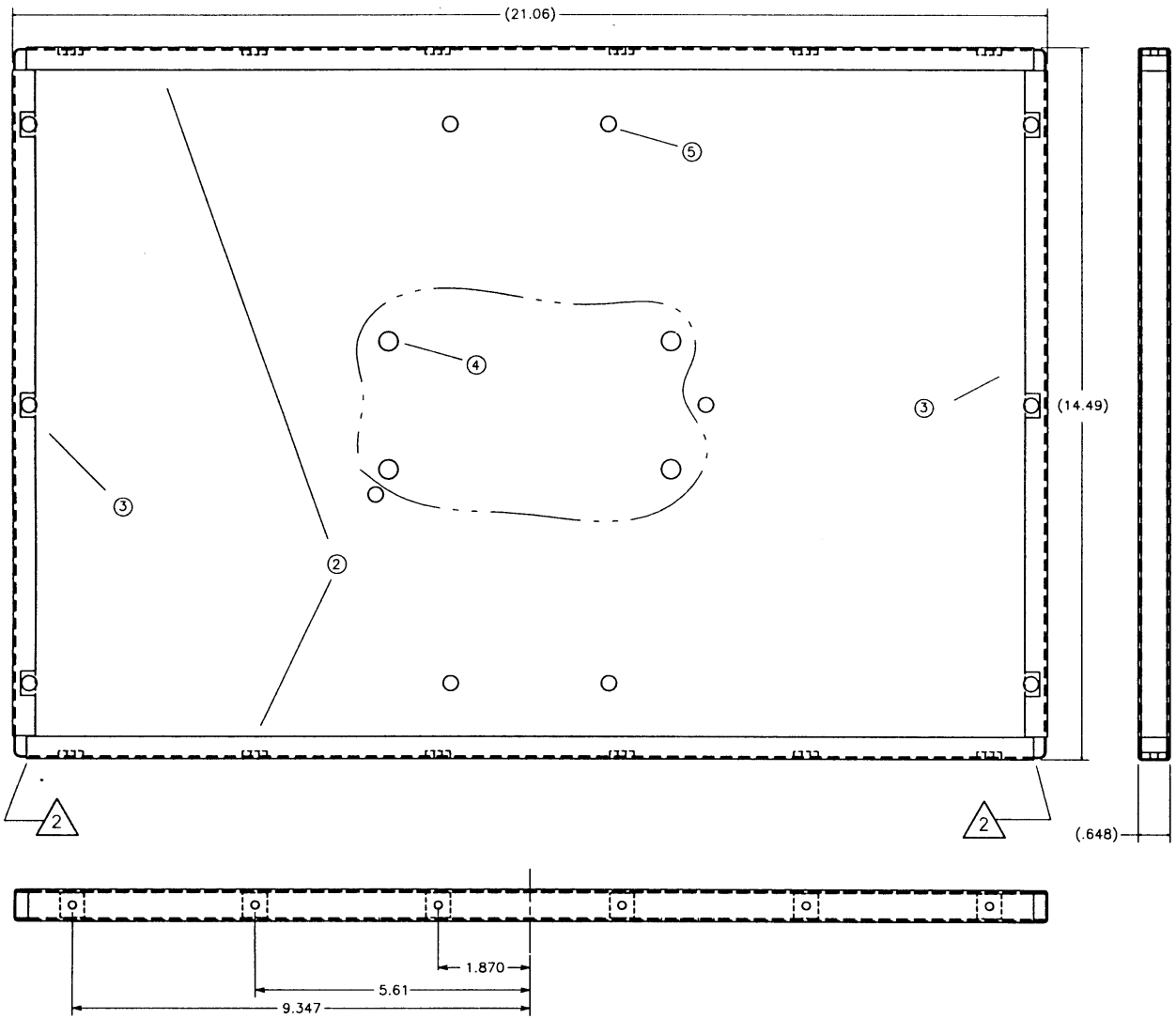
ITEM	PART	PART NO.	QTY
1	BOTTOM PANEL	DWG 001113-0	1
2	BOTTOM/SIDE CLOSEOUT	DWG 001123-0	2
3	BOTTOM/FRONT CLOSEOUT	DWG 001124-0	2
4	#10-32 SHUR-LOK INSERT	SL6061-3	4
5	#4-40 SHUR-LOK INSERT	SL6061-04	12



4	DURING ADHESIVE CURE, APPLY CLAMPING FORCE AGAINST ALL FOUR EDGES USING PIPE CLAMPS OR EQUIVALENT METHOD AND CLAMP CLOSEOUTS TO FACE SHEETS USING C-CLAMPS
3	ASSEMBLE FRONT/REAR CLOSEOUTS SECOND USING SIDE CLOSEOUTS AS GUIDES AND ALIGN CUTOUTS WITH BOTTOM INSERTS -- PRESS FLUSH TO FRONT (OR REAR) SIDE OF BOTTOM PANEL
2	ASSEMBLE BOTH BOTTOM/SIDE CLOSEOUTS FIRST. SCRIBE SHORT LINES .250" FROM FRONT/REAR EDGE OF FACE SHEET TO VISUALLY CENTER CLOSEOUT. APPLY ADHESIVE AND PRESS FLUSH TO SIDE OF BOTTOM PANEL
1	PRIOR TO ASSEMBLY OF CLOSEOUTS, INSTALL ALL SHUR-LOK INSERTS (ITEMS 4 & 5) AND REMOVE INSTALLATION TABS

NOTES

JET PROPULSION LABORATORY

CALIFORNIA INSTITUTE OF TECHNOLOGY
PASADENA, CALIFORNIA

DIMENSIONS ARE IN INCHES
UNLESS OTHERWISE SPECIFIED

TOLERANCES:

FRACTIONS	DECIMALS	ANGLES
1/32	.XX = 0.015 .XXX = 0.005 .XXXX = 0.001	0.1°

DRAWING TITLE:
BOTTOM PANEL SUBASSEMBLY
CHASSIS

PROJECT: ET ROVER		DWG NO.: 001101-0
DRAWN: TONY GANINO 393-1363	DATE: 7/14/98	REV: C
SCALE: None	MATERIAL: N/A	QUANTITY: 1