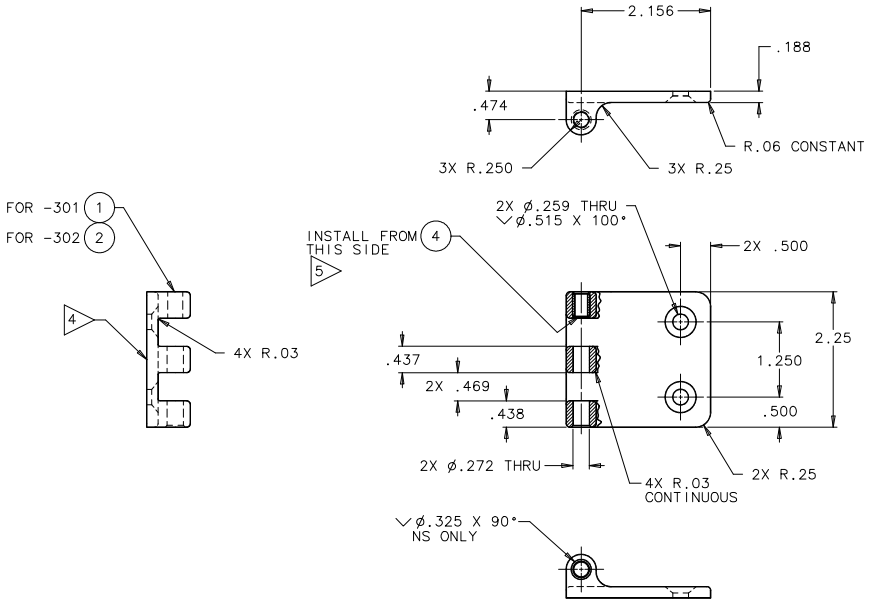
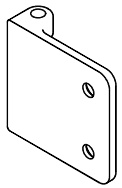
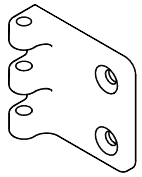
REV	ZONE	DESCRIPTION OF CHANGE



-301 SHOWN
-302 (OPP -301)



ISO VIEW -302
FOR REFERENCE ONLY



ISO VIEW -301
FOR REFERENCE ONLY

NOT FINAL

-302	-301	PART NUMBER	DESCRIPTION	MATERIAL	SPECIFICATION	ITEM
AR	AR	73X	INK, MARKING, BLACK		3	7
AR	AR	SUPER KOROPON 515-700/910-704	EPOXY PRIMER		2	6
						5
1	1	MS21209F4-15L	INSERT, THREAD, SELF-LKG, LUBE	CRES .250-28UNF-3B X .38		4
						3
1		-002	BRACKET, LH	7075-T3751 AL ALY 2.5 X 2.3 X .8	SAE-AMS-QQ-A-250/12	2
	1	-001	BRACKET, RH	7075-T3751 AL ALY 2.5 X 2.3 X .8	SAE-AMS-QQ-A-250/12	1
-		-302	ATTACH BRACKET ASSY, LH			
	-	-301	ATTACH BRACKET ASSY, RH			

5. THIS ASSEMBLY DOES NOT CONTAIN FRACTURE CRITICAL PARTS.
4. CLEAN ALL SURFACES TO LEVEL GC PER NASA/JSC PRC-5001; WIPE CLEAN ALL SURFACES.
3. ALL DIMENSIONS ARE IN INCHES.
2. FABRICATION PER NASA/JSC SKZ36103755, JSC FABRICATION TOLERANCES AND PRACTICES.
1. INTERPRET DRAWING PER NASA/JSC JPG 8500.4, ENGINEERING DRAWING SYSTEM MANUAL.

NOTES: UNLESS OTHERWISE SPECIFIED

5 INSTALL HELICAL COIL INSERTS (ITEM 4) PER NASA/JSC PRC-9008. SEAL INSERTS WITH EPOXY PRIMER (ITEM 6) PER NASA/JSC PRC-4004. INSTALL THE INSERTS FROM THE SIDE INDICATED. ALL HELICAL COIL INSERTS ARE TO BE INSTALLED AS CLASS 3B.

4 PART NUMBER SHALL BE MARKED IN .12 INCH HIGH CHARACTERS BY RUBBER STAMPING USING INK (ITEM 7) PER NASA/JSC PRC-9002. LOCATE APPROXIMATELY AS SHOWN.

3 INDEPENDENT INK INC, GARDENA, CA

2 COURTAULDS AEROSPACE, GLENDALE, CA

1 ANODIZE ALL SURFACES PER NASA/JSC PRC-5006, TYPE II, CLASS 1.

FLAG NOTES:

UNLESS NOTED OTHERWISE DIM ARE IN INCHES, TOL ARE: .0 ± .1 .000 ± .005 .00 ± .02 ANGULAR ± .5°
SURFACE FINISH IN MICROINCHES RMS UNLESS NOTED OTHERWISE 125
FRACTURE CRITICAL ☐ YES ☒ NO
NEXT ASSY SEG46119580
PROJECT:
LIBRARY:
☒ FLT HDWR ☐ APPLICABLE QSE
☐ OTHER (SPECIFY) _____

SIGNATURES		DATE
DR	J.L. GLASGOW	03/11/14
ENG		
CH		
APP		
QE		
MATL		
STRESS		
AUTH		

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION
LYNDON B. JOHNSON SPACE CENTER HOUSTON, TEXAS

ATTACH BRACKET ASSEMBLY, RIGHT AND LEFT HAND, BOTTOM FENCE/ RACK POST-

PROJECT B132 HRF MARES RACK

SIZE D | CODE ID NO. 21356 | DWG NO. SDG46120066 | REV

SCALE: 1/1 | ORG EB | FMT S01MAR01 | SHEET 1 OF 1