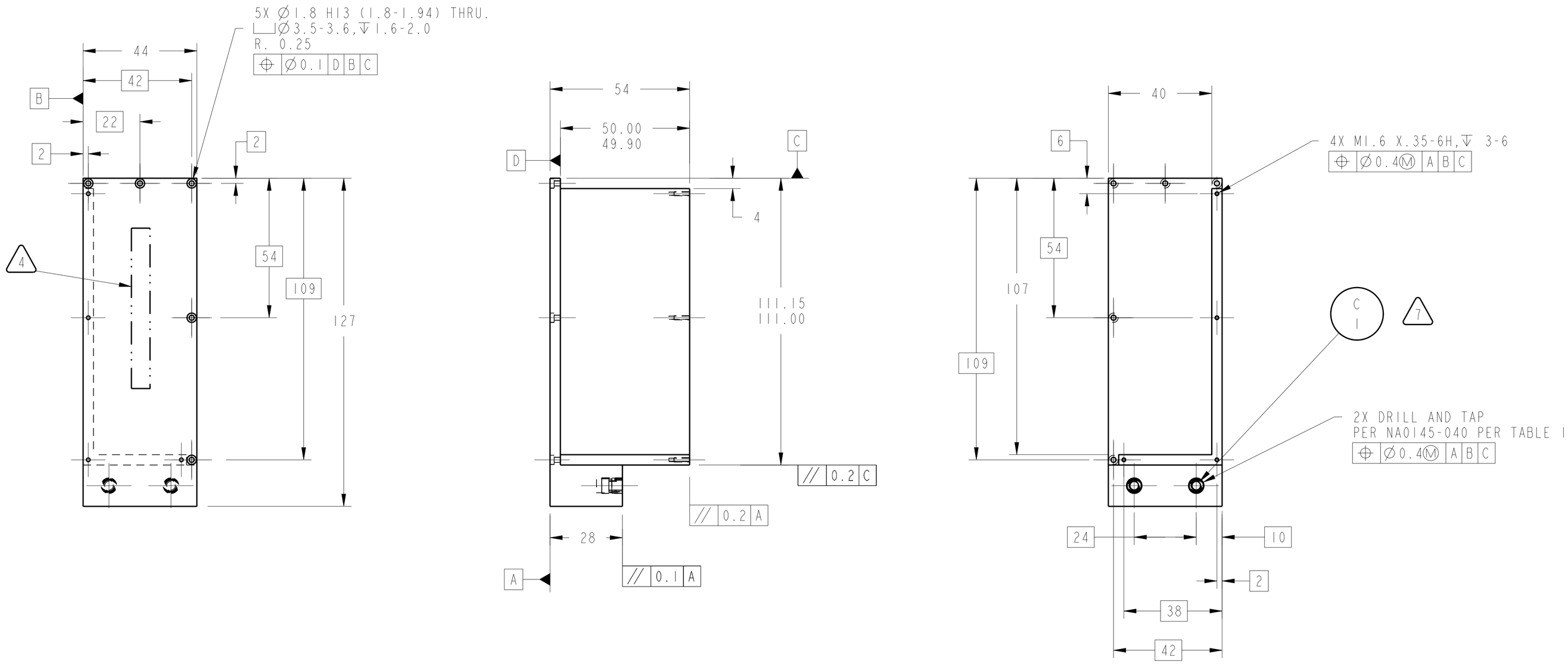
COMMERCIAL PARTS LIST

PART TYPE	BALLOON NO	DESCRIPTION	QTY/ ASSY
C	1	INSERT, KEENSERT PART NUMBER KNCML 4X0.7 (FOR M4 X 0.7 SHCS)	2



1. MATERIAL: 6061-T651 ALUMINUM PER SAE-AMS-QQ-A-250/11 OR ASTM B209
2. CERTIFICATION OF CHEMICAL AND MECHANICAL PROPERTIES IS REQUIRED.
3. 3.2 Ra ALL MACHINED SURFACES PER ANSI/ASME B46.1.
4. ALL INTERNAL RADII R1 UNLESS OTHERWISE NOTEED.
5. ELECTROCHEMICAL ETCH DRAWING PART NUMBER 67212MEDM145 ON SPECIFIED SURFACE PER SAE AS478 METHOD 7A (ZONE C5)
6. SURFACE TREATMENT: CLASS 3 CHEMICAL CONVERSION COATING PER MIL-C-5541: YELLOW/GOLD; USE IRIDITE 14-2 (ref. MACDERMID INC.); APPLY BY BRUSH OR IMMERSION AS APPLICABLE. BRUSH AND/OR SWAB TOUCH UP PER MIL-C-5541 SEC. 3.4; USE IRIDITE 14-2 BRUSH-ON KIT. THE USE OF IRIDITE 14-2 EQUIVALENT(S) IS PROHIBITED UNLESS SPECIFICALLY APPROVED BY ENGINEERING.
7. INSTALL KEENSERT KNML 4X 0.7 PER MANUFACTURER'S SPECIFICATIONS AFTER SURFACE TREATMENT PER NOTES 5
8. CLEAN SURFACES WITH 190 PROOF ETHYL ALCOHOL. WIPE WITH CLEAN COTTON SWABS AND/OR LINT-FREE CLOTH.
9. BEFORE STORAGE, PROTECT WITH CONTAMINATION BARRIER. USE CLEAN, NEW, TRANSPARENT, POLYETHYLENE BAG SEALED WITH FIBERGLASS PACKAGING TAPE. SEAL AND MARK WITH IDENTIFICATION NUMBER ON TAG ATTACHED TO BAG.
10. PROCESS PLAN REQUIRED.
11. ESTIMATED WEIGHT: 0.183 Kg.

CHG	ZONE	DESCRIPTION	APP/DATE

REVISIONS

UNLESS OTHERWISE SPECIFIED:
1. ALL DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994
2. ALL DIMENSIONS ARE IN MILLIMETERS
3. BREAK EDGES: 0.2-0.5
4. LINEAR TOLERANCES:
   0.5-6 ±0.1
   OVER 6-30 ±0.2
   OVER 30-120 ±0.3
   OVER 120-315 ±0.5
   OVER 315-1000 ±0.8
   OVER 1000-2000 ±1.2
5. ANGULAR TOLERANCES: 0° 30′

CONTRACT	NAS3-99155
CONTRACTOR	ANALEX CORP.
TASK ORDER	-
DRAFTER	LTHOMAS
ENGINEER	DCATALANO
DESIGNER	LTHOMAS

THIRD ANGLE PROJECTION

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
JOHN H. GLENN RESEARCH CENTER
LEWIS FIELD
CLEVELAND, OHIO

MFC ENCLOSURE ASS'Y

67212MEDM142

M145 MFC ENCLOSURE - BACK

PDM REL LEVEL: **RELEASE** PDM REVISION: **x.3**
PDM DATABASE: **FCF**
MODEL NAME: **67212MEDM145**
PRIOR TO USE VERIFY THE INTENDED PURPOSE IN PDM ("FOR" ATTRIBUTE)

SIZE	DRAWING NUMBER	REV	BLDG	AREA
A1	67212MEDM145	-	110	117

UNITS: mm

SCALE:	INITIAL REL DATE	SHEET	DISCIPLINE
1:1	08/15/2000	1 OF 1	MECH.

PRO/E VERSION: 2000i

SIZE A1 DRAWING NUMBER 67212MEDM145 REV -

NAME:EDJEN OBJECT:67212MEDM145 DATE:30-Oct-00 11:06:30