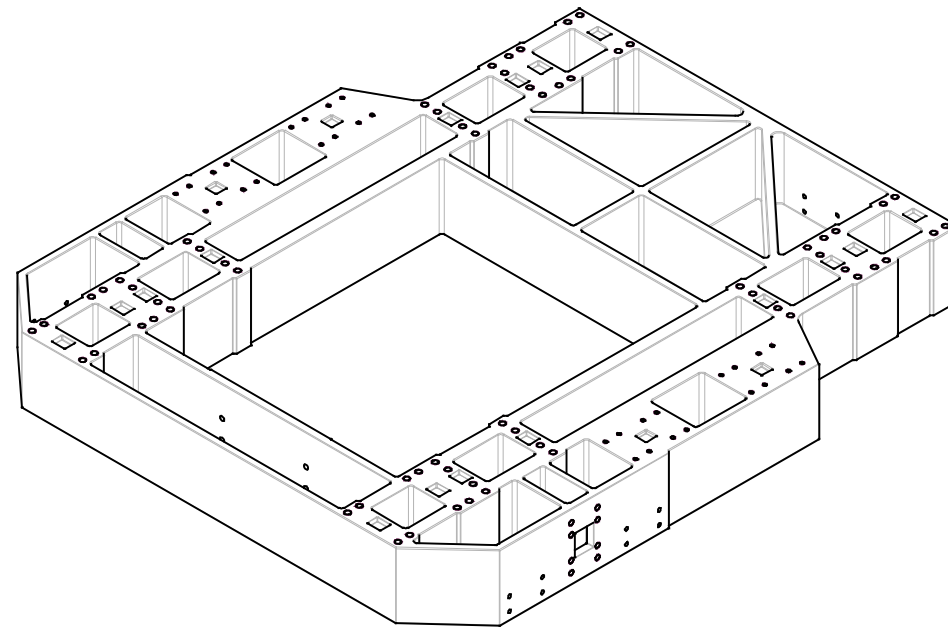


NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: ALUMINUM ALLOY, 6061-T651 PER ASTM B209 OR SAE-AMS-QQ-A-250/11.
2. AFTER FINAL MACHINING, PERFORM ETCH AND DYE PENETRANT INSPECTION PER S-313-009, CODE ASPEA, REMOVING .0004-.0006 OF MATERIAL PER SURFACE.
3. ALL EXTERNAL EDGES, EXCEPT HOLES (AND SLOTS) ARE R.06.
4. ALL BURRS AND EDGES SHALL BE REMOVED. THE MAXIMUM ALLOWED RADIUS OR CHAMFER IS .03.
5. FINISH: CHEMICAL CONVERSION COATING, COLOR GOLD, PER MIL-DTL-5541, CLASS 3.
6. FINISH: ANODIC COATING PER MIL-A-8625, TYPE II, CLASS I, COLOR CLEAR. SODIUM DICHROMATE SEALER SHALL NOT BE USED.
7. REMOVED.
8. INSTALL INSERT PER NASM33537, AFTER FINISH. REMOVE DRIVING TANG.
9. ORIGINAL SOURCE OF SUPPLY:  
EMHART TECHNOLOGIES  
INDUSTRIAL DIVISION  
50 SHELTON TECHNOLOGY CENTER  
PO BOX 859  
SHELTON, CT 06484
10. ALL FASTENERS SHALL MEET THE REQUIREMENTS OF GSFC SPEC 541-PG-8072.1.2.
11. INK STAMP PER MIL-STD-130, PARAGRAPH 4, WITH 36FCI-2091570 AND SERIAL NUMBER PER ELC-PROC-000242. MARK .12 HIGH CHARACTERS, APPROXIMATELY WHERE SHOWN, USING ENTHONE M-O-N, SERIES M, PERMANENT MARKING INK, COLOR BLACK, USING 100/4 WEIGHT RATIO OF CATALYST 20/A, CURE 5 - 7 DAYS AT ROOM TEMPERATURE OR 80° C ± 15° C FOR 90 MINUTES.  
ORIGINAL SOURCE OF SUPPLY:  
ENTHONE INC  
350 FRONTAGE RD  
WEST HAVEN, CT 06516
12. INTENT IS FOR FEATURE TO BE MACHINED AT ASSEMBLY USING TEMPLATE ???.  
IF MANUFACTURER CHOOSES NOT TO MACHINE AT ASSEMBLY, FINAL FEATURE SIZE AND LOCATION MUST MEET THE REQUIREMENTS OF NEXT ASSEMBLY.



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ITEM	REQD	PART NO.	DESCRIPTION	MATERIAL	MATERIAL SPEC & NO.
4	64	3591-7B0656	INSERT, SCR THD, LKG, .4375-20, .656 L	PH BRZ	SEE NOTE 9
3	28	3591-6B0662	INSERT, SCR THD, LKG, .375-24, .562 L	PH BRZ	SEE NOTE 9
2	32	3591-4B0375	INSERT, SCR THD, LKG, .250-28, .375 L	PH BRZ	SEE NOTE 9
1	AR		PLATE		SEE NOTE 1

NAME	INIT.	DATE
APPROVED BY: D. MCGUINNESS		
APPROVED BY: B. MACT		
APPROVED BY: B. HARRIS		

NAME	INIT.	DATE
N. CLEMONS		
N. CLEMONS		
D. FOOTE		
L. LEBEAU		
J. CARRO		
J. SLATER		
J. HALL		

THIS DRAWING WAS PRODUCED USING	SOFTWARE: PVA/ENGINEER VERSION: WF2
FILE NAME: 2091570 -03A	
MODEL NAME: 2091570 -04	

APPROVED BY: D. MCGUINNESS	APPROVED BY: B. MACT	APPROVED BY: B. HARRIS	APPROVED BY: N. CLEMONS	APPROVED BY: N. CLEMONS	APPROVED BY: D. FOOTE	APPROVED BY: L. LEBEAU	APPROVED BY: J. CARRO	APPROVED BY: J. SLATER	APPROVED BY: J. HALL
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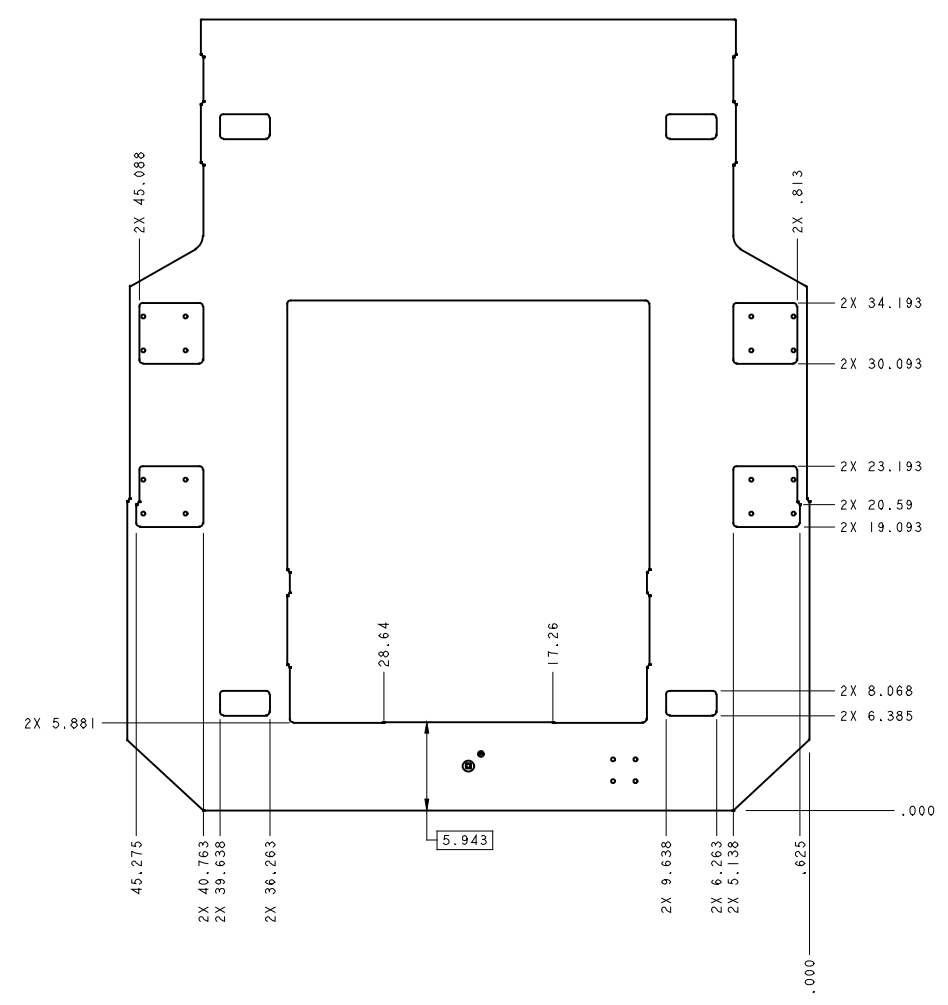
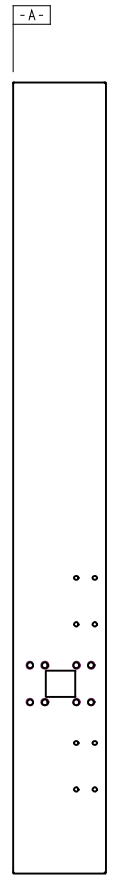
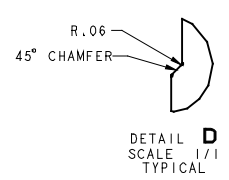
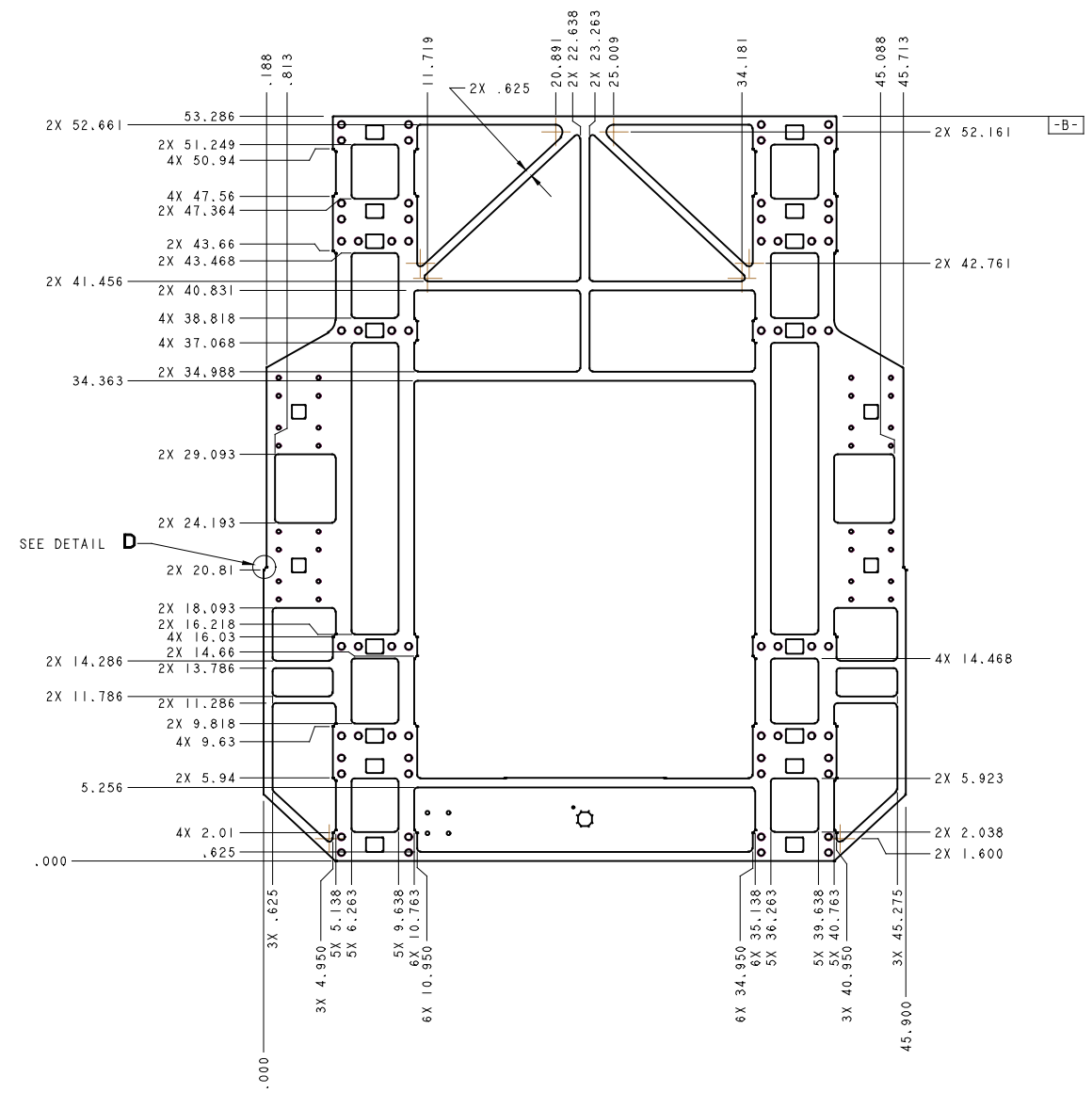
LIST OF MATERIAL	
ITEM NO.	DESCRIPTION
1	PLATE

Goddard Space Flight Center Greenbelt, Maryland	
DRAWING INTERPRETED PER GSFC-XRTD-04-1	
FRAME PASSIVE COMMON ATTACH SYSTEM	
GE 36FCI	2091570
CODE: 459	SCALE: 1/4
WEIGHT:	SHEET: 1 OF 4

GE 2091570

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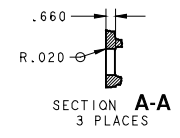
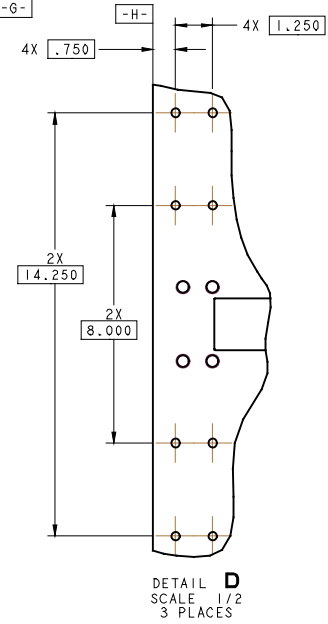
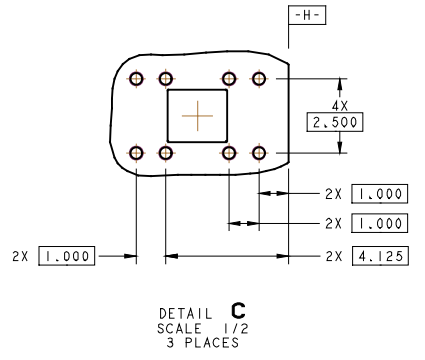
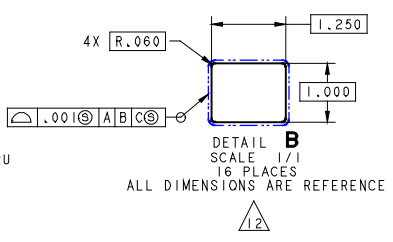
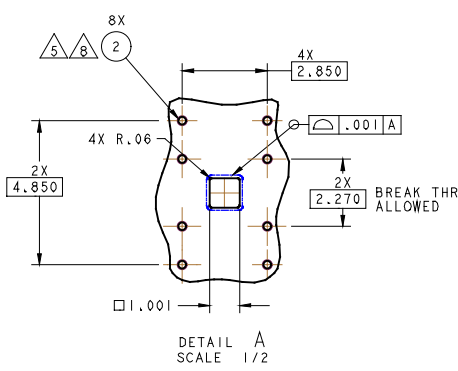
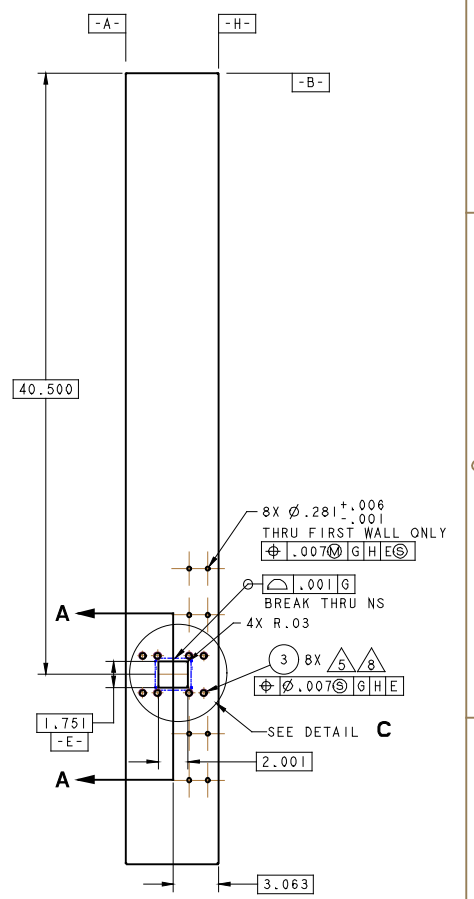
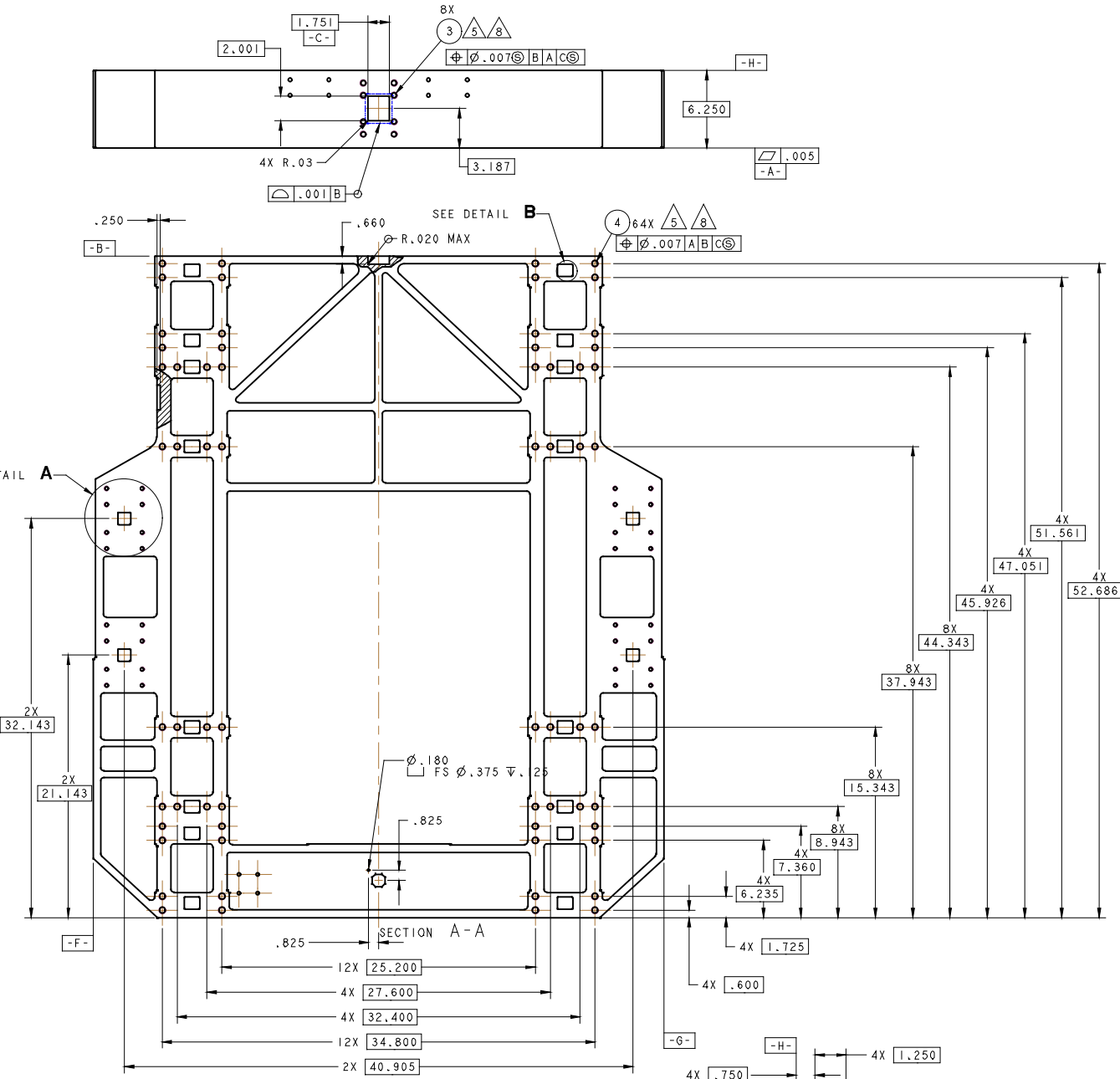
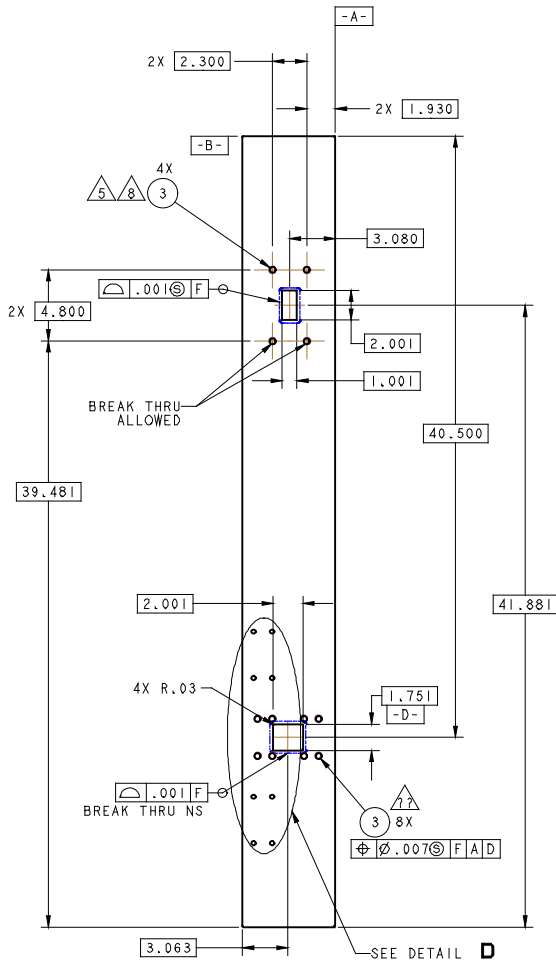
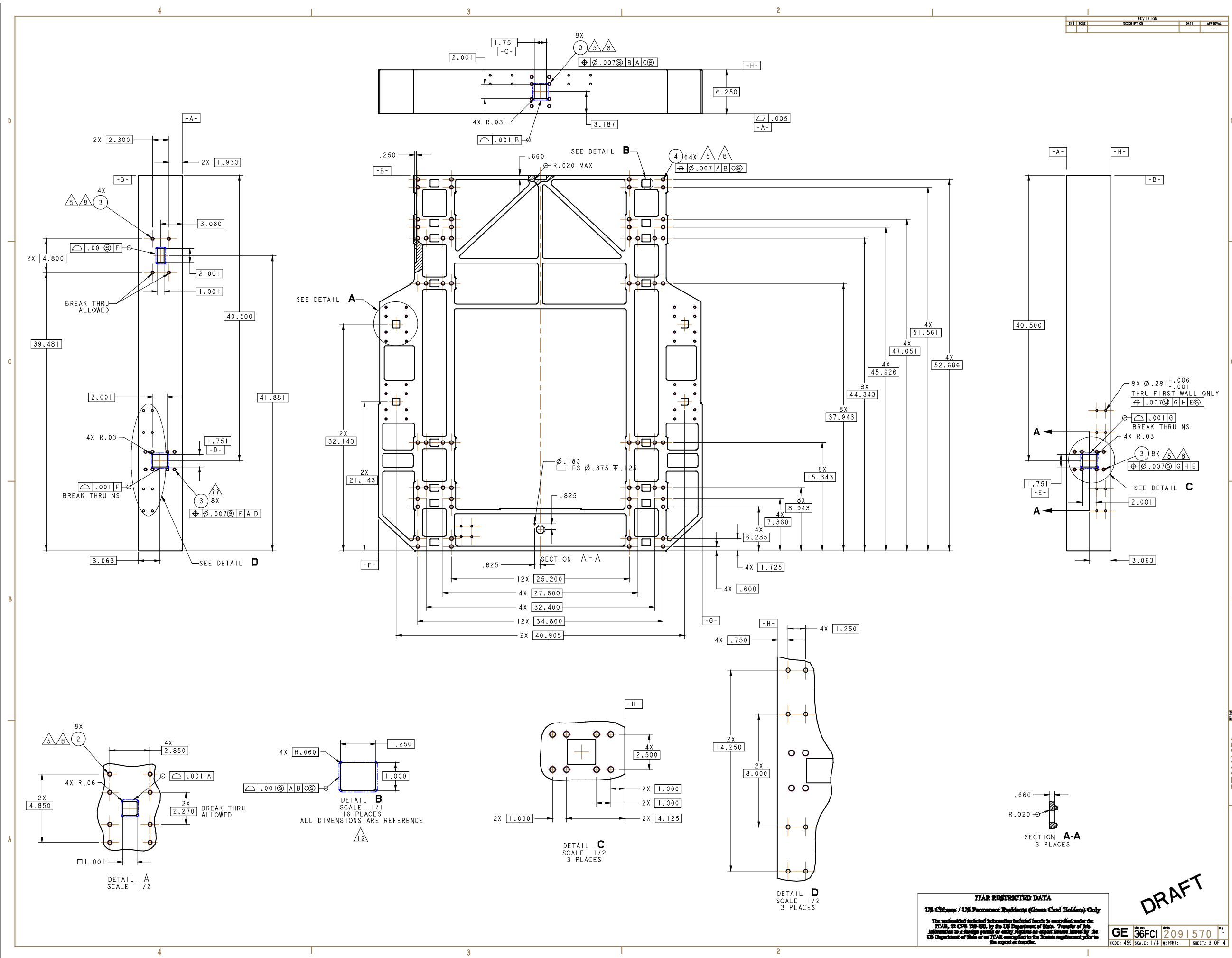
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GE 36FC1 2091570  
 CODE: 459 SCALE: 1/4 WEIGHT: SHEET: 2 OF 4

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GE2091570

REV	DATE	DESCRIPTION	APPROVAL
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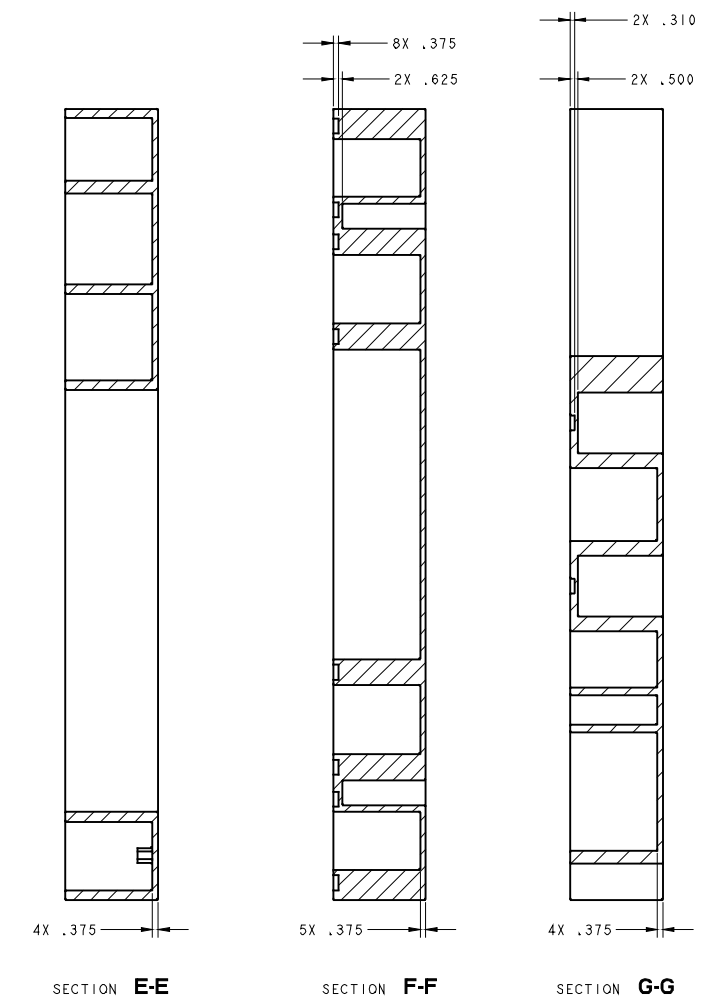
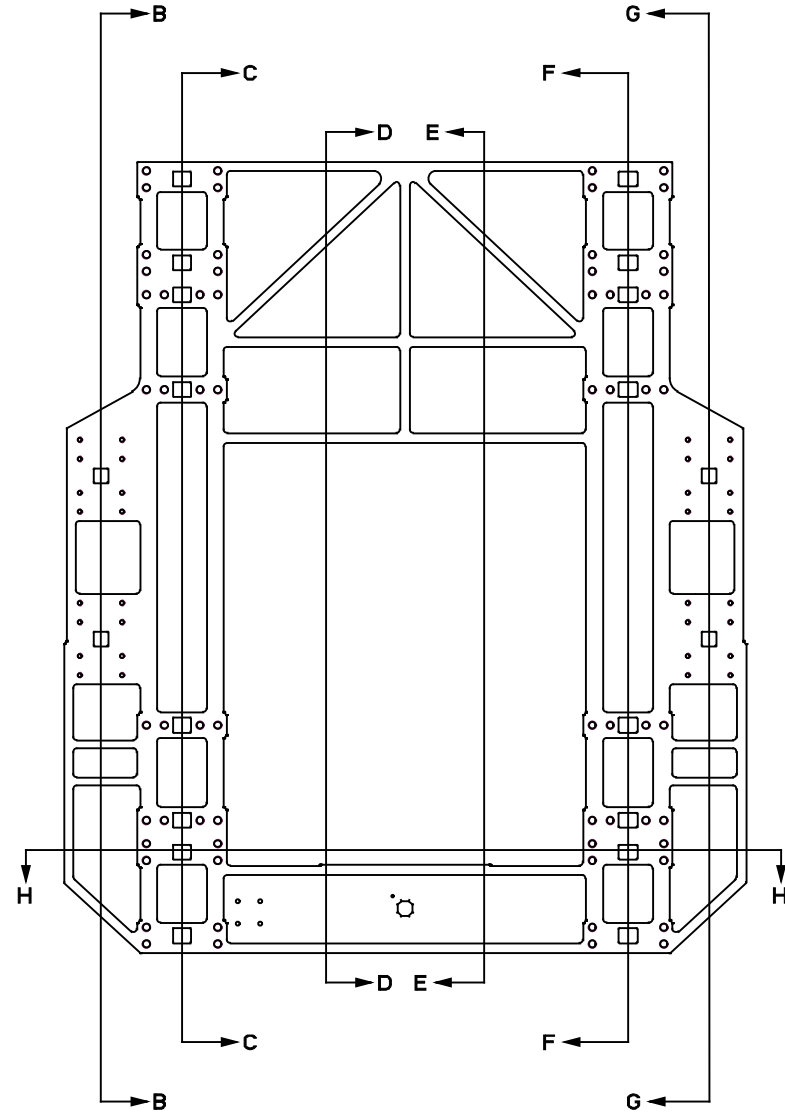
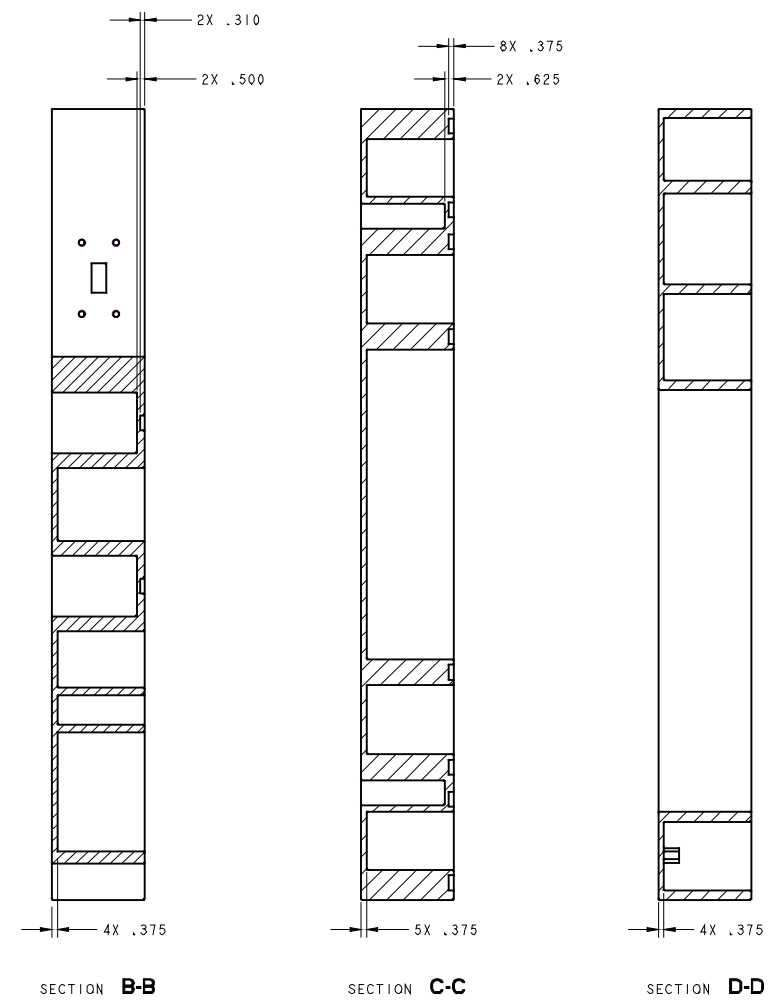
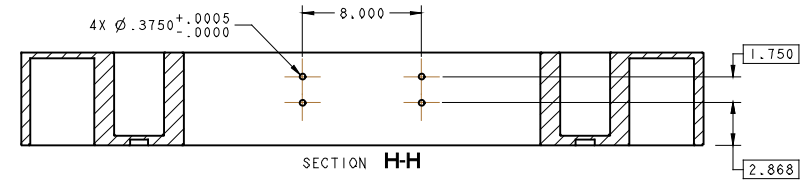


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 GE 36Fci 2091570  
 CODE: 459 SCALE: 1/4 WEIGHT: SHEET: 3 OF 4

GE2091570

REVISION			
REV	DATE	DESCRIPTION	APPROVAL
-	-	-	-



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GE 36Fci 2091570  
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