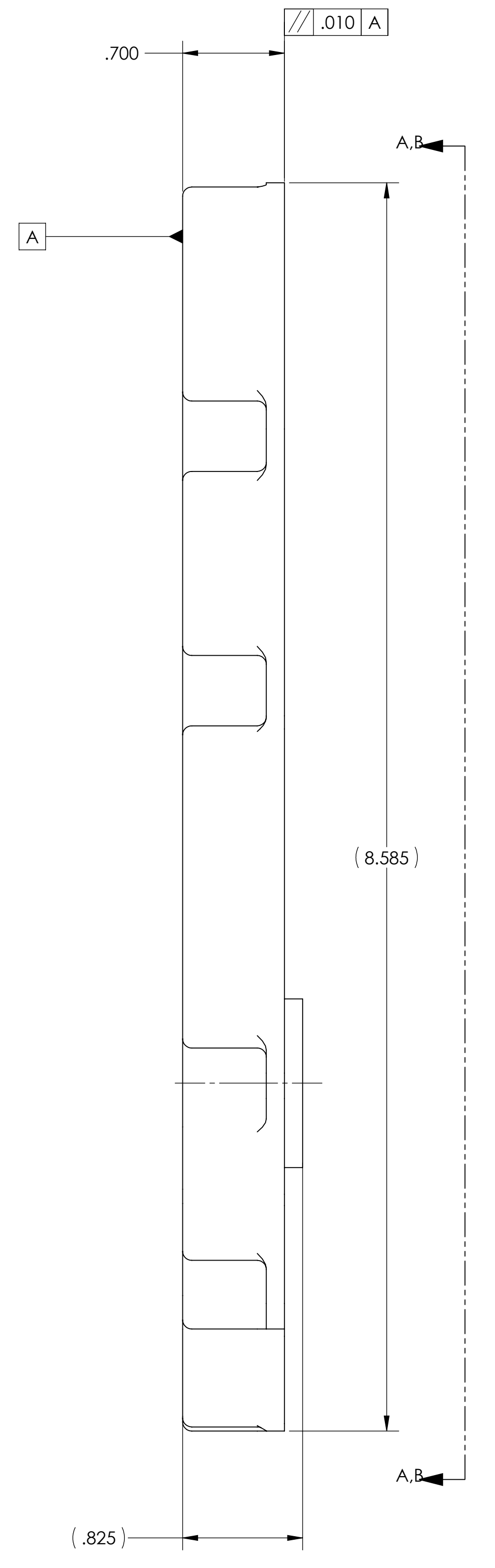
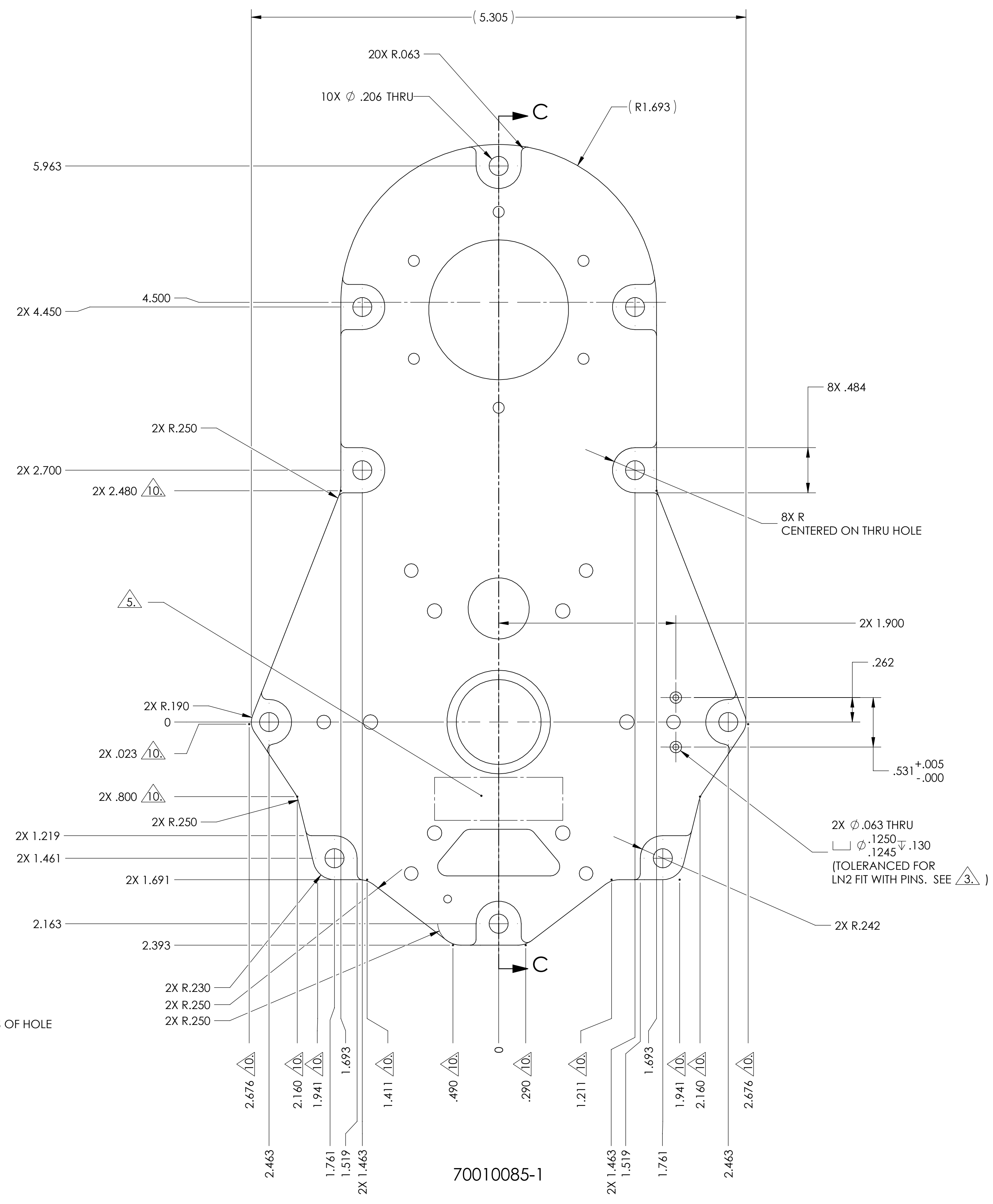
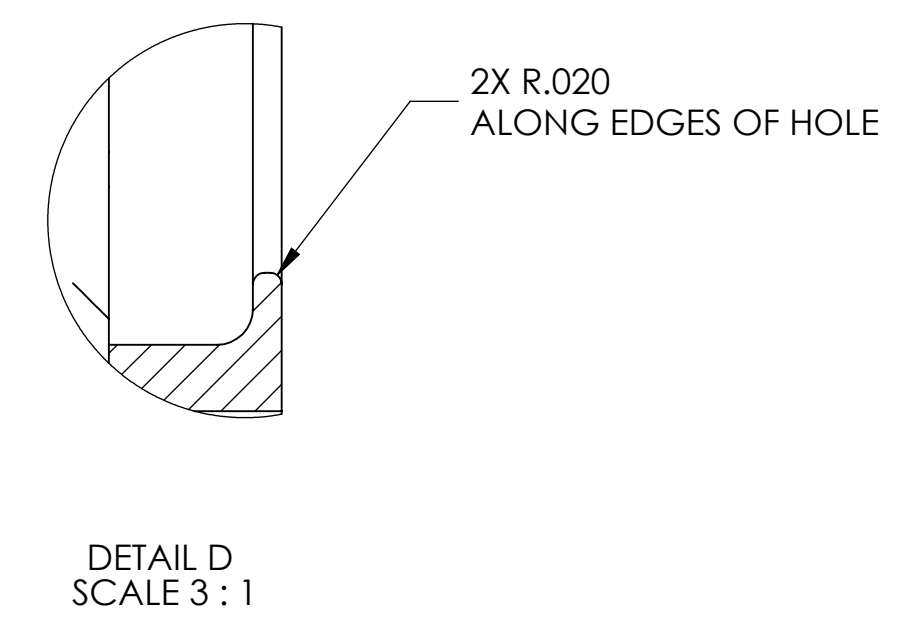
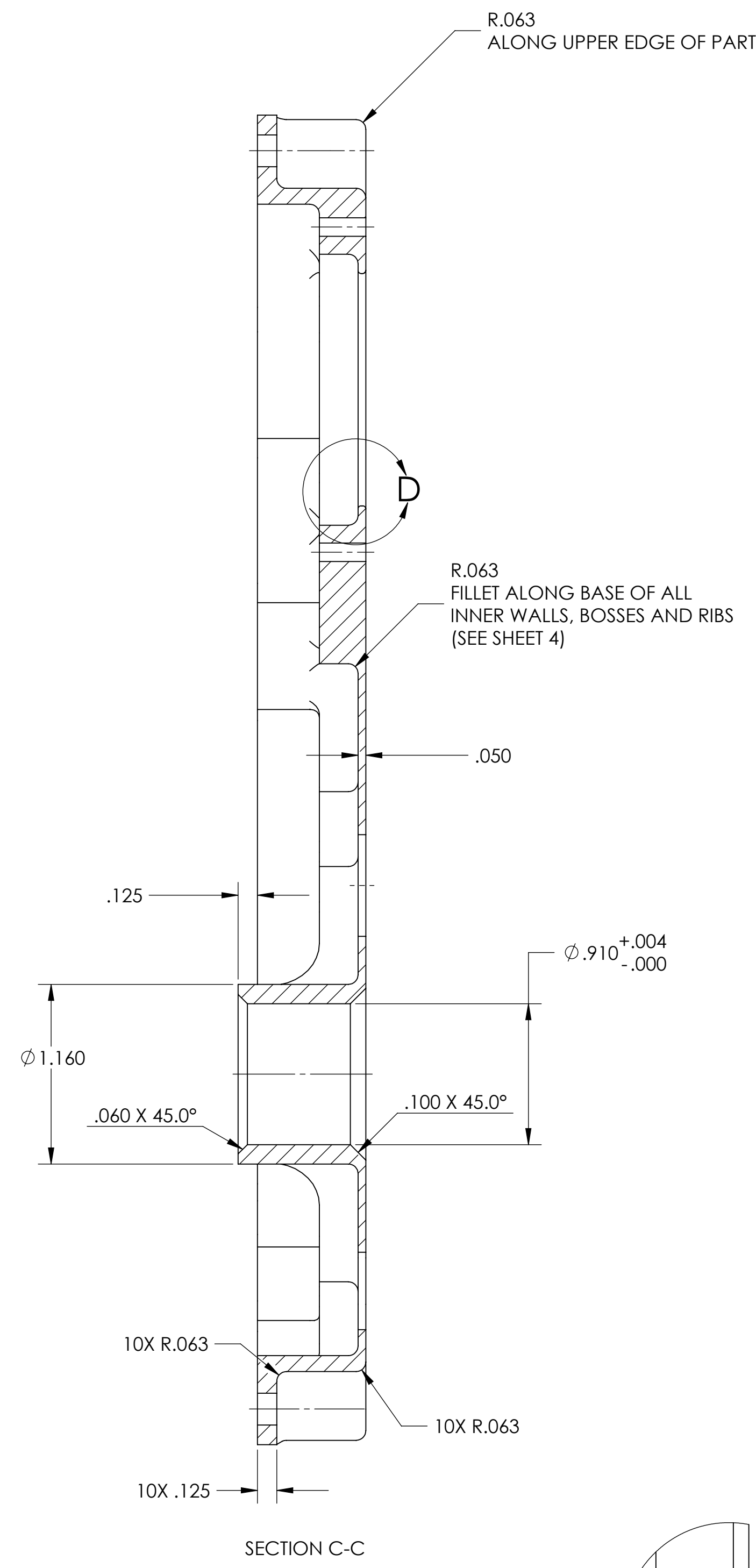
-UNLESS OTHERWISE SPECIFIED-

- 1. MATERIAL: 6061-T6 ALUMINUM PER SAE AMS-QQ-A-200/8, MATERIALS CERTIFICATE REQUIRED
- 2. FINISH: $\sqrt{32}$, VIBRATORY FINISH PER PROCEDURE 70006256, CHROMATE CONVERSION COAT PER MIL-C-5541, CL3, COLOR: GOLD.
- 3. PRESS FIT PINS INTO PART AFTER CHROMATE CONVERSION
- 4. AFTER APPLICATION OF FINISH PER NOTE 2 INSTALL HELICAL COIL INSERTS (ITEMS 3 AND 4) PER NASM33537
- 5. MARK PER BUSEK PROCEDURE 70000060, APPX WHERE SHOWN
- 6. INSTALL PEM STUD AFTER CHROMATE CONVERSION.
- 7. BREAK ALL EDGES .005 MAX, INTERNAL RADII R.01 MAX
- 8. NOT FOR MANUFACTURING UNLESS STAMPED AND ANNOTATED WITH PRODUCTION ORDER NUMBER
- 9. BAG AND TAG WITH PART NUMBER, REV, AND PRODUCTION ORDER NUMBER
- 10. DIMENSIONED TO THEORETICAL INTERSECTION.
- 11. CLEAN PER PROCEDURE 70000083

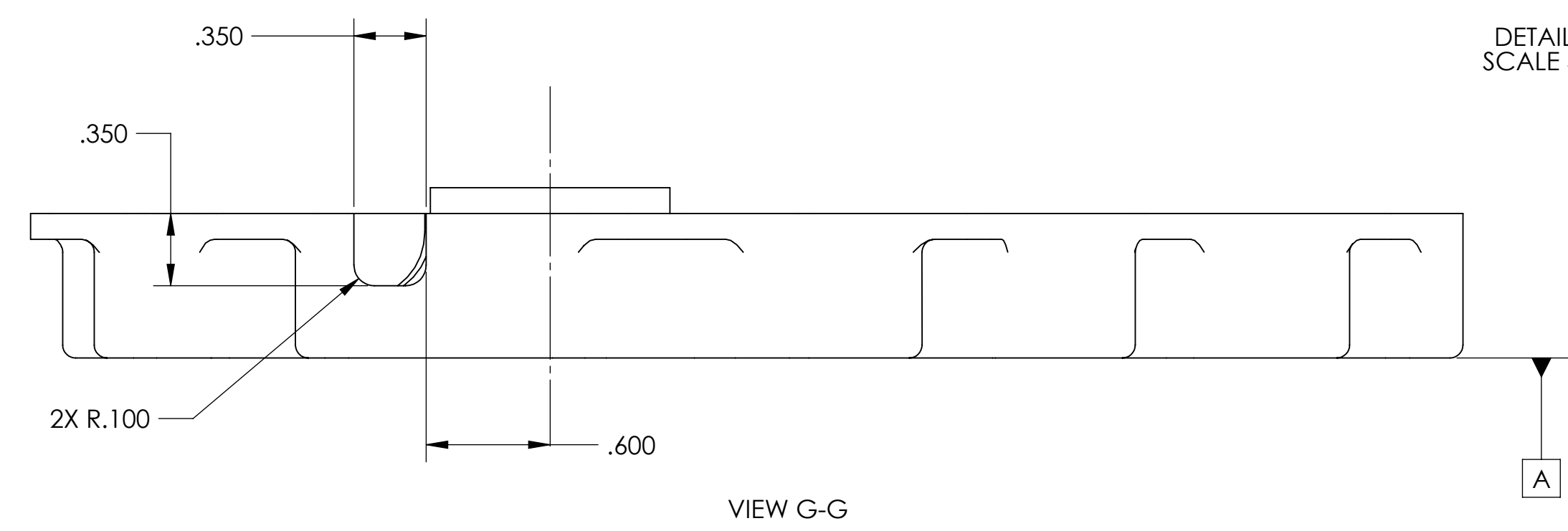
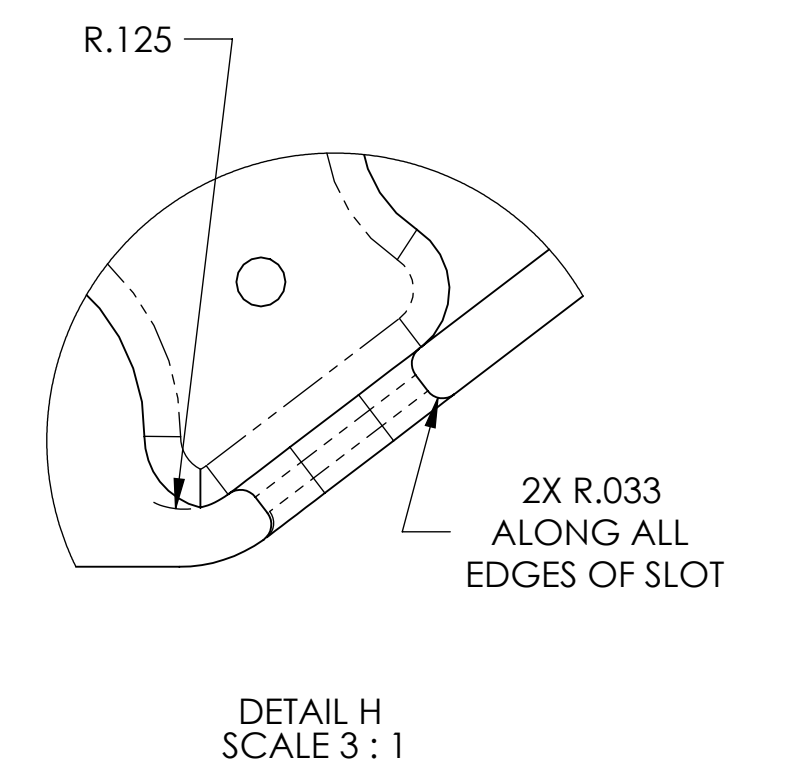
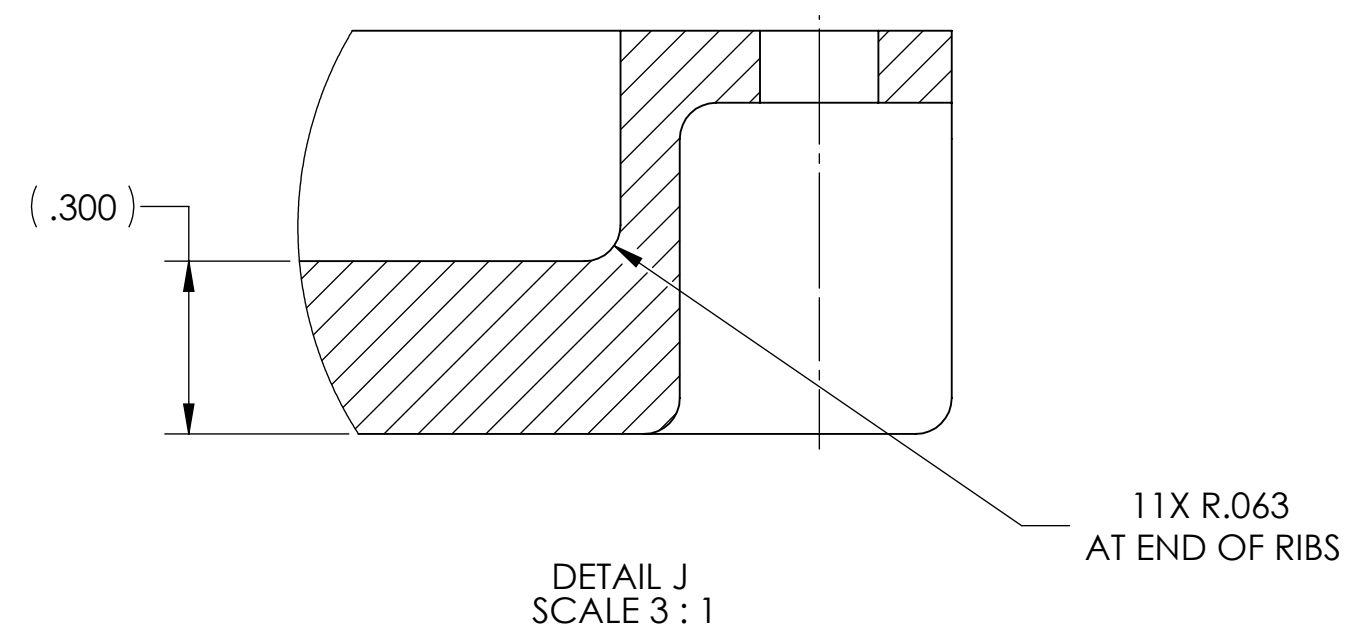
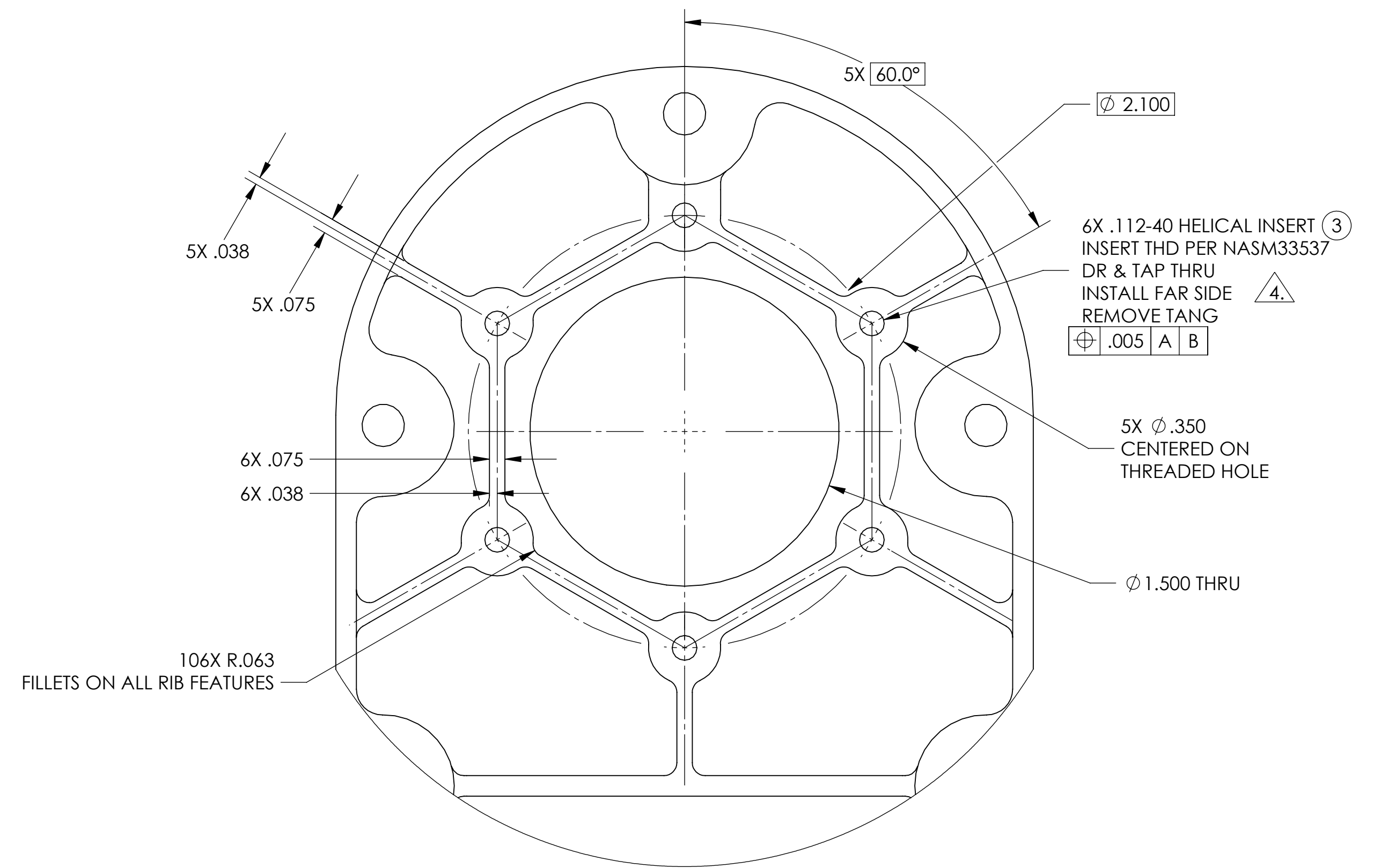
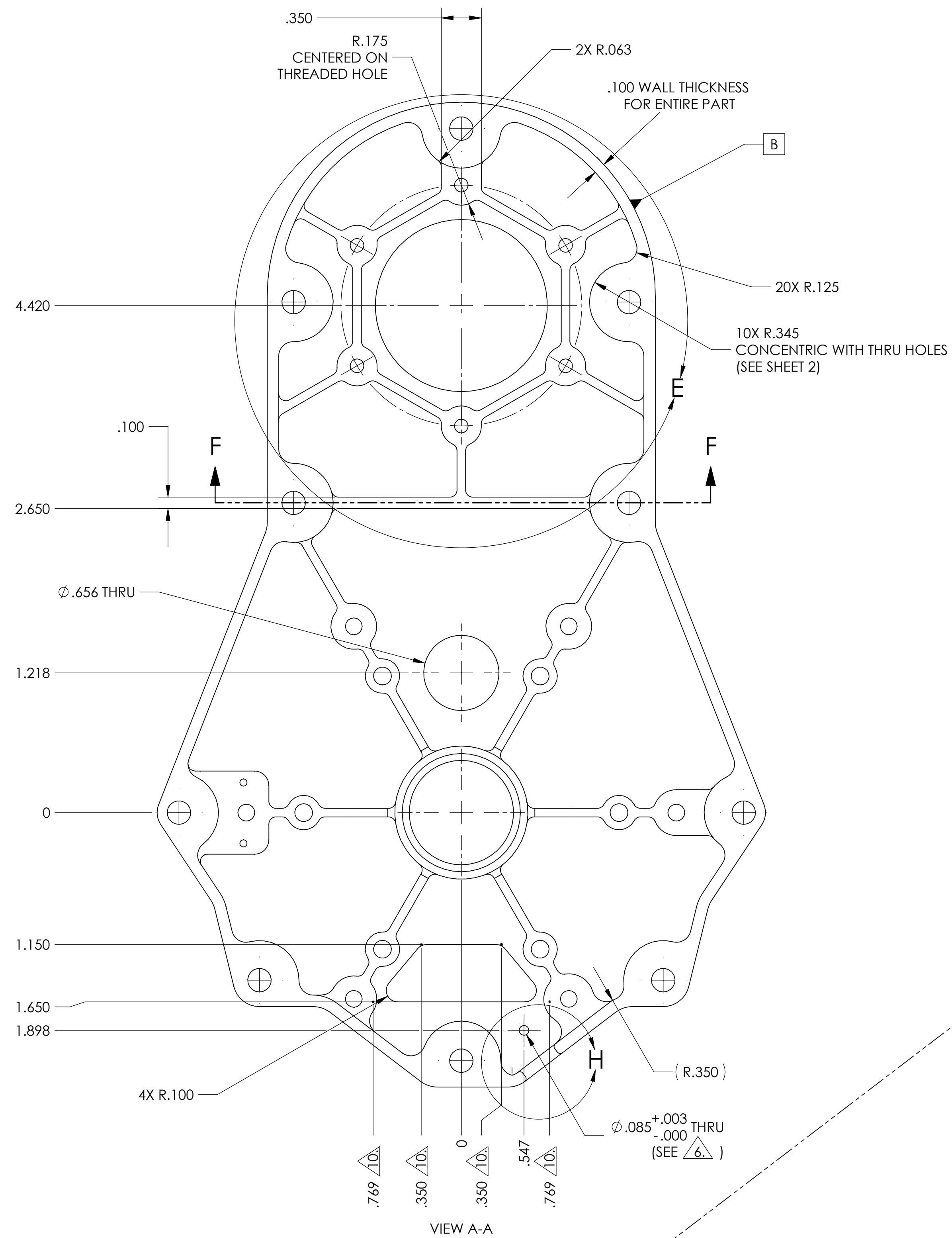
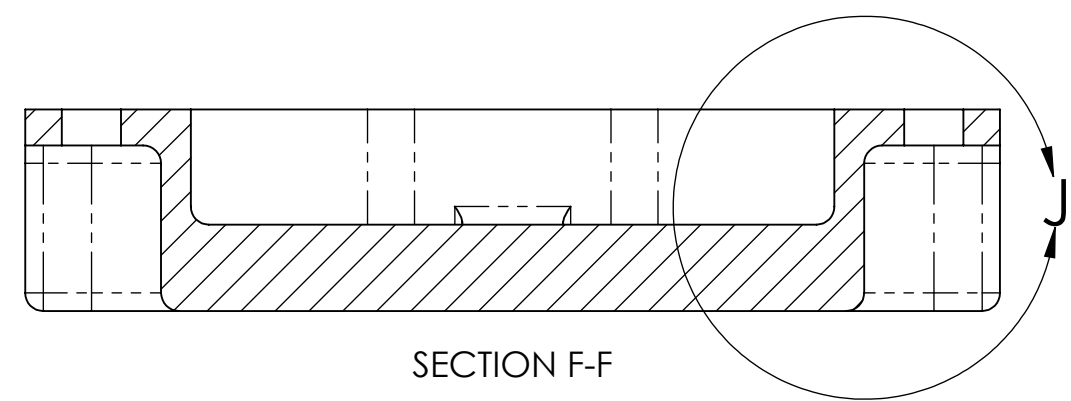
ITEM NO.	QTY REQD	PART NUMBER	DESCRIPTION	REMARKS
5	6	MS122158	INSERT, CRES HELICAL COIL COURSE THREAD, 2 DIA NOMINAL LENGTH, .138-32 PER NASM122156 THRU 122195	4. MATERIALS CERTIFICATE REQUIRED
4	6	MS122156	INSERT, CRES HELICAL COIL COURSE THREAD, 2 DIA NOMINAL LENGTH, .112-40 PER NASM122156 THRU 122195	4. MATERIALS CERTIFICATE REQUIRED
3	2	NAS607-2-3	HEADLESS STRAIGHT DOWEL PIN, .125" DIAMETER, .375" LONG	3. MATERIALS CERTIFICATE REQUIRED
2	1	FHS-256-5	SELF-CLINCHING PEM STUD, #2-56 THREAD, FLUSH HEAD, CRES SS, .312 LONG	6. MATERIALS CERTIFICATE REQUIRED
1	1	70010085	BRACKET, HALL THRUSTER/CATHODE	1., 2.

INTERPRET DRAWING PER ASME Y14.5M-1994	DRAWN: JBF	NAME:	DATE: 12/15/08	BUSEK 11 TECH CIRCLE NATICK, MA. 01760		
UNLESS OTHERWISE SPECIFIED	CHECKED:	TITLE:				
DIMENSIONS ARE IN INCHES	COG. ENG.:	BRACKET, HALL THRUSTER/CATHODE				
TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR: ±0.5°	PRINC. INV.:					
THIRD ANGLE PROJECTION	MATERIAL:		SIZE: D	CAGE CODE: OT2F070010085	DOC. NO.:	REV: B
DO NOT SCALE DRAWING	SUBSURFACE FINISH:		SCALE: 3:2	WEIGHT:	SHEET 1 OF 4	

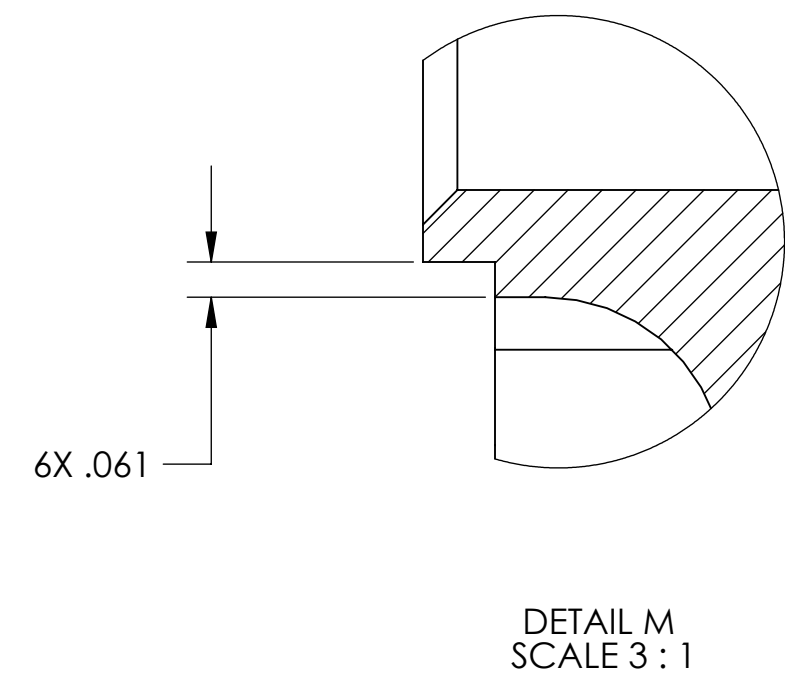
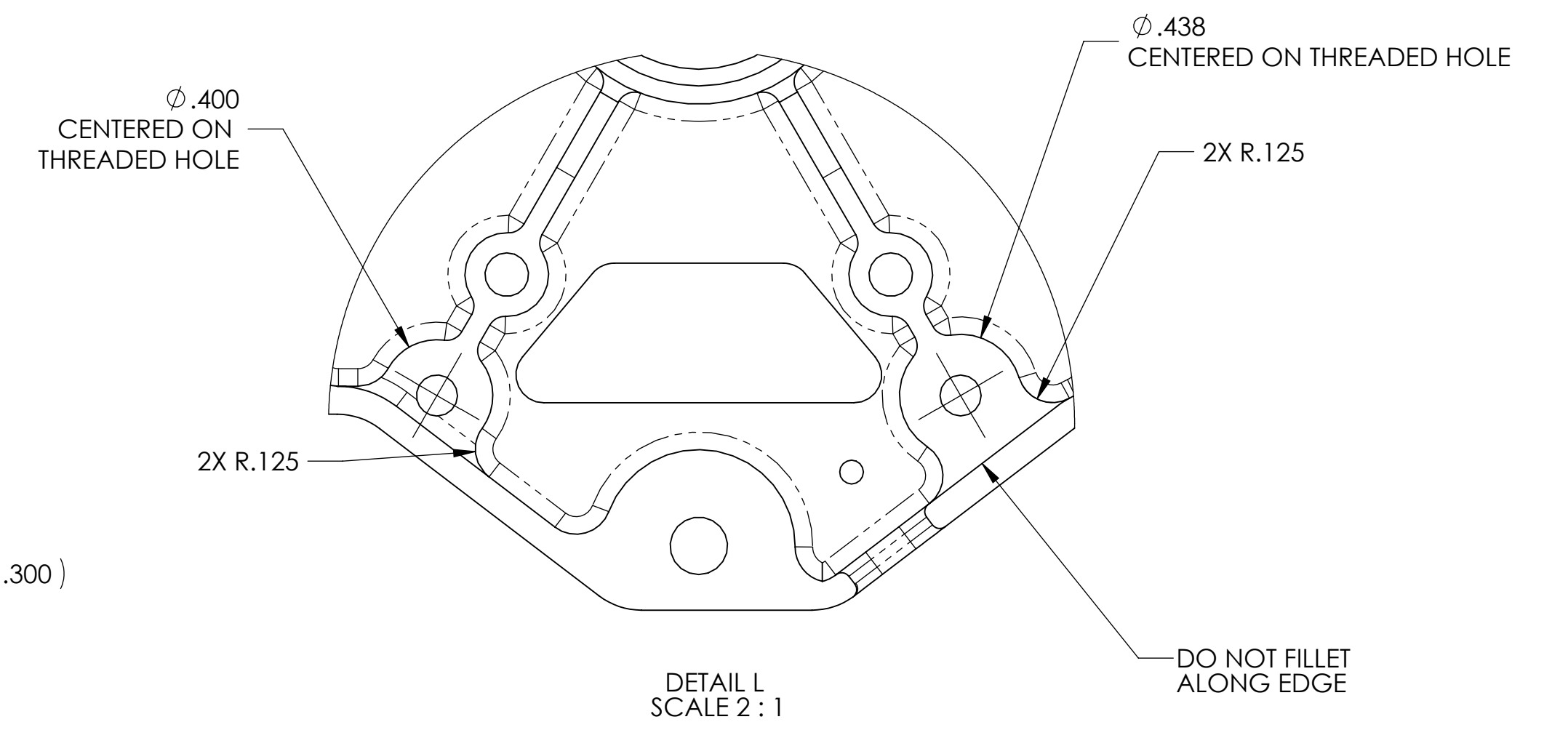
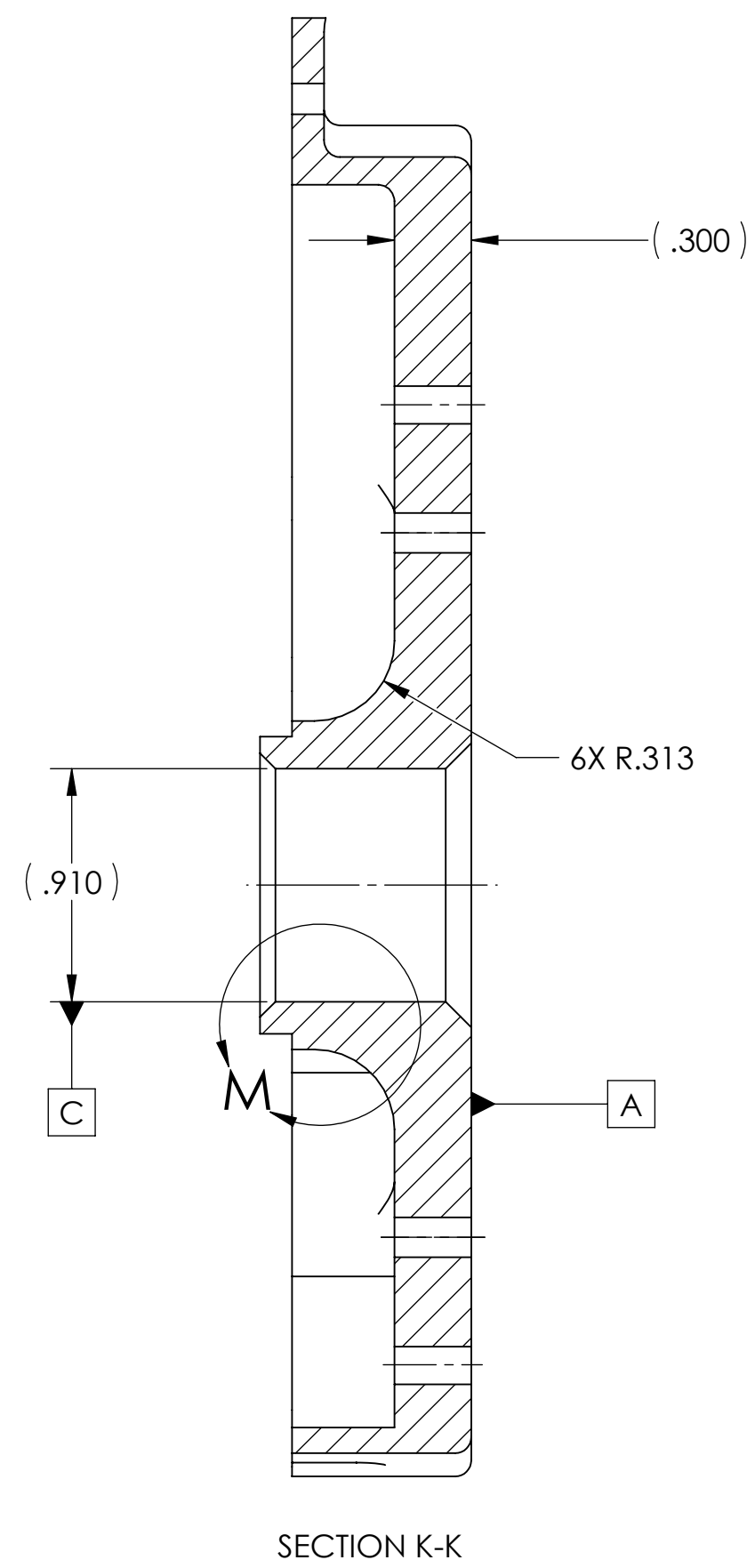
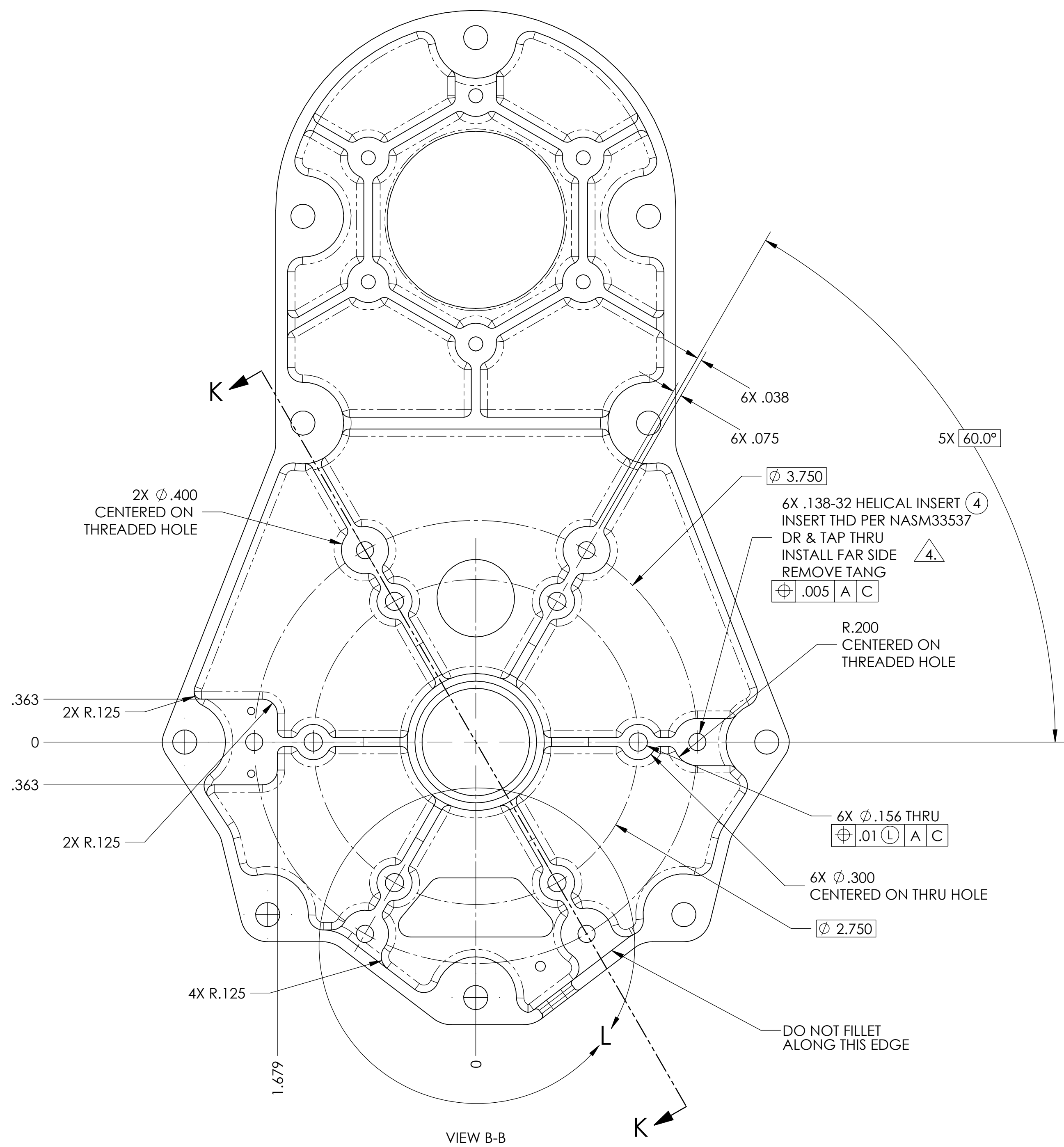
NOTICE: THIS DOCUMENT IS THE PROPERTY OF BUSEK CO. INC. AND IS DELIVERED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE DISCLOSED, REPRODUCED IN WHOLE OR IN PART, OR USED FOR MANUFACTURE FOR ANYONE OTHER THAN BUSEK CO. INC. WITHOUT ITS WRITTEN CONSENT, AND THAT NO RIGHT IS GRANTED TO DISCLOSE OR SO USE ANY INFORMATION CONTAINED IN SAID DOCUMENT. THIS RESTRICTION DOES NOT LIMIT THE RIGHT TO USE INFORMATION FURNISHED BY VENDORS OR OTHERS OUTSIDE BUSEK CO. INC.



SIZE: D	CAGE CODE: OT2F070010085	DOC. NO.:	REV: B
SCALE: 3:2	WEIGHT:	SHEET 2 OF 4	



SIZE:	CAGE CODE:	DOC. NO.:	REV.:
D	OT2F070010085		B
SCALE: 3:2	WEIGHT:	SHEET 3 OF 4	



SIZE:	CAGE CODE:	DOC. NO.:	REV.:
D	0T2F070010085		B
SCALE: 3:2	WEIGHT:	SHEET 4 OF 4	